


WELDING INSTRUCTIONS

The lifespan of spikes mainly depends on the ground conditions. On hard rocky ground, the life can be as little as 6 months, and on soft ground they can last for many years.

Spike re-welding is delicate balance between getting enough penetration on the joint and **NOT** overheating the track pad. We strongly recommend following the procedures for best results:

PREPARATION

- Take the track into the workshop **24 hours** before welding on spikes.
- Clean the area where the spike is to be welded, removing dirt, rust and debris, and make sure there is no moisture on the track.
- Preheat this area to **150°C** with a gas torch.

It is vitally important that the tracks are clean and dry to reduce the possibility of hydrogen embrittlement which can be fatal to a track. 

	Esab OK Autrod 12.50		Esab OK 48.00
Diameter, mm	1.0mm wire	1.2 mm wire	3.2mm electrode
Arc voltage, V	22v-25v	24v-28v	23v
Welding current, A	200A-220A	260A-300A	115A

MIG wire electrode:

ESAB AUTROD 12.50 (or similar)

Welding electrode:

ESAB OK74.78 (or similar)

WELDING PROCESS

- Place spikes into position and tack onto the track.
- Starting at the first spike (1), weld on opposite side of the tack lateral to the track plate (A), and then move onto the next spike (2), completing one weld **only** on each spike.
- Never weld across the track plate.
- After all the spikes have been given one weld, start at the first spike (1) and weld on the opposite side (B).

