

Welding Instruction

Welding fillers to use:

Recommended rod electrode

► **BÖHLER FOX 7018 (or similar)**

Recommended wire electrode

► **BÖHLER EMK 6 TOP (or similar)**



General information:

To avoid cracks in the material, a pre-heating of the base material of min. +80 ° C is recommended.

The welding area at the pewag bluetrack should be dry and clean before welding the stub.

The welding seam should not be more than 5 mm.

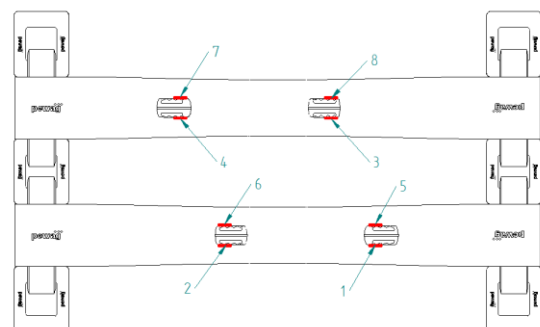
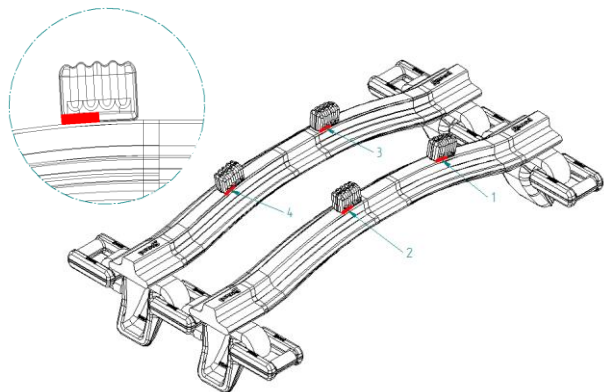
Instruction:

To avoid excessive heating of the base material please follow the steps below:

If possible, please always work on two profiles at the same time.

Please weld only ¼ of a pewag bluetrack stub at the beginning, see red marking step 1 – 4.

The next step is to weld ¼ of the stub on the backside, see red marking step 5 – 8.

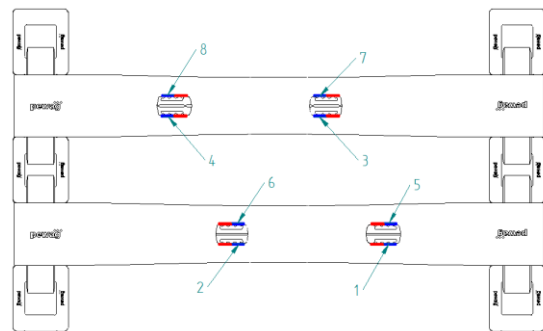
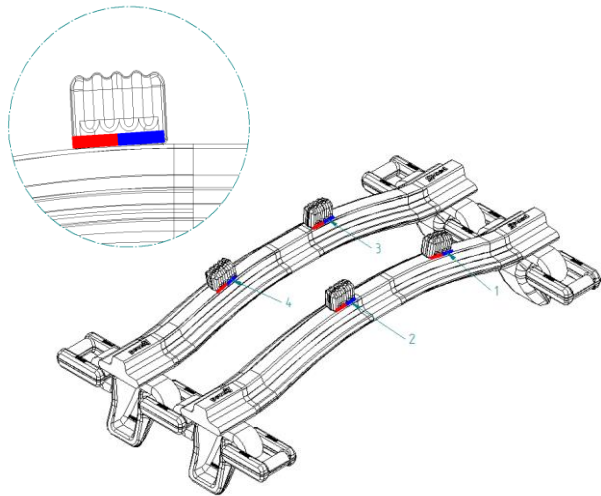


Now start to finish the welding on each side of the stubs, see blue marking.

Start first with step 1 – 4 and then continue with step 5 – 8 as shown in the illustration.

Leave yourself enough time between the process steps so that the material is allowed to cool down.

To continue with the next two profiles please start at the beginning of this instruction.



Technical changes and misprints excepted.