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XPANSION WING SHROUD WELDING PROCEDURE

OUTLINE

This procedure provides an outline of how to attach the Talon Xpansion Wing Shroud shear blocks and boss onto a bucket. Please ensure a copy of this procedure is available for personnel who are tasked with welding Talon products.

WELDING SAFETY

Welding, cutting and any allied process are a significant safety risk. Before undertaking any of these processes ensure that all precautions have been considered or implemented as per welding safety standards AS1674: 2007 or ANSI Z49.1: 2005 or equivalent globally recognized standard.

Of particular note please ensure the following is adhered to:

- Wear correct PPE including
 - Full sleeve non-flammable work wear. (No gaps)
 - Non-flammable welding gloves
 - Steel capped work boots
 - Safety glasses
 - Hearing protection
 - Full face welding shield
- Suitable ventilation is available for the person completing the operation.
- Welding is an electrical risk ensure the area where welding is to be conducted is not damp or wet.
- Welding is a fire risk ensure the area where welding is to be conducted is free of any thing flammable and that suitable fire extinguishers are easily available.
- If welding is to be conducted in an area where other people are working, ensure welding flash shields are utilized.
- Good general housekeeping to ensure the work area is safe and free of clutter.
- Ensure appropriate tags for your workplace and work environment are used.

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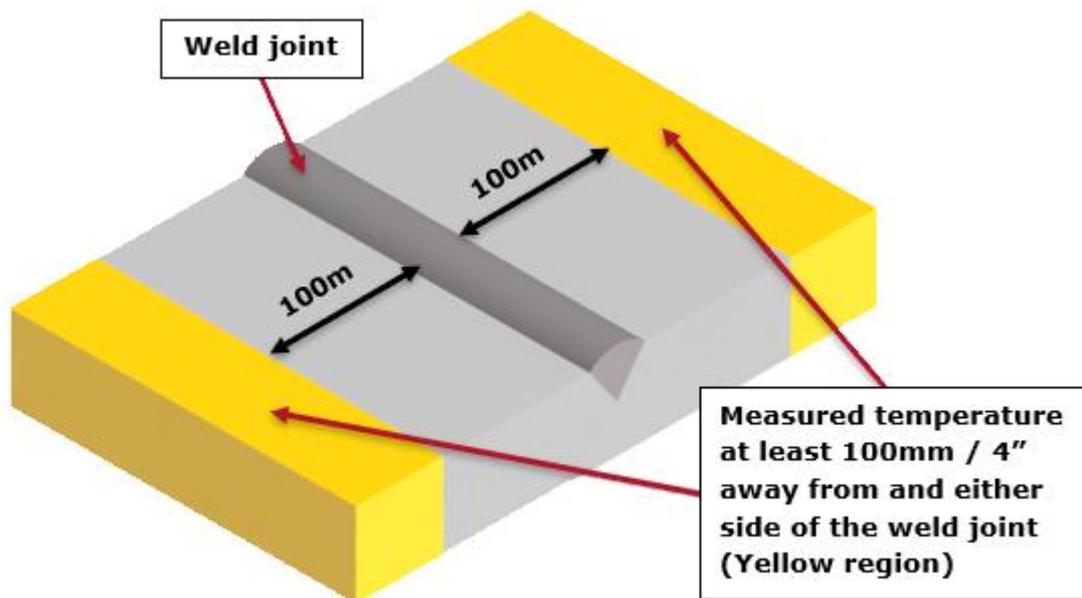
WELDING PROCESS AND PREHEAT NOTICE



Please ensure that you follow the Thermal Treatment (Preheat) procedure stated in this welding procedure. Preheat of the weld area prior to commencing welding will help ensure weld quality, reduce the occurrence of cracking and other problems that can result in costly rework. The weld area must be heated to 150°C, measured at least 100mm / 4" away from and either side of the weld joint and maintained between 150°C and 250°C throughout the welding

process.

The warranty may be void on Talon Weld-On components if the specified process is not followed correctly.



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TALON WELDING SETUP

WELD PREPARATION

The surfaces to be welded must be good and free from scale, grease, paint, water, or any other contaminants. The heat from welding breaks down any hydrocarbons and moisture in the area and releases hydrogen. The hydrogen along with any remaining particulate matter can be absorbed in the weld and result in cracking, porosity, and inclusions.

Preparation of the weld surfaces may be achieved by sand blasting, shot blasting, grinding, sanding, air carbon arc gouging, or a combination of any these processes. Should the air carbon arc gouging process be used, finish the surface by grinding to remove all carbon slag. Following any of these preparation processes ensure any dust or particulate matter is removed from the weld area to prevent porosity and inclusions.

WELDING PROCESS

Welding may be completed by any of the following processes:

- Gas Metal Arc Welding (GMAW)
- Flux-cored Arc Welding (FCAW)

A combination of GMAW or FCAW can be utilised.

