



PROCEDURE FOR CUTTING SANDVIK WELD ON G.E.T.

SHARK™ GROUND ENGAGING TOOLS

1.0. INTRODUCTION

This procedure details the procedure and requirements to be followed before cutting any weld on Sandvik Shark Ground Engaging Tools (G.E.T.) made from SS2000, SS2500 or SS2300 materials by flame cut or similar hot-work procedures. The following products are made from these materials which generally require trimming the length before being installed on the primary lip.

- Half Arrow Straights
- Cast Profile Bar Side Bars
- Blue Pointer II™ Cast Corners
- Mako™ Cast Corners
- and similar future products from Sandvik Shark with similar material characteristics

2.0. SAFETY

2.1 Use mechanical lifting aids and follow site or workshop-specific safety requirements during handling and cutting of Sandvik GETs.

2.2 Throughout all stages of handling, Personal Protective Equipment (PPE) must be worn. This includes but not limited to steel toe cap boots, safety glasses and gloves.

3.0. PREHEAT TEMPERATURE

Material	Target Pre-heat temperature °C	Max cut temperature °C
Sandvik Shark castings	100-150	230

Table 1 Preheat, Inter-pass temperatures

Refer to Weld Procedure PWP0001 for more details.

4.0. PREPARATION AND PROFILING SAFETY

4.1 Follow the dimensions specified in the Lip Layout drawing (SL0XXX) or other provided drawing or instruction to determine the trim length needed for weld on parts

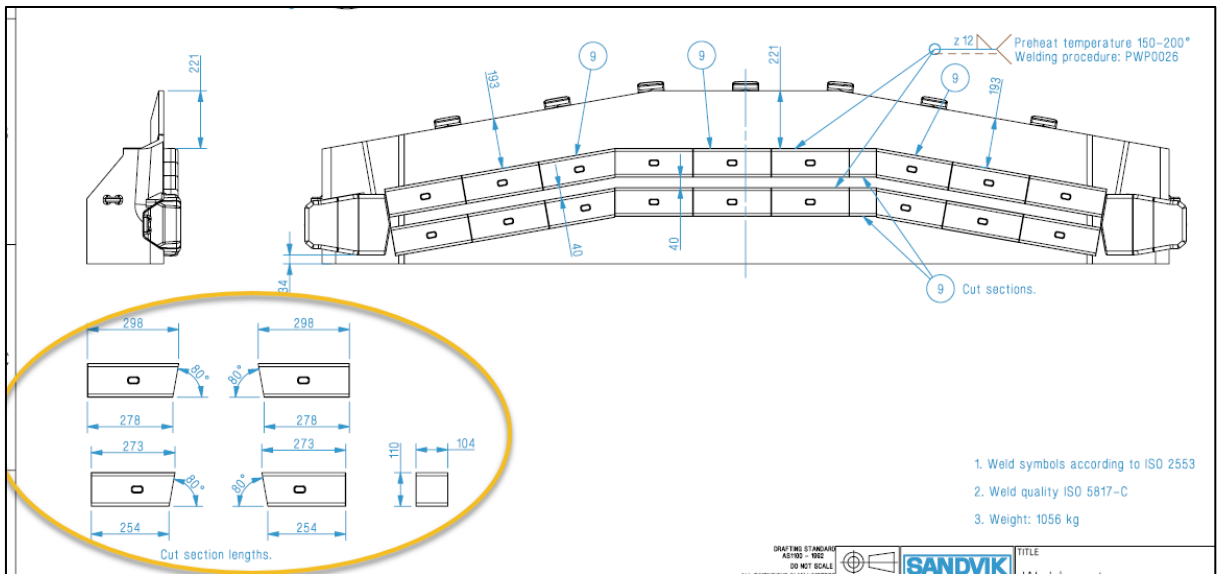
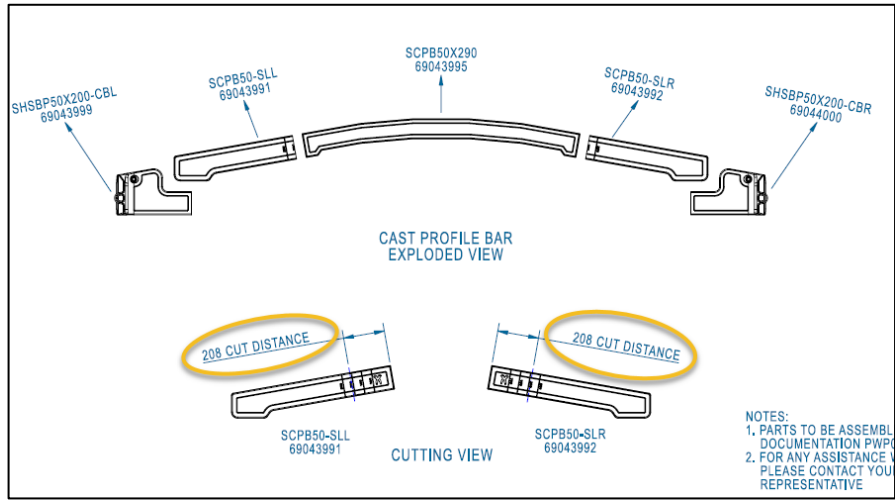
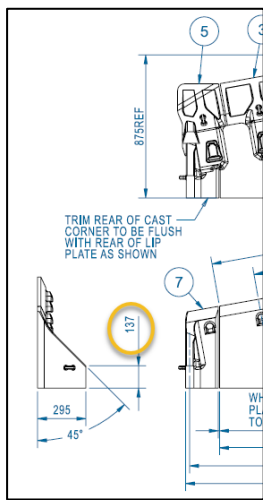
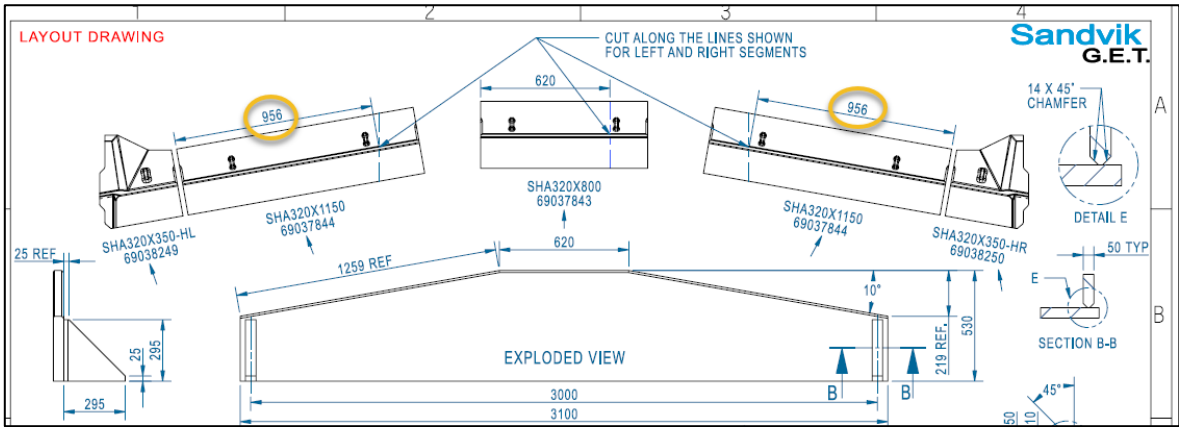


