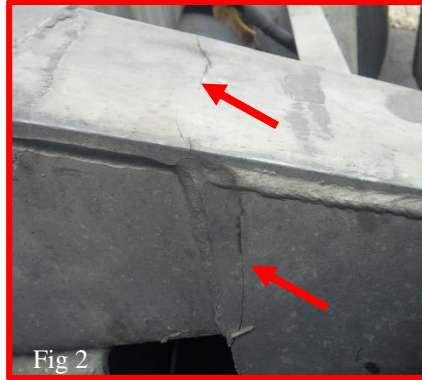
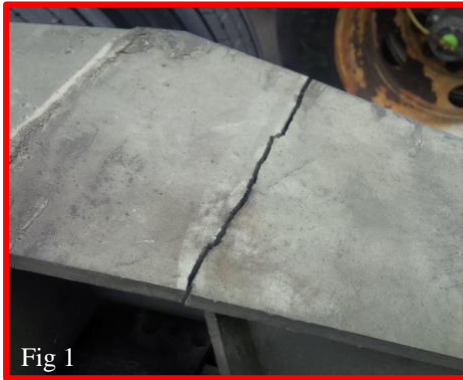


Converter Dolly Inspection

6/17/2016



Issue Overview: Cracked dolly counterbalances (Fig 1-3). The failure of this connection is progressive in nature and inspection is required until units can be repaired.



Cracked counterbalance

Inspection:

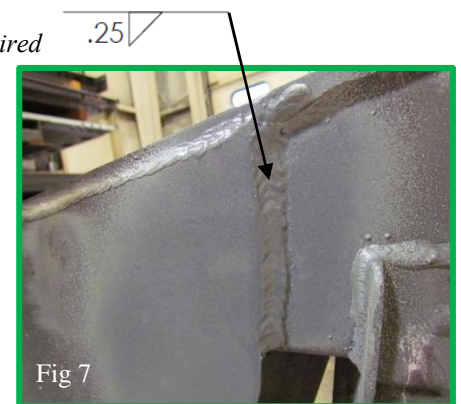
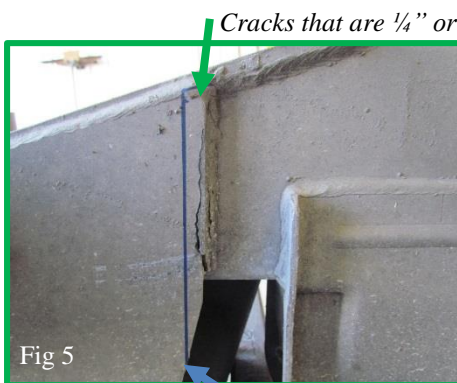
- Inspect counterbalance connections for cracks (Fig 4). Dollies with cracks across top plate are to be taken out of service immediately until repairs can be made (Fig 1). These units need to be transported on flatbed to repair location.
- Outboard vertical side welds can be temporarily repaired to get units to a repair location, coordinated with WNC Warranty.
- Temporary repairs still require a final repair as soon as possible.



Arrows indicate areas of inspection

Temporary Repair:

- If crack is present only on outboard vertical weld, unit can be temporarily repaired by grinding out the entire crack. Care must be taken not to grind into top cap. Any notch to top plate must be welded and ground smooth. Grind vertical line down through entire leg (Fig 5 & 6). Re-weld with a *vertical up joint* (Fig7).
- Then coat the repair with cold galvanization.



Cracks that are 1/4" or more from top plate weld can be temporarily repaired

Regardless of crack length, grind to new material behind crack and through entire vertical leg. See cut line

Next Steps:

- Work with WNC Warranty to understand geographical location. Technical bulletin is available and Warranty group is working on a list of service providers who can perform repair.

For any questions, please contact WNC Warranty at 765-771-5404