The following table details **recommended** reference consumables:

Process	AWS	AS/NZS	ISO	Shielding Gas	Polarity
GMAW	AWS A5.18 ER70S-4	2717.1: ES4-GC/M-W503AH		100% CO ₂ Ar + 10-15%CO ₂ Ar + 15-25%CO ₂	DC+
GMAW	AWS A5.18 ER70S-6	2717.1: ES6-GC/M-W503AH		100% CO ₂ Ar + 10-15%CO ₂ Ar + 15-25%CO ₂	DC+
FCAW-G	AWS A5.20 E71T-1 H8	17632-B: T49 2 T1 1 CAU H10		100% CO ₂ Ar + 20-25%CO ₂	DC+
FCAW-G	AWS A5.18 E70C-6M H4	17632-B: T49 4 T15 0 MAU H5		Ar + 20-25%CO ₂	DC+/-
FCAW-S	AWS A5.20 E70T-7	17632-B: T49 Z T7 0 NA		NR	DC-
FCAW-S	AWS A5.20 E71T-8	17632-B: T49 3 T8-1NA-H15		NR	DC-

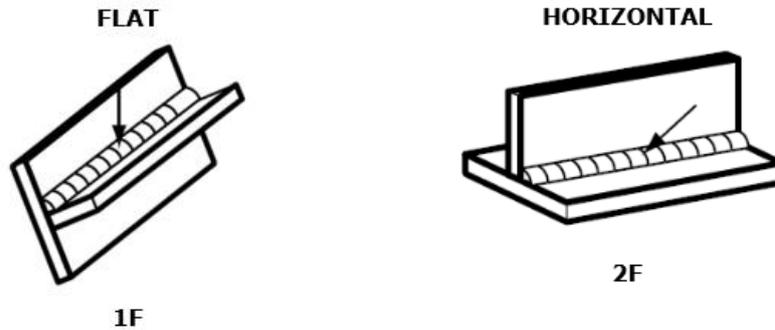
ELECTRICAL PARAMETERS

The person completing the weld should refer to the manufacturer's specifications to determine the optimal settings to complete the weld. Actual voltage, welding current and Electrode Stick Out (E.S.O.) used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

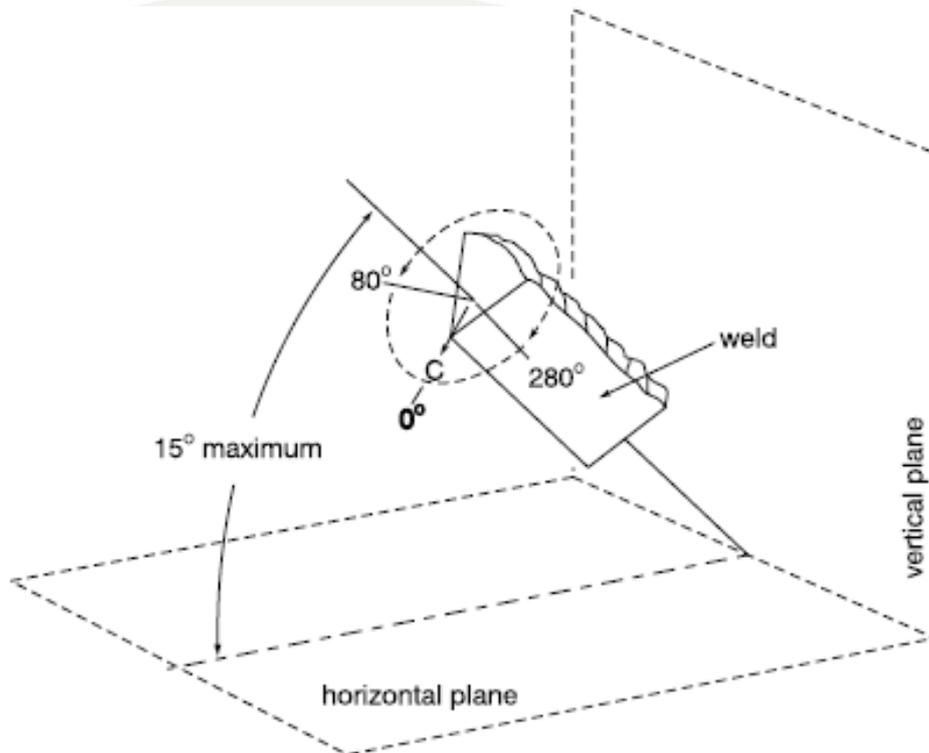
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WELDING POSITION

Welding of Talon Xpansion Wing Shroud shear blocks and boss is recommended and shall be completed in the Flat 1F and Horizontal 2F position. The other positions can be welded but the process should be adjusted to suit the applicable weld wire and equipment to ensure good weld strength and integrity.



Deviation from the Flat or Horizontal position is permissible as shown in figure below as typically described in welding standard AWS D1.1, Structural Welding--Steel, Figure 4.2 "Positions of Fillet Welds".



The longitudinal axis of the weld may be inclined no more than 15° with respect to the horizontal plan. The centre of the weld face "C" must lie within the rotational limits of 80° to 280° as shown.

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THERMAL TREATMENT

It is important to preheat the work piece prior to commencing welding and ensure the components are maintained within the acceptable interpass temperature range during welding. Preheat is the heating of a work piece prior to being welded, flame cut, or air carbon arc gouged. Heat can be applied through several methods such as propane or butane gas flame burners or torches and magnetic induction.

As welding, flame cutting and air carbon arc gouging use a high temperature heat source to melt the base metal, a high temperature in a small localized area is created along with a large temperature differential to the rest of the work piece. This causes high stresses, hardened areas, deformation, and a very small area for hydrogen gases to be released from the steel. Preheat reduces the temperature differential and so lowers the risk of weld cracking, maximum hardness of the heat affected zone, lessens distortion, and releases hydrogen from the steel prior to welding.

Maintaining the correct interpass temperature is important to hold the reduced temperature differential gained from preheating and to ensure the work piece does not get too hot. Allowing the steel to become too hot will temper the steel and soften it, reducing its hard-wearing properties.

When preheating with burners and torches it is most effective to heat the work piece from below. This allows the heat to soak up through the body of the work piece. Using insulating heat blankets on the topside of the work piece will improve and speed up the process, allowing the dispersion and retention of the heat that has been input.

Temperature should be measured using an infrared thermometer or temperature indicating crayon at least 100mm / 4" away from and either side of the weld joint. Best practice is to measure the temperature on the top side as heat is applied to the bottom side, this will ensure a complete preheat through the thickness of the work piece. Prior to any welding, flame cutting and air carbon arc gouging on Talon components and steel bodies the following preheat and interpass temperatures must be reached and maintained.

Material	Thickness	Min Preheat Temp	Max Interpass Temp
Talon GET Castings	All Weld-on Castings	150°C / 300°F	260°C / 500°F
ASTM A514 Steels	Greater than 63mm / 2-1/2"	120°C / 250°F	260°C / 500°F
400-450 BHN Abrasion Resistant Steel	Greater than 63mm / 2-1/2"	150°C / 300°F	260°C / 500°F

Notes:

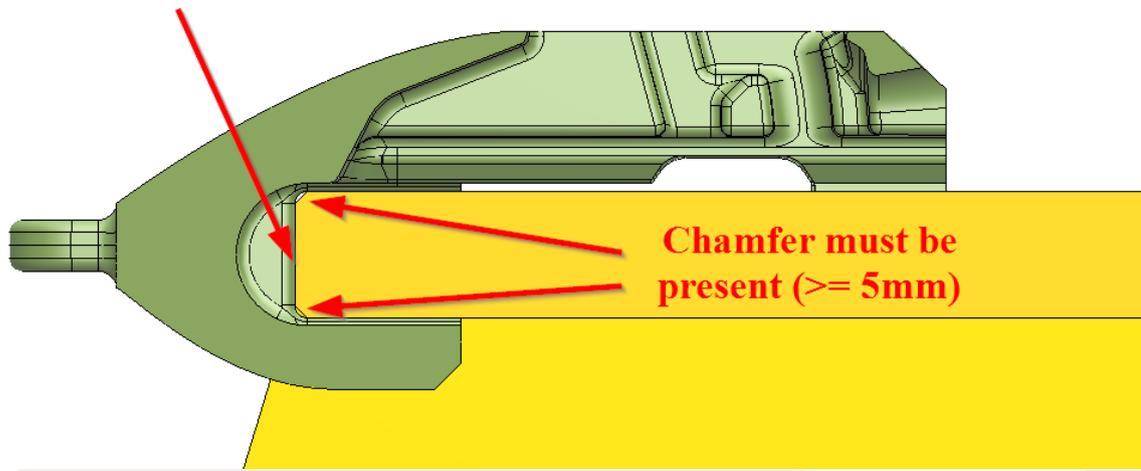
- If the ambient humidity is high and or the temperature is below 4°C / 40°F, the tabulated thermal treatment temperature should be increased by 27°C / 80°F. At no time should any material type or thickness be welded when the temperature of the steel is at or below 4°C / 40°F. This includes tack or spot welds or any allied process. Preheat must be applied as specified.
- All material within 100mm / 4" of the weld zone must be within the specified temperature.
- Cool weld slowly, for a minimum of 8 hours, utilising thermal blankets. Do not allow drafts or cool ambient temperatures to cool the parts or assembly. Cool down rate should not exceed 55°C / 130°F, per hour.
- If the ambient temperature is at or below 4°C / 40°F the part must be covered with a thermal blanket to insure the cool down rate above. Alternatively, the entire part maybe post-heated to 150 - 200°C / 300 - 400°F for four hours and then maybe air cooled.

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WELDING PROCEDURE

Check that the edges of the side wall are bevelled with a 5mm chamfer or more. Any surrounding wear material that can cause the side wall to become thicker than what the wing shroud can accommodate needs to be cut out. Slide and position the wing shrouds onto the side wall and ensure the leading edge of the shrouds touches the front face of the side wall.

