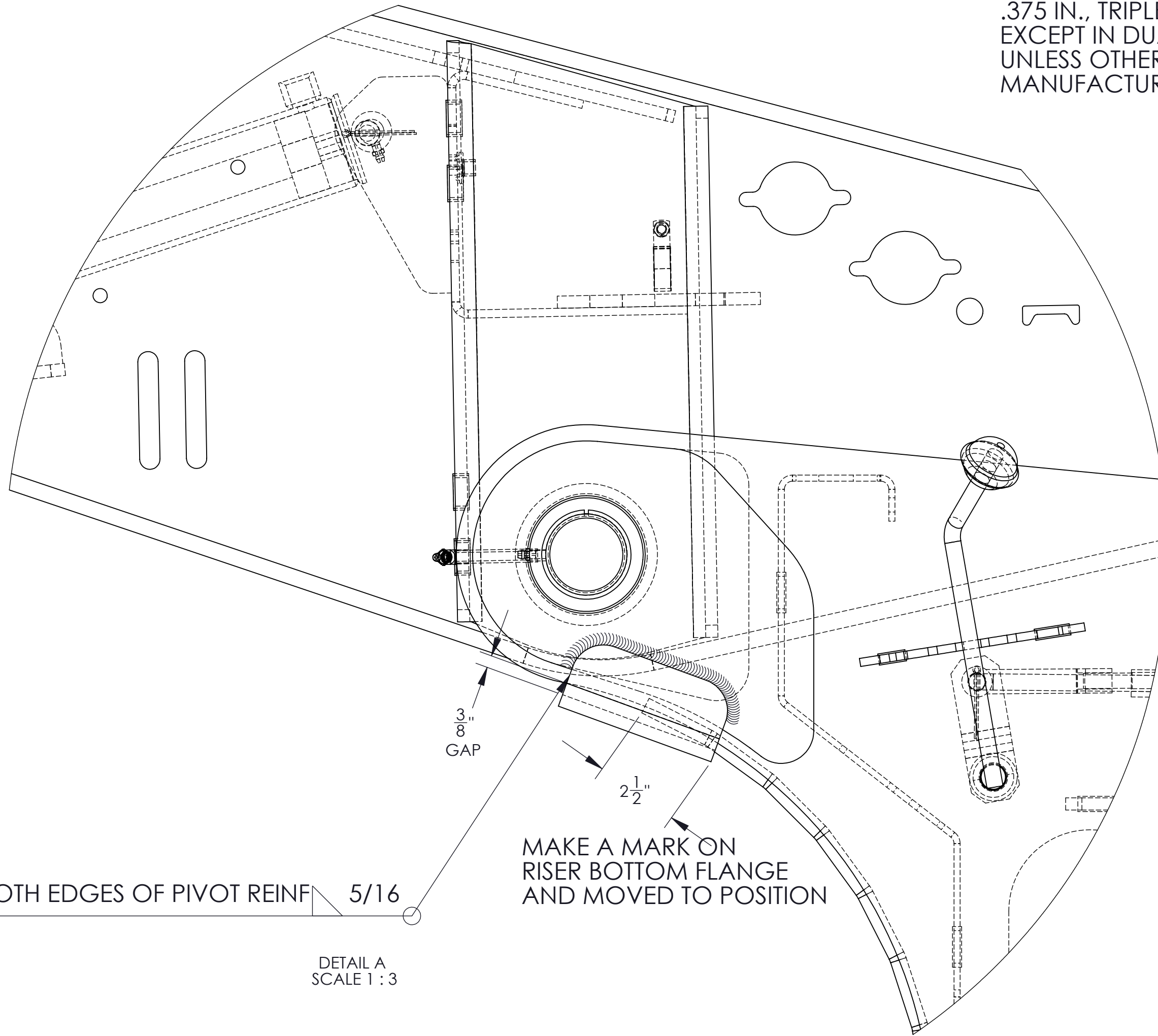


WELDING:
AMPERAGE: 270-330
VOLTS: 25-32
WIRE SPEED: 320-370
WIRE TYPE: ER-70S-6(L-56)
OPTION: ER-70S-3(L-50)
WIRE DIA: .045-.052
SHIELD GAS: 95% ARGON, 5% O2
OPTION: 90% ARGON, 10% CO2

