

BPX BOSS WELDING PROCEDURE

STEP 1

Check that the surfaces to be welded are good and free from scale, grease, paint, water, or any other contaminants.

STEP 2

Mark out on the lip plate the locations of Talon BPX Bosses as per lip assembly drawing for your specific bucket size and configuration.

STEP 3

Use the appropriate Talon Lip Template Gauge to locate the Talon BPX Boss on the lip.

STEP 4

Once the Boss is in the correct position, tack weld Boss in the correct location with a small 12mm (1/2") long weld on each side of the Boss.

STEP 5

Preheat the lip plate and Bosses as required. Complete a 10mm fillet weld as shown in the figure below. Ensure 2 or more weld passes are used to complete the full-size fillet weld.

STEP 6

Ground smooth surfaces of all boss welds and inspect for cracks. Any cracks detected must be repaired and reinspected.

