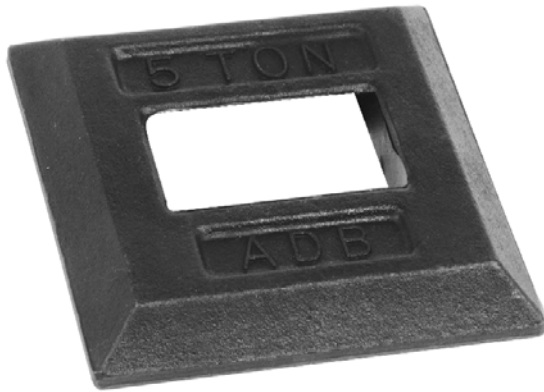
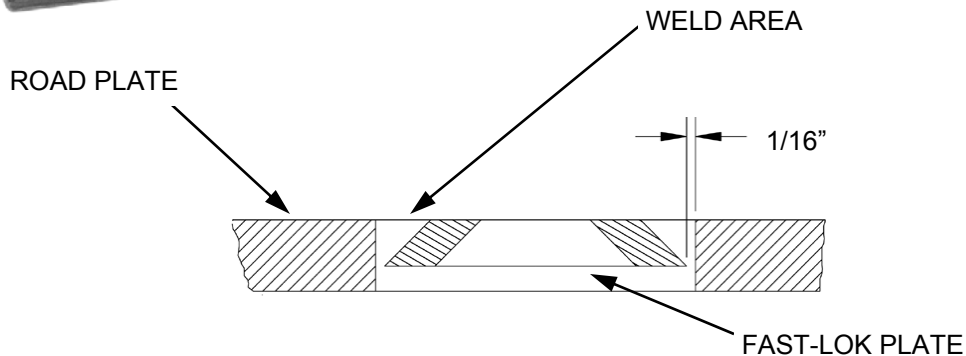




# WELDING INSTRUCTIONS FOR WELD-IN FAST-LOK™ PLATE



- Material: Alloy steel.
- Minimum tensile strength of 180,000 psi.
- 100% Magnetic Particle Inspected
- Finish: Black Oxide per MIL C-13924B



## WELDING INSTRUCTIONS:

- Use electrode AWS class E7018 per MIL-E-22200/1
- Center Fast-Lok Plate with 1/16" clearance on each side
- Align with top surface of road plate and tack weld in place to start.
- Preheat the Fast-Lok Plate and roadplate in an area approximately 6" radius around the roadplate cutout hole to 200°-300° F.
- Preheat temperature must be held during the welding process. A propane torch could be used for this.
- Use fresh electrodes because old electrodes may have absorbed humidity into the flux which could cause cracking.
- Weld Fast-Lok Plate to road plate from top side.
- Cool gradually to prevent cracking.
- For MIG welding use ER70S-2 or ER70S-6 .035 diameter wire.

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