THE NUMBER AND SEQUENCE OF WELD PASSES SHALL BE DICTATED BY MATERIAL THICKNESS. ALL WELDS SHALL BE MINIMUM 1/4 IN. FILLET WELD. WHEN THE THINNEST MATERIAL BEING JOINED IS EQUAL TO OR GREATER THAN .375 IN., TRIPLE PASS WELDING SHALL BE REQUIRED, EXCEPT IN DUAL WIRE SUB-ARC WELDING PROCESS. UNLESS OTHERWISE SPECIFIED BY ENGINEERING MEMO, MANUFACTURING MEMO, OR TRAIL KING SPECIFICATION.



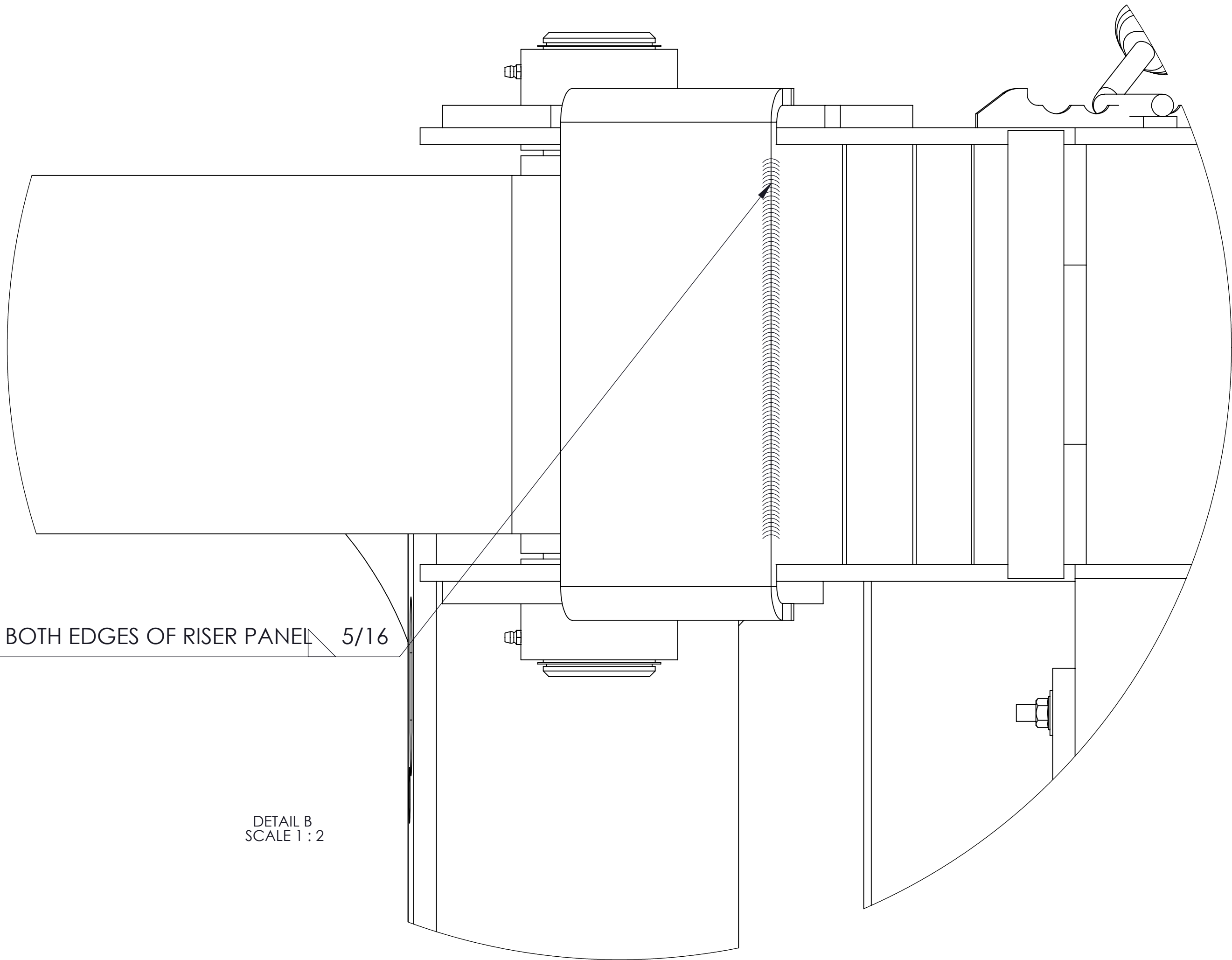
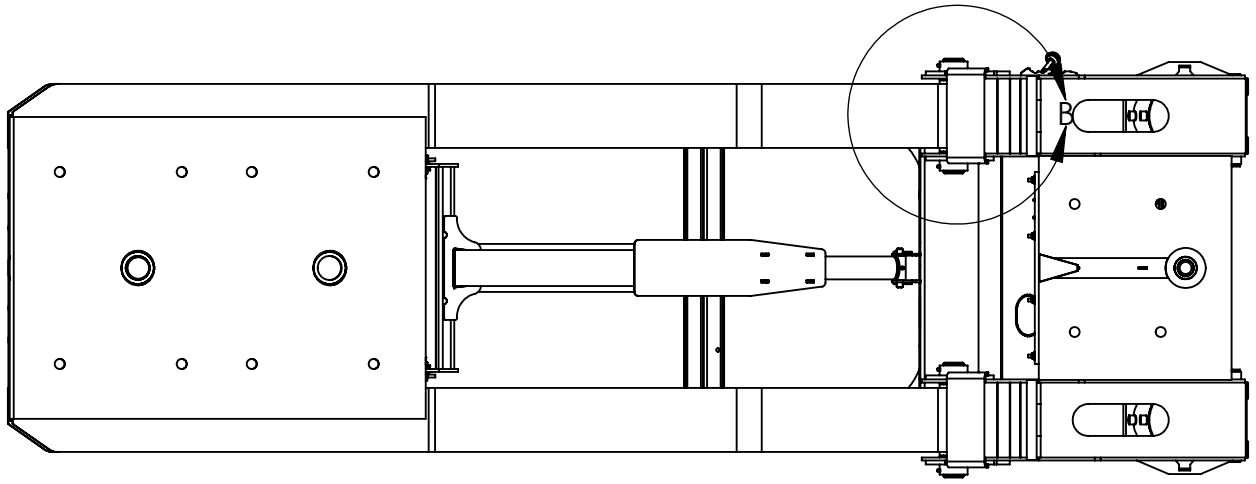
3/8"
GAP

2 1/2"

