

Procédure R13029

SP13-22 RADIUS ROD SUPPORT WELD INSPECTION
REFER TO SAP FOR CODES AND NOTIFIED VEHICLES
POUR LA VERSION FRANCAISE SE RÉFÉRER AU RETROFIT R13029

WELD BEADS MAY BE TOO SMALL ON RADIUS ROD SUPPORTS ON REAR SUB-FRAME.
(PART 175113)
X SERIES VEHICLES WITH NEW SUB-FRAME ONLY.

LIFT VEHICLE.

ON REAR SUB-FRAME, CHECK THE SIZE OF THE WELD BEADS ON THE 3 EDGES OF EACH RADIUS ROD SUPPORT.

CORRECT SIZE IS 8MM (5/16").

IF SIZE IS INCORRECT, UNPLUG ALL ELECTRONIC MODULES & EQUIPMENT ACCORDING TO USUAL PROCEDURE FOR PROTECTION OF ELECTRONICS BEFORE WELDING.

CLEAN WELD REMOVING GRAVEL GUARD, ETC.

WELD USING FCAW STAINLESS - FLUX CORE GAS SHIELDED WIRE
APPLY FOLLOWING PARAMETERS: 26 volts 190 amps gaz: 75% Ar, 25% CO2 @ 35 CFH

ADD GRAVEL GUARD.

PLUