

S-264 Pad Eye Welding Guidelines

Welding is to be performed by a qualified welder using a qualified procedure in accordance with American Welding Society and/or American Society of Mechanical Engineers requirements. Always follow your country or local mandatory regulations or codes.

The following welding recommendations should be included in the qualified procedure for welding to low or medium carbon steel. For welding to other grades of steel a qualified weld procedure must be developed.

- a) Weld material is to have a minimum tensile strength of 70,000 PSI (such as AWS A5.1 E-7018). Always observe the electrode manufacturer's recommendations.
- b) Before welding, all weld surfaces must be clean and free from rust, grease, paint, slag and any other contaminants.
- c) Pre-heat pad eye and base area to a temperature range of from 70°F to max 400°F.
- d) Fillet weld size should be equal to the base height of the pad eye.
- e) Welding should be carried out in a minimum of two passes to ensure adequate root penetration at the base of the pad eye.
- f) Weld completely around the base.
- g) Do not rapidly cool the weld.
- h) A thorough inspection of the weld should be performed. No cracks, pitting, inclusions, notches or undercuts are allowed. If doubt exists, use a suitable NDE method, such as magnetic particle or liquid penetrant to verify.
- i) If repair is required, grind out the defect and re-weld using the original qualified procedure. After welding, apply a load at least equal to 1.5 times the maximum service load.

Classification	Catalog No.	Document No.	Revision No.	File Name
EYE	264	264-2	0	tds2642.doc