MAKE A MARK ON
RISER BOTTOM FLANGE
AND MOVED TO POSITION

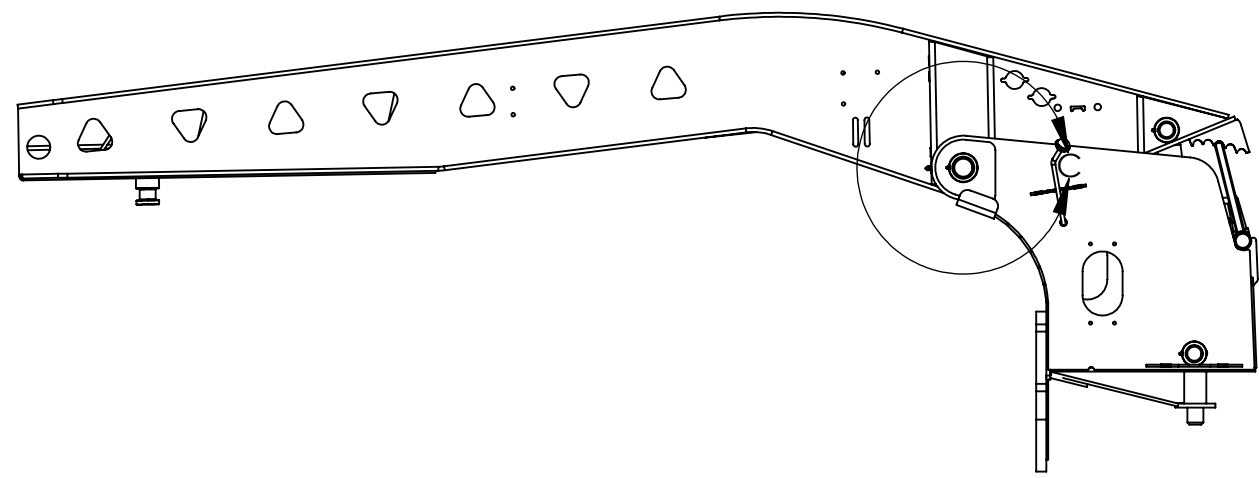
STAY 1/2" AWAY FROM BOTH EDGES OF PIVOT REINF 5/16

DETAIL A
SCALE 1 : 3

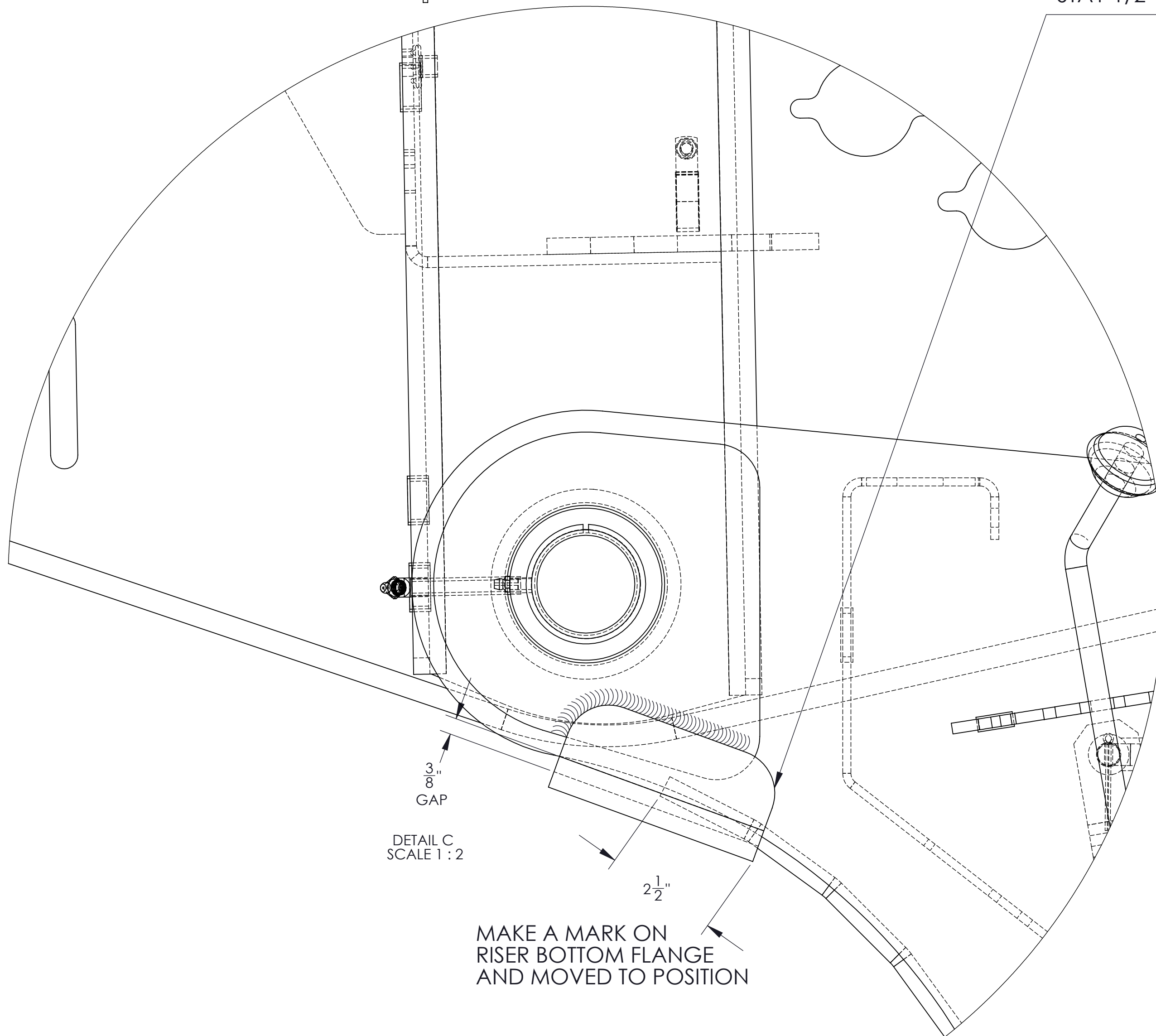


