

Spike Welding Procedure

When welding spikes onto the track plate, it is vitally important that the tracks are clean and dry and also at ambient temperature of at least 18°C . Pre-Heating to 200°C is also desirable.

Recommended welding electrode

ESAB OK74.78 (or similar)

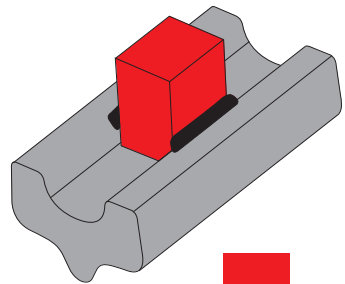
Recommended MIG wire electrode

ESAB AUTROD 13.12 (or similar)

Stage 1

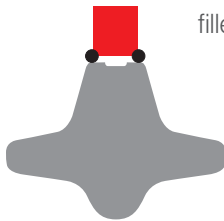
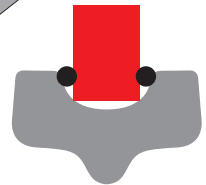
Start by tacking all spikes in place. Do not place spikes on the centre of the track pad, nor within 100mm of existing spikes.

To avoid overheating the track plate, work along and round the track as per stages 2 – 5 below.



Stage 2

Work along length of track, welding only 1 side of the spike, no greater than 5mm fillet weld (Terra).



Stage 3

Work down other side of track, welding only 1 side of the spike, no greater than 5mm fillet weld (Terra).



Stage 4

Work along the first side of the track (step 2), performing the second weld per spike.

Stage 5

Finish by working along the second side (as started in stage 3), completing the second weld per spike.