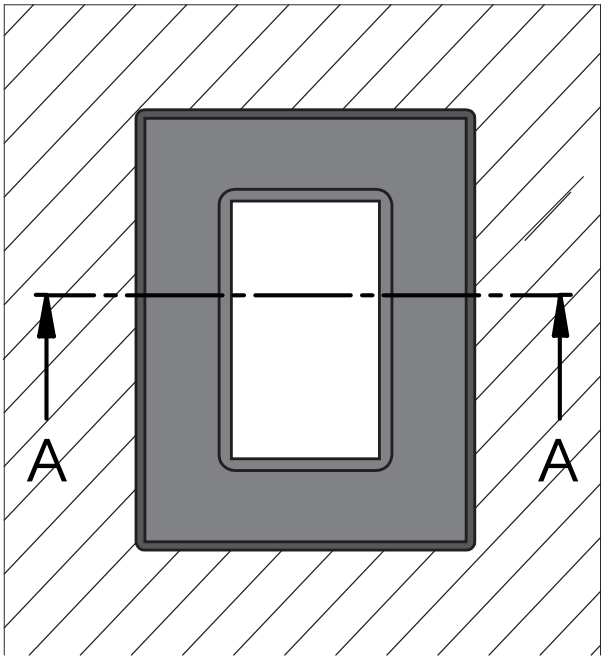
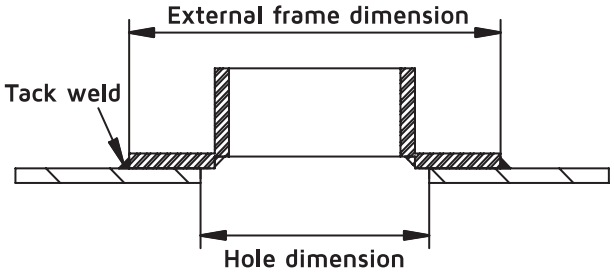
HTS

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

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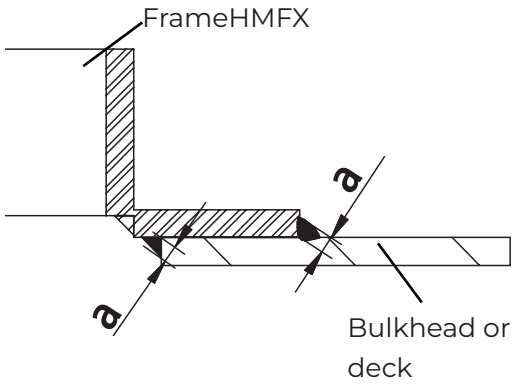
2. Grind off weld tacks before start filled weld. Weld runs should not start or stop at a tack weld but should run over a tack.

Follow same welding sequence for correct procedure.
The interpass temperature should not exceed 200ºC for mild steel and aluminium and 150ºC for stainless ste

This welding throat should not excess following values:

T >7mm a=5mm
T ≤ 7mm a=4mm



- Max Run Lenght
  - Mild Steel: 200 mm
  - Stainless Steel: 150 mm
  - Aluminum: 200 mm

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

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

η = { 1 SMAW; 0,8 GMAW / FCAW; 0,6 GTAW }

	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