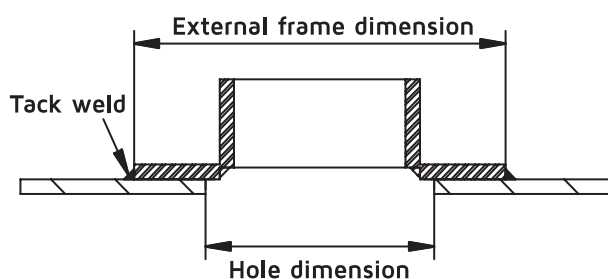
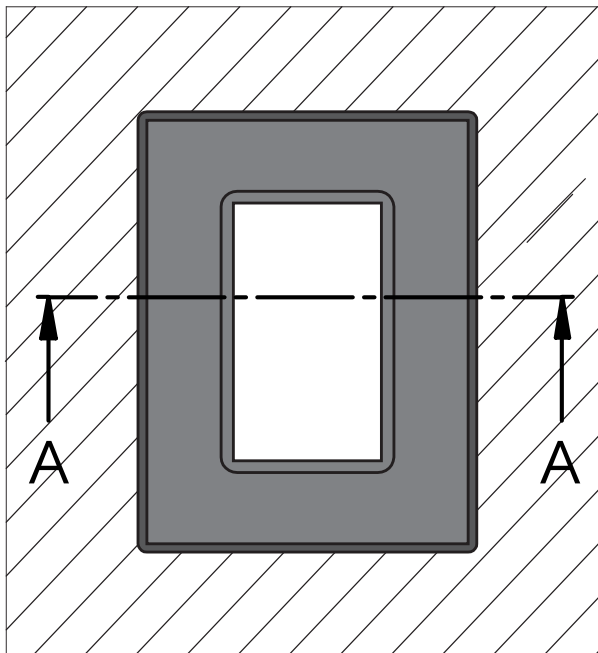


HMFX WELDING INSTRUCTIONS

1. Tack weld on the front side, centring the frame onto the cut-out hole.
Same as step 2 of standard welding instructions.



Minimum hole dimension	=	(external HMFX dimensions)	less 110mm
Maximum hole dimension	=	(external HMFX dimensions)	less 10mm

2. Grind off weld tacks before start filled weld. Weld runs should not start or stop at a tack weld but should run over a tack.

Follow same welding sequence for correct procedure.

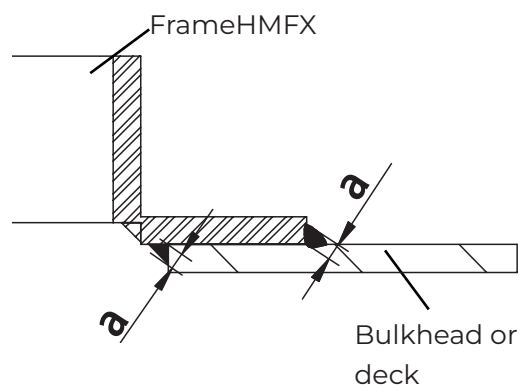
The interpass temperature should not exceed 200°C for mild steel and aluminium and 150°C for stainless steel.

This welding throat should not exceed following values:

$$\begin{aligned} T > 7\text{mm} & \quad a = 5\text{mm} \\ T \leq 7\text{mm} & \quad a = 4\text{mm} \end{aligned}$$

■ Max Run Length

{	Mild Steel	200 mm
	Stainless Steel	150 mm
	Aluminium	200 mm



$$\text{Heat Input (KJ/mm)} = \frac{V \cdot I \cdot \eta}{\text{vel} \cdot 1000} \quad \eta = \begin{cases} 1 & \text{SMAW} \\ 0,8 & \text{GMAW / FCAW} \\ 0,6 & \text{GTAW} \end{cases}$$

V = volts / I = amperes / vel = mm/s

	Máx. Heat Input (KJ/mm)		
	Mild Steel	Stainless Steel	Aluminium
$a = 4 \text{ mm}$	1,2	1,1	2
$a = 5 \text{ mm}$	1,4	1,1	2