

S0024 Repair SB330 Stabiliser Housing H Pin

S0024	Version 1	Structural	14-07-05
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The following is a procedure for repairing the H pin when cracking occurs in the weld around the H pin boss.

Removal of cracked weld:

The removal of cracked welding must be carried out. It requires the following:

1. The weld around the boss needs to be removed to the dimensions shown in figure 1. The removal depth of weld required should be 10mm as shown in figure 1. If the crack continues into the boss, then the boss needs to be removed and a different procedure is required. If the crack exceeds the diameter of 96mm then the web will need to be replaced and a different procedure is to be used.
2. After the weld material has been removed, the boss needs to be welded back to web plate to the weld details in figure 2, and to the weld specification WP-34538.

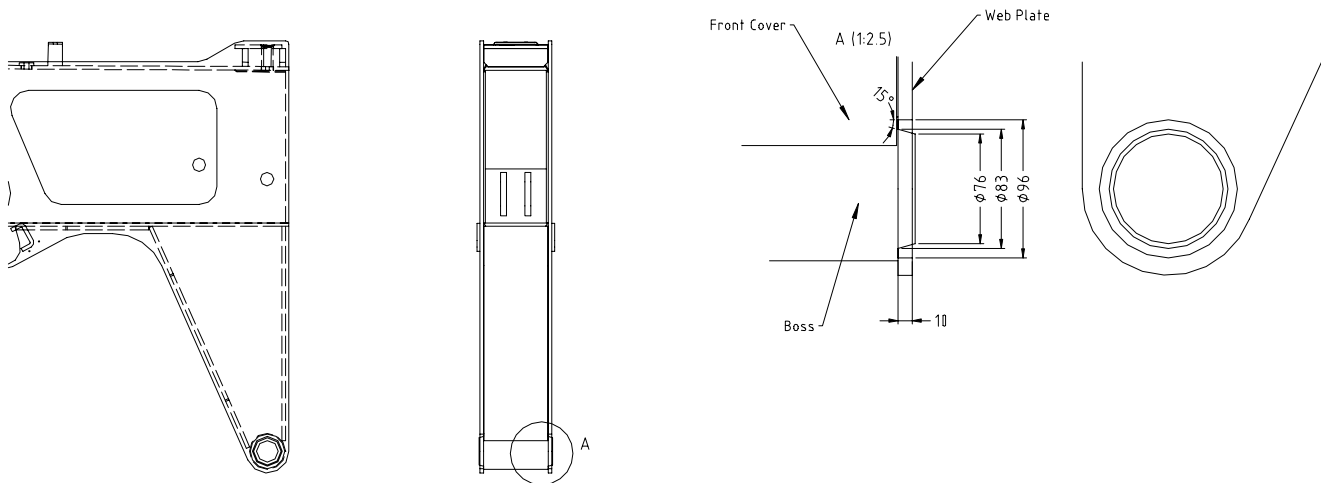
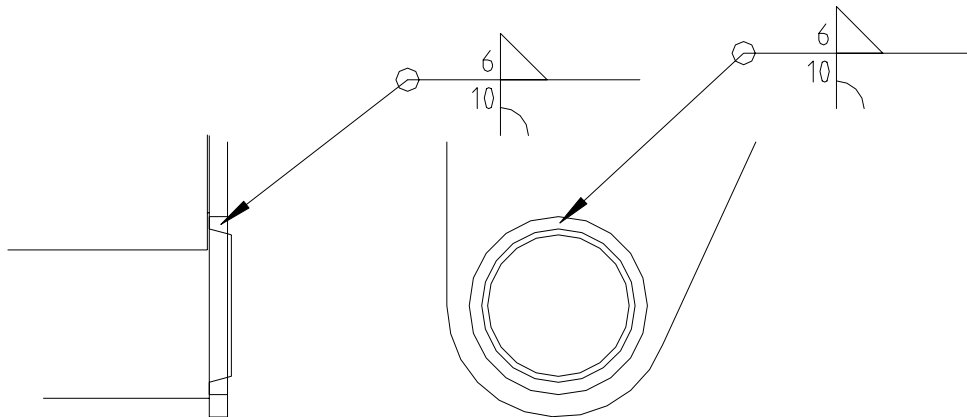


Figure 1: Weld material removal required



WELDING NOTES:			
Parent Material: ASTM A514			
Filler Material: CMK56 or Equivalent			
Gas: Argonshield Universal			
Wire: Solid Wire 1.2mm			
AWS A5.18/ASME SFA5.18ER 70S-6			
	3 - 12mm	12 - 19mm	19 - 25mm
PREHEAT	50 - 75°C	75 - 100°C	100 - 120°C
MAXIMUM INTERPASS	150°C	180°C	200°C

Figure 2: Welding requirements, weld to weld specification WP-34538