STAY 1/2" AWAY FROM BOTH EDGES OF RISER PANEL 5/16

DETAIL B
SCALE 1 : 2



STAY 1/2" AWAY FROM BOTH EDGES OF PIVOT REINF 5/16

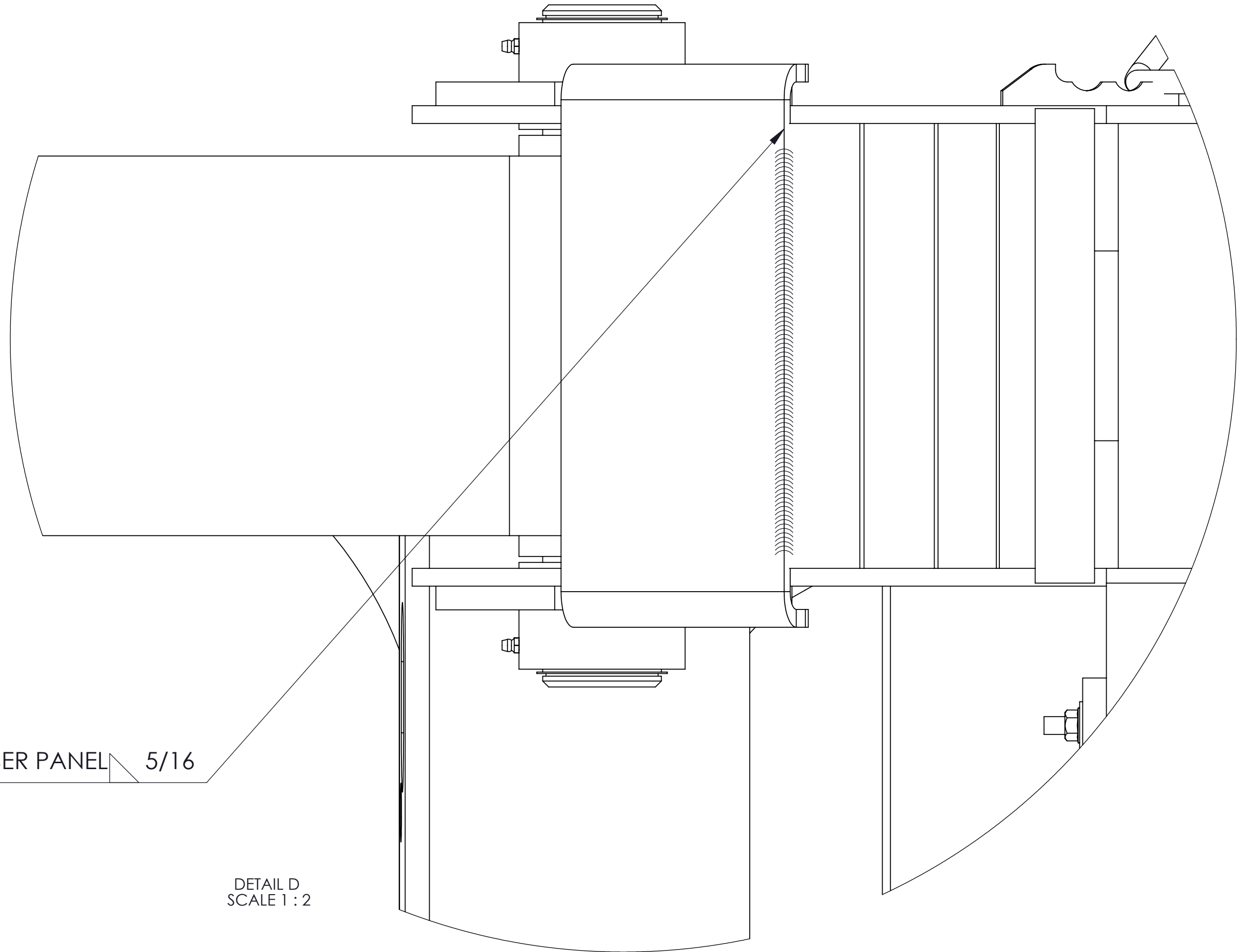
