



HACK8 WELD ON 'D' RING

WELDING INSTRUCTIONS

Pay attention to the following points during welding:

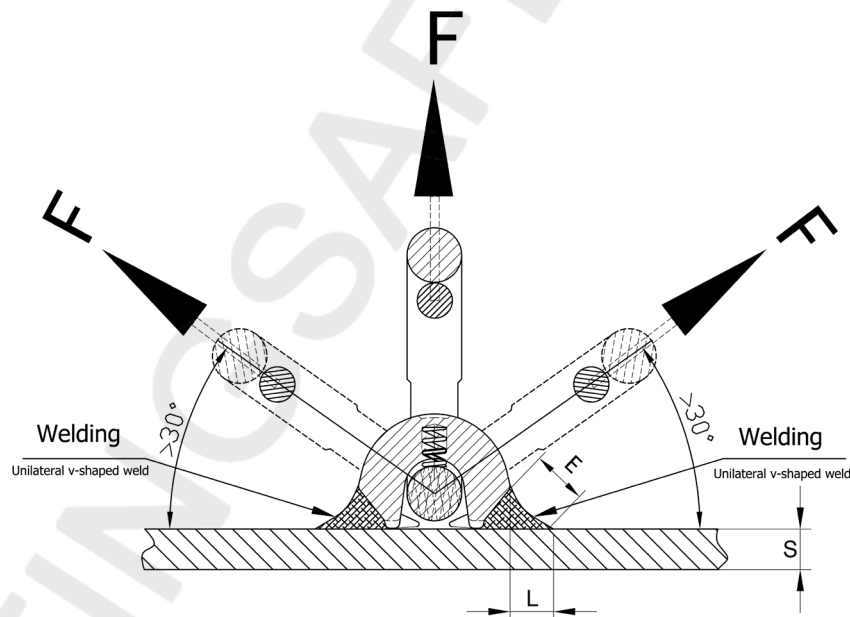
- The welding should be carried out by a qualified welder according to DIN EN 287-1.
- Material of welding block is St 52-3 (1.0570).
- The connecting surfaces must be free from dirt, oil, colour etc.
- Do not weld at the powder coated tempered load ring.
- The complete construction can be annealed stress-free for several times at 600°C without reduction of the Working Load Limit (WLL).
- The welding spot has to be suitable for the corresponding force introduction.
- The distance lugs assist in achieving the required root weld (approx. 3mm).

Important

By the arrangement of weld (continuous HV), the following requirements are fulfilled:

DIN 18800 for steel building prescribes

At outdoor sites or in case of special danger of corrosion, the welds should only be designed as continuous, fillet welds. The HV weld at the LBS assures a connection via the whole cross-section of the material. This corresponds to the closed weld showing no signs of corrosion.



| Part Code | WLL t | Mass kg | S Min. thickness of baseplate | E Welding bead width | L (Min) |
|-----------|-------|---------|-------------------------------|----------------------|---------|
| 8-H08-001 | 1.12 | 0.5 | 6 | 12 | 10 |
| 8-H08-003 | 3.15 | 0.9 | 10 | 15 | 12 |
| 8-H08-005 | 5.30 | 1.3 | 12 | 22 | 18 |
| 8-H08-008 | 8.00 | 2.6 | 14 | 24 | 20 |

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