Figure 1 Trim lengths – Example

Note: The above images are for reference only. Refer to the correct drawing for accurate lengths.

- 4.2 Mark the desired trim length on the part to be cut.
- 4.3 Secure the part that requires trimming safely on a table or stand using mechanical aids.



5.0. PREHEATING REQUIREMENTS & TEMPERATURE DURING CUTTING

- 5.1 Before performing any cutting operations, preheat the to the target temperature (refer to Section #3 Table 1) measured at least 75mm / 3" either side of the scribed cut line.
- 5.2 Apply preheat to all around the part at the cut line preferably by using a LPG heating torch. Measure temperature at the area being cut.

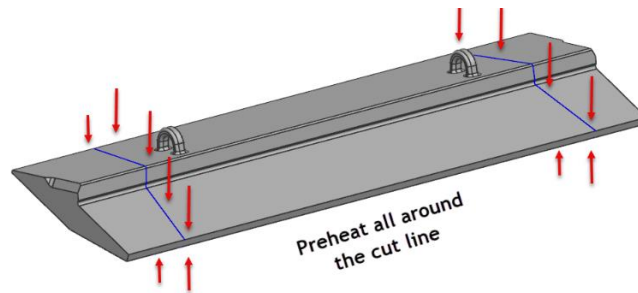


Figure 2 Example – preheat around cut line

- 5.3 Cut the GET at the scribed line. Ensure the temperature at the cut area does not exceed the max inter-pass temperature (refer to Section #3 Table 1) at any time during the cut.
- 5.4 After thermal cutting, grind all cut surfaces to remove heat affected zone (HAZ), scale and debris.
- 5.5 If arc gouging/cutting method is used to cut the casting, then ensure Carbon rich layer is completely removed by grinding.
- 5.6 Trial assemble the trimmed part to check if the part will fit to the adjacent G.E.T prior to preheating and tack welding.
- 5.7 Follow the applicable procedure for welding the trimmed component.



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6 REVISION HISTORY

Rev	Notes	Prepared By	Checked By	Approved By	Date
0	Initial release	J. Jose	B. Knowles	M. Javadi	20/04/2021
1	Document revised by including feedback from weld consultant	J. Jose	Weld consultant	M. Javadi	24/02/2023
2	Add weld temperature table	R. Lauchlan	J. Jose	M. Javadi	23/11/2023

