

Product Welding Procedure

Title:	Recommended Removal Procedure for Sandvik Shark Half Arrow, Heel Shroud and Cast Corner		
Applicable Parts:	All Sandvik Shark Half Casting Parts and Heel Shroud		
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Date:	21 November, 2012	Date:	13/09/2023

1. SUMMARY

This report visually details the recommended procedure to be followed when removing Sandvik Shark Half Arrow, Heel Shroud and Cast Corner components from the lip. The basic procedure can and is recommended to be utilised when removing Half Arrow and Heel Shroud from other applications as well, for example bucket cheek plates or bulldozer blades.

2. TARGET TEMPERATURES


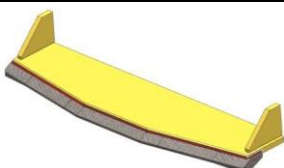
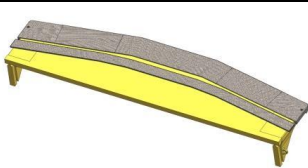
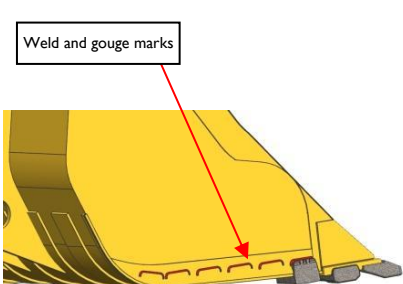
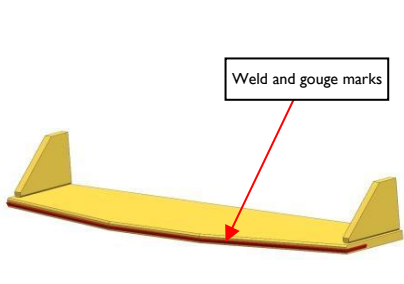
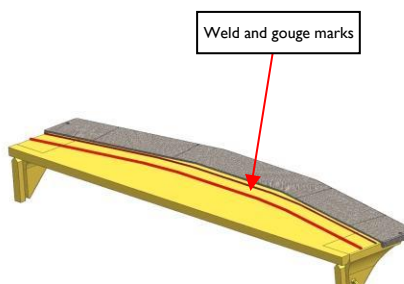
It is important to preheat components prior to removal from the bucket. See the below table for weld temperatures.

Products	Target pre-heat temperature °C	Max inter-pass temperature °C
Shark G.E.T. castings and heel shrouds	160-190	230

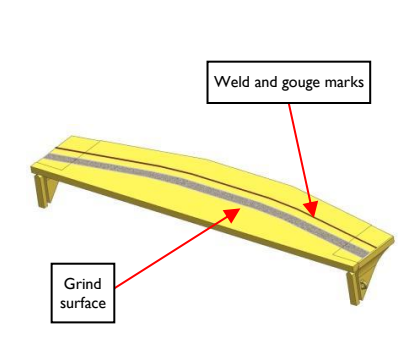
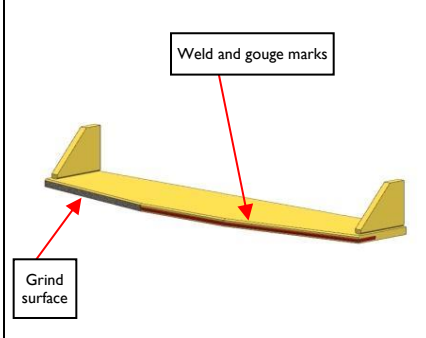
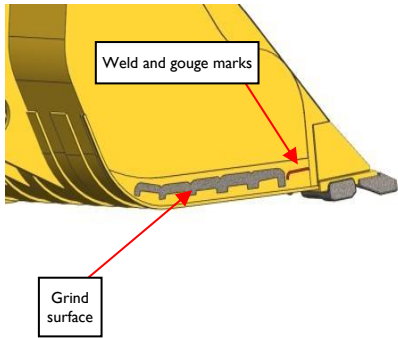
Table 1: Preheat, Inter pass temperatures

Refer to Weld Procedure PWP0001 for more details.

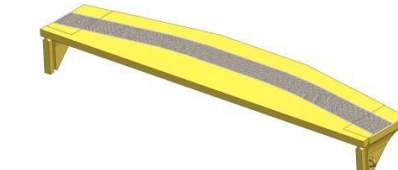
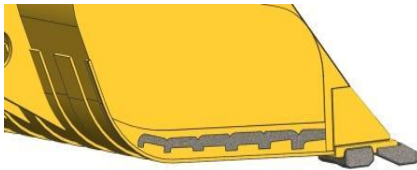
3. PROCEDURE

1. Worn parts:		
Heel Shroud	Half Arrow welded to plate or Cast Corner	Profile Bar or Cast Profile Bar
		
2. Gouge parts of the bucket:		
		
When removing Heel Shrouds, Half Arrow and Profile Bar ensure OEM manufacturing procedures, local site safety procedures, and welding procedures are followed.		

3. Use a grinder to remove leftover welds and to clean carbon-infused areas from the bucket or lip:



4. Perform NDT (Non-Destructive Testing) on the gouged area of the bucket to ensure no cracking exists. If cracks are found regrind to remove entire cracks and reweld according to PWP0001 and relevant OEM welding procedure:



5. To weld the parts to the bucket or lip follow the relevant OEM welding procedure (*options shown below*):

PWP0014

PWP0016
PWP0021

PWP0009
PWP0026
PWP0030

4. REVISION HISTORY

Rev	Date	Changes	Revised By	Approved
0	21/11/2012		Justya Czekaj	
1	13/09/2023	Added temperatures and document change register	R. Lauchlan	M. Javadi