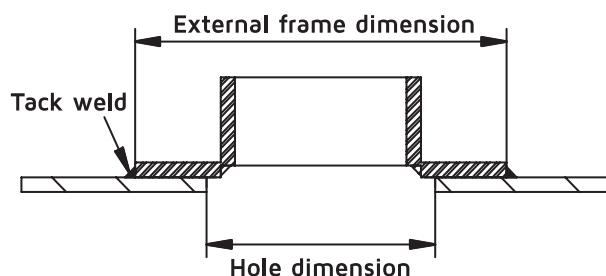
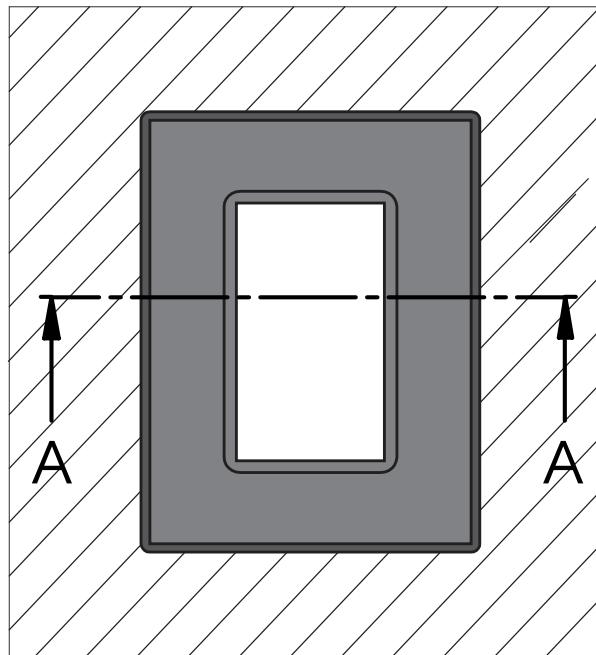


 **HMFX WELDING INSTRUCTIONS**

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.

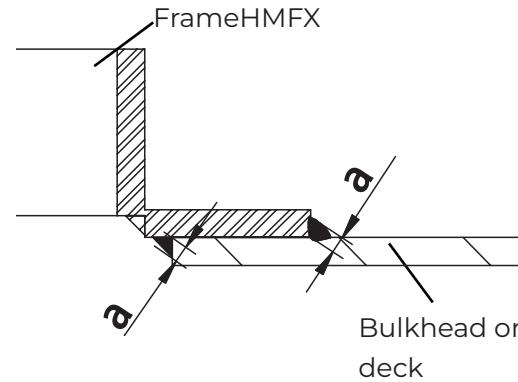
The interpass temperature should not exceed 200°C for mild steel and aluminium and 150°C for stainless ste

This welding throat should not exceed following values:

T > 7mm    a=5mm  
 T ≤ 7mm    a=4mm

Max Run Length

$\left\{ \begin{array}{l} \text{Mild Steel} \\ \text{Stainless Steel} \\ \text{Aluminum} \end{array} \right. \begin{array}{l} 200 \text{ mm} \\ 150 \text{ mm} \\ 200 \text{ mm} \end{array}$



$$\text{Heat Input (KJ/mm)} = \frac{V \cdot I \cdot \eta}{\text{vel} \cdot 1000}$$

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

$$\eta = \begin{cases} 1 & \text{SMAW} \\ 0,8 & \text{GMAW / FCAW} \\ 0,6 & \text{GTAW} \end{cases}$$

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