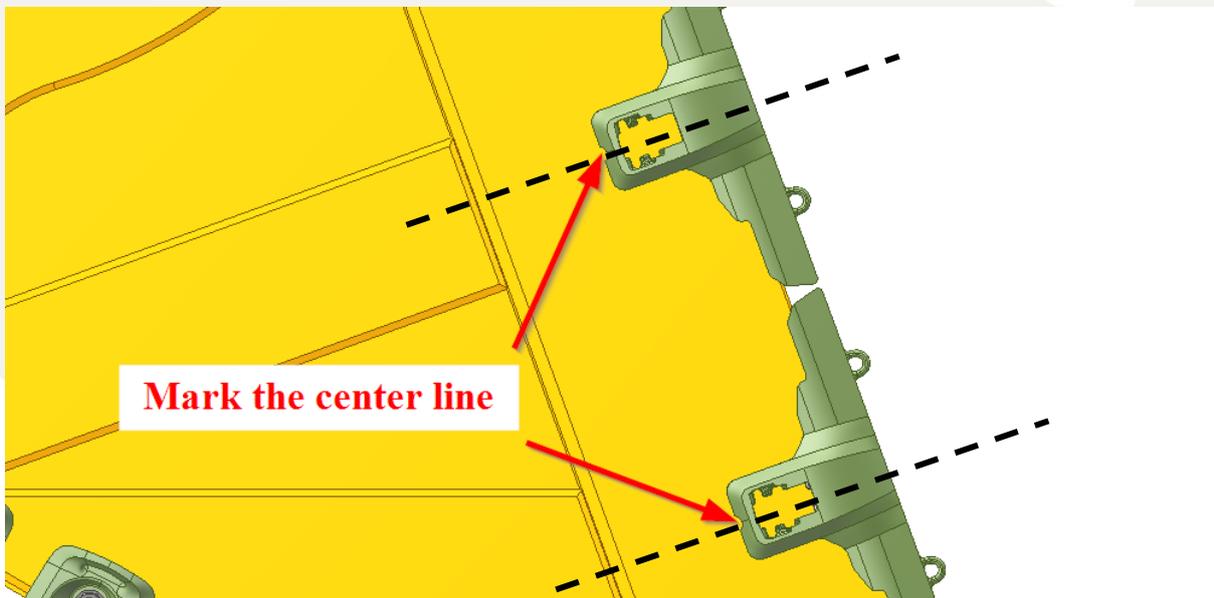
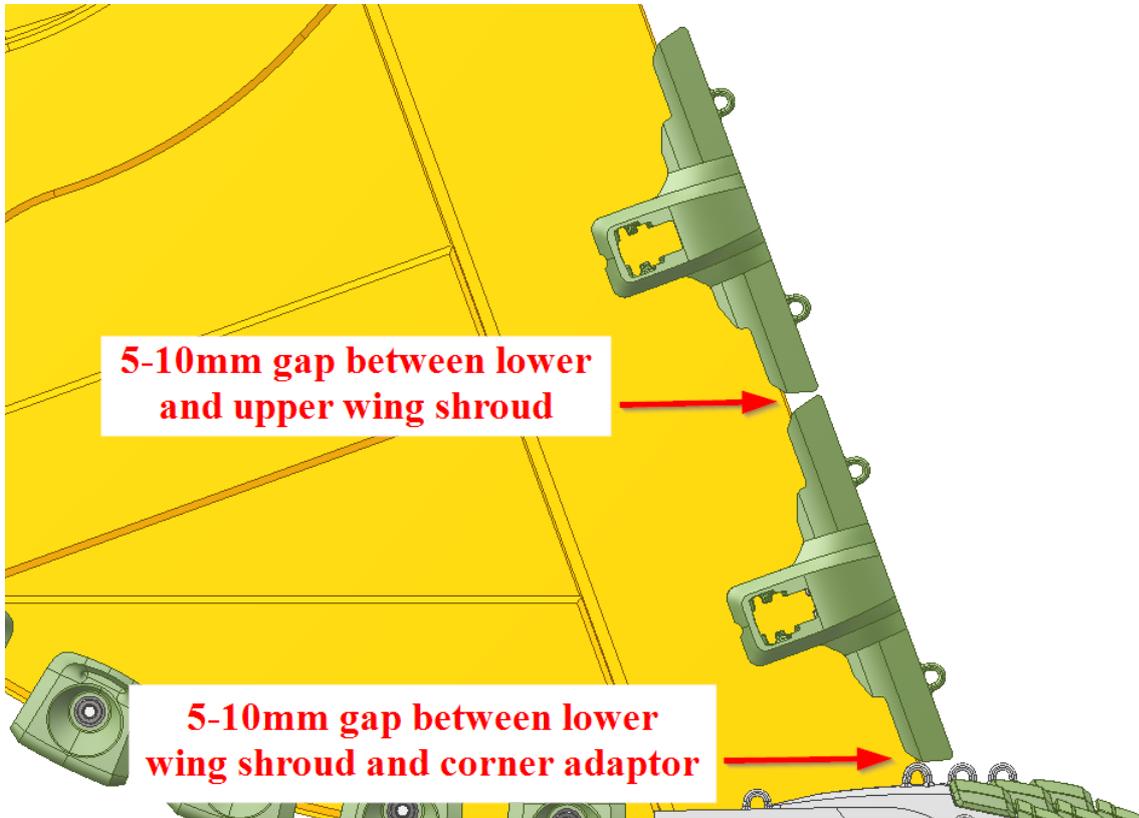
**Touching at front face
of side wall**



Depending on application, one or two wing shrouds may be needed for the bucket. Tack weld some supports between the wing shroud and side wall if the wing shrouds can move easily.

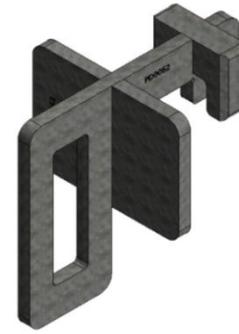
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Leave a small gap of about 5 to 10mm between the lower wing shroud and the corner adaptor. Also leave a small gap of about 5 to 10mm between the wing shrouds, then mark the centre line of both wing shrouds.



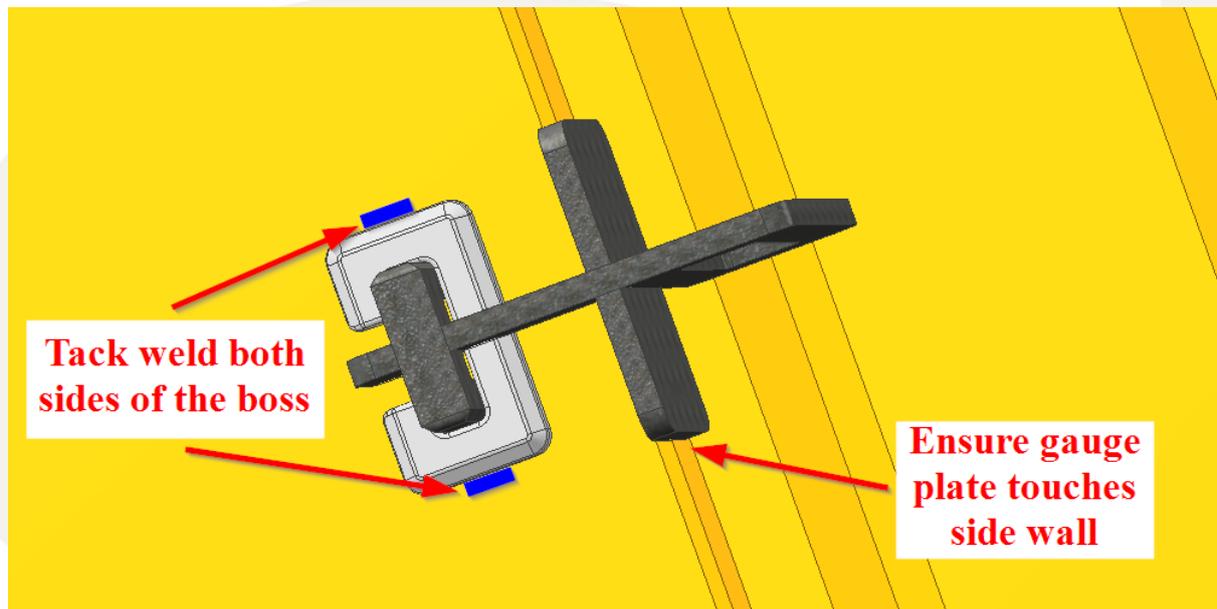
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Remove the wing shrouds. Use the centre mark to locate the Talon Bosses on top of the side wall and along the centreline. Use the appropriate Talon Template Gauge as determined from the following table to determine the set-back for each Boss on the side wall along the centreline:



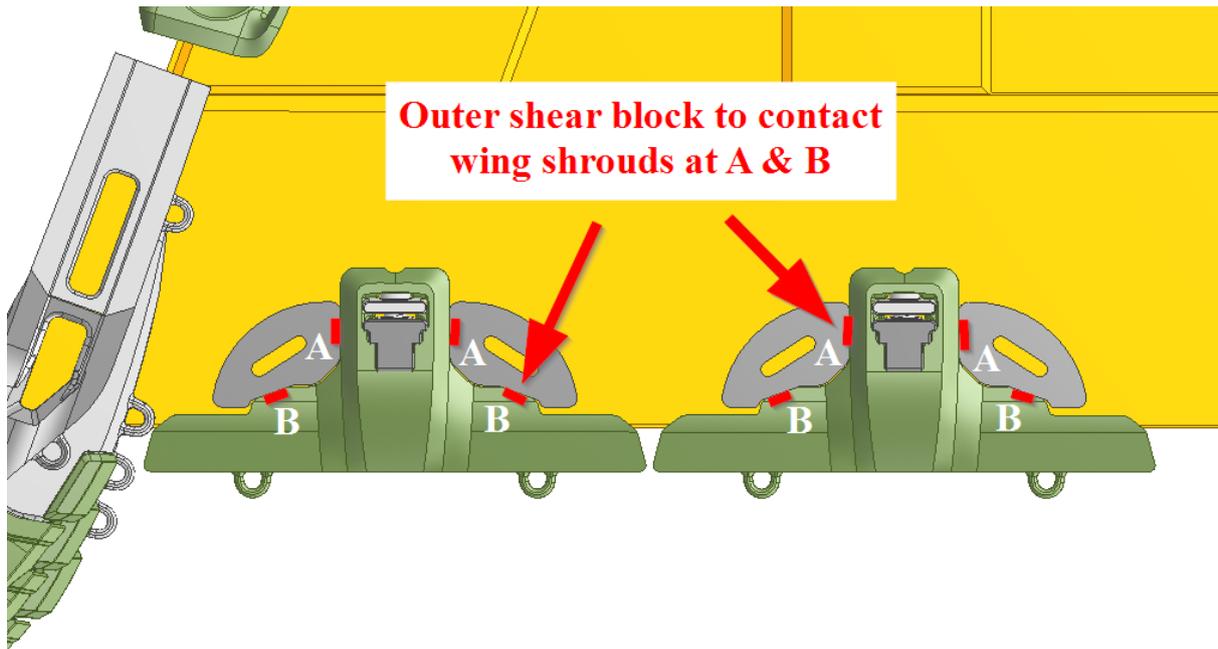
	Gauge Frame	Gauge Assembly
50mm Xpansion Wing Shroud	FG0096	FG0099
80mm Xpansion Wing Shroud	FG0096	FG0099