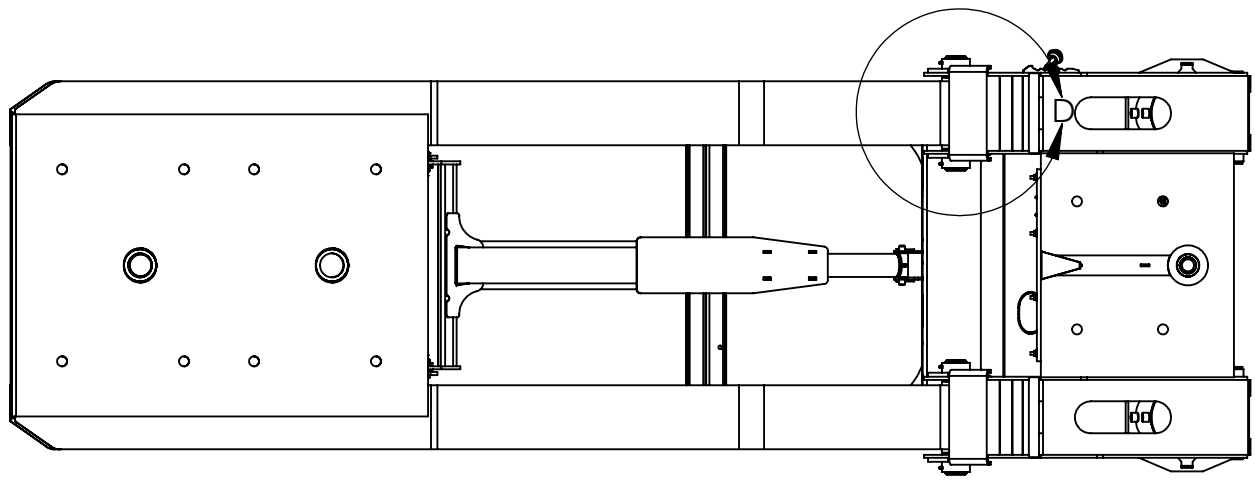


3/8"
GAP

DETAIL C
SCALE 1:2

2 1/2"

MAKE A MARK ON
RISER BOTTOM FLANGE
AND MOVED TO POSITION



STAY 1/2" AWAY FROM BOTH EDGES OF RISER PANEL 5/16

DETAIL D
SCALE 1 : 2