These gauges will locate the Talon Boss on the lip such that the Boss is in line with the direction of bucket side wall operation and front face is set back the correct distance from the lateral edge of the bucket side wall. When using the Talon Template Gauges ensure the gauge contacts with the lateral edge of the side wall and the Boss is secured fully in the locating cradle. Fix each Boss in place with one 12mm / 1/2" long tack weld at the root of the weld prep on each side of the Boss.

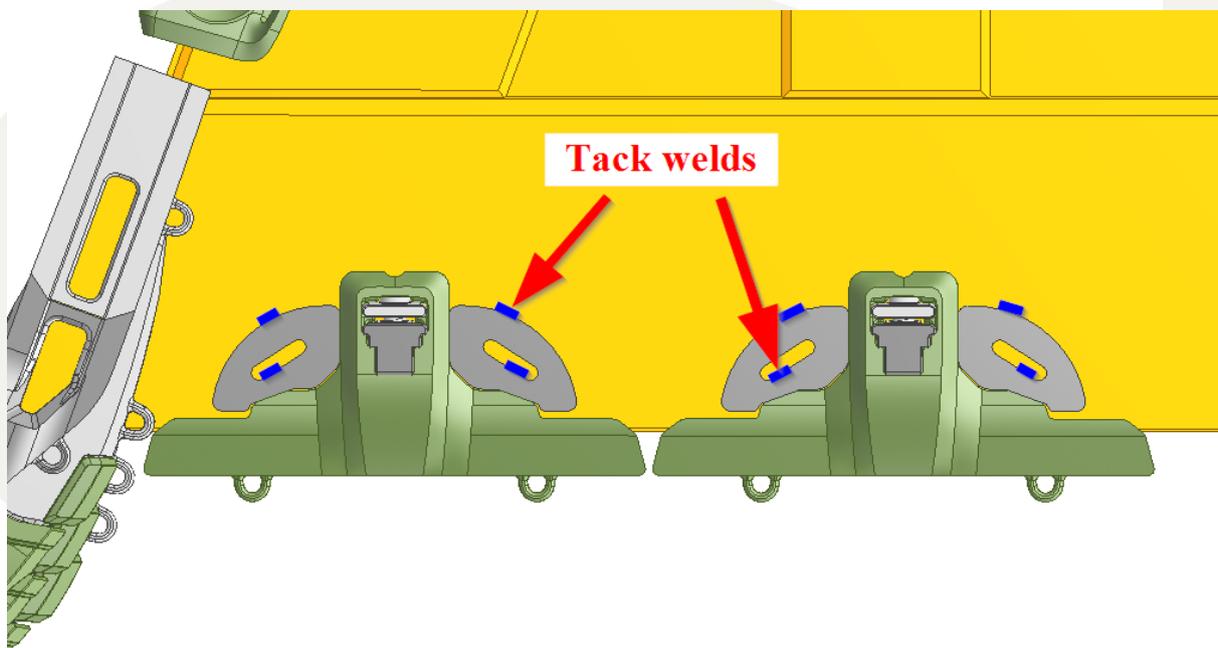


After tack weld the bosses, install the wing shrouds, and secure with the lock. May refer to the installation procedure of the wing shrouds on the side wall with Xpansion Locks as detailed in the assembly procedure AP0013. Place the outer shear blocks around the wing shrouds and on the outside of the side wall. Ensure the outer shear blocks are contacting the wing shrouds at the locations shown in the figure below.

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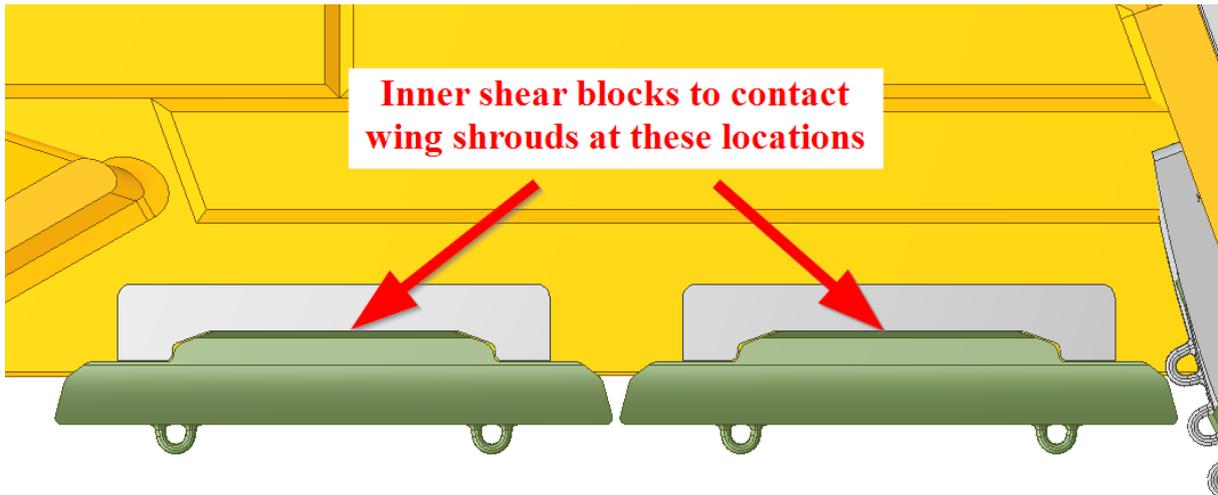


Fix the outer shear blocks by making one 12mm / 1/2" long tack weld in each of the slots and one at each of the outside curved arcs as shown in next figure.

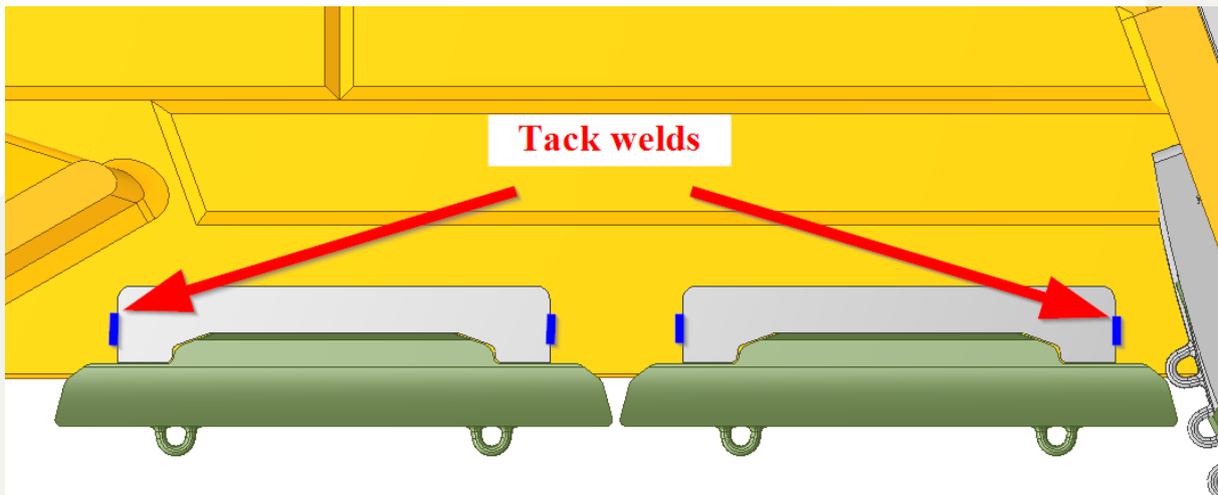


Proceed with the inside of the bucket side wall. Place the inner shear blocks and ensure the fitment faces contact the back of the legs of the wing shrouds as indicated in the following figure.

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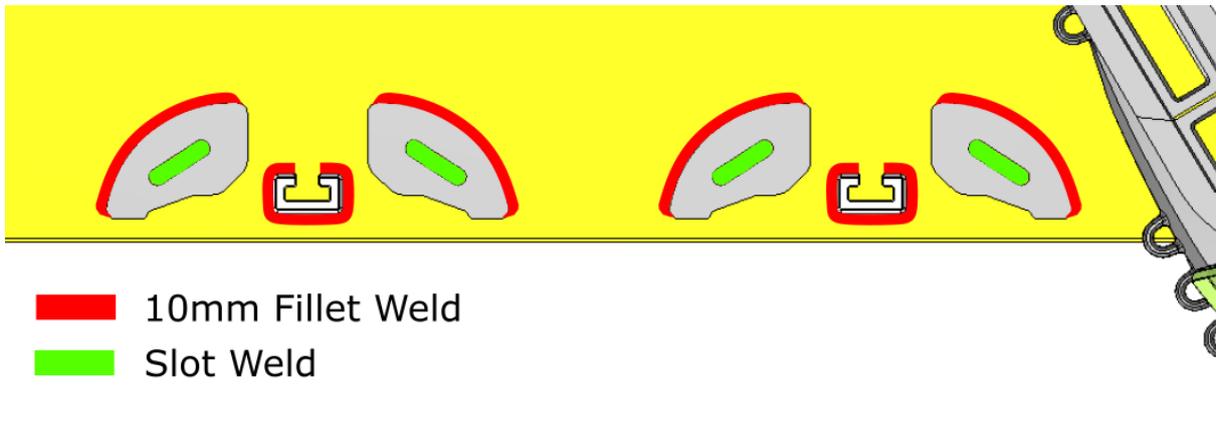
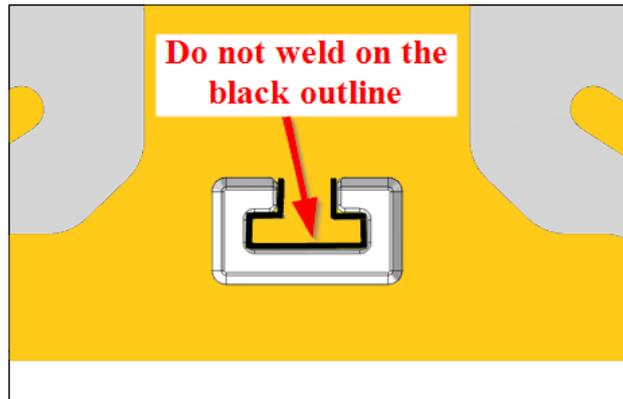


Fix each inner shear block in place with one 12mm / 1/2" long tack weld on each side of the shear block.

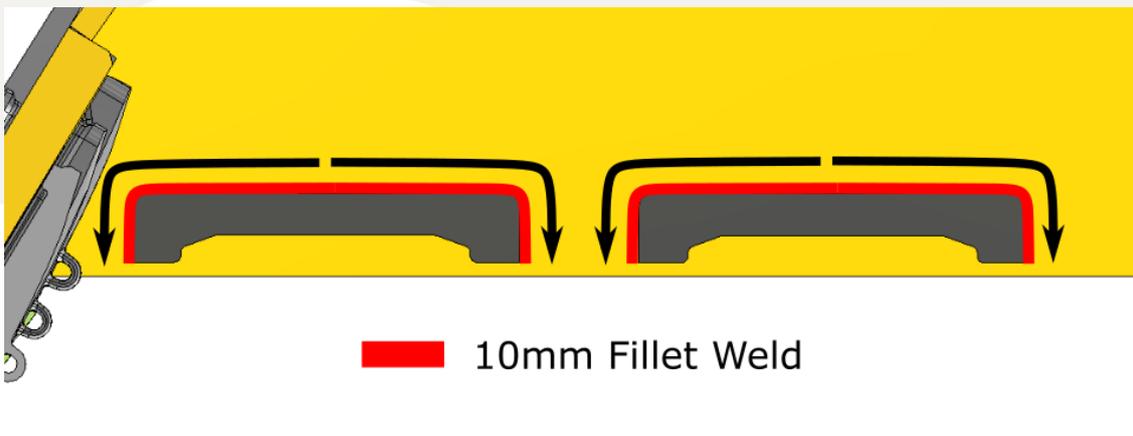


Disassemble the wing shrouds, preheat the side wall, bosses, outer shear blocks and inner shear blocks as required. Continue to fully weld bosses and blocks at the slots and the curved arcs with 10mm fillet weld size, as shown by figures on the next page. Ensure 2 or more weld passes are used to complete the full-size fillet welds. Do not weld on the inside of the bosses.

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After welding the outer shear blocks and bosses, verify the welding by checking whether the wing shrouds can fit and slide freely onto and away from the side wall without interfering with the shear blocks and bosses. Continue to fully weld the inner shear blocks with 10mm fillet weld size. Ensure 2 or more weld passes are used to complete the full-size fillet welds. Use alternate weld passes instead of continuously welding in one direction to reduce distortion.

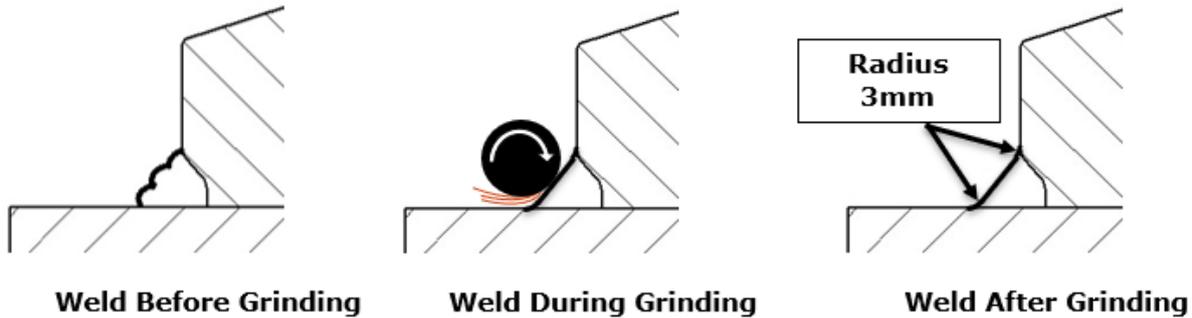


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WELD FINISHING

Welds shall be ground such that the surface of the weld becomes a smooth surface free of any roughness or ripples associated with fresh welds. The toes of the weld shall transition smoothly, such that the transition exhibits a minimum of a 3mm / 1/8" radius.

Although various methods of grinding maybe used to remove the bulk of the weld roughness. Grinding shall be finished such that any remaining grinding markings are all perpendicular to the weld.



For bosses, inspect finished weld size using Xpansion Boss Weld Gauge. This gauge is a simple GO / NO-GO gauge. The gauge should be able to pass easily over the welded Talon Boss while maintaining contact with the lip surface. If the gauges interfere with the weld surface continue to grind the weld until the gauge can pass over the Boss.

The end of the weld must be tapered and smooth prevent a stress riser at a change in restraint or profile location.

It is recommended that all finished welds are inspected for cracks using either MPI or Dye Penetrant Inspection. It is preferable to use the MPI process. Any cracks detected must be completely gouged out and filled with weld. Finish the repair with grinding as detailed above and re-inspect for cracks.

CHANGE REGISTER

Rev	Date	Changes from previous version
0	22/03/2021	Original Issue
1	04/04/2022	Add preheat notice, update Welding Setup details and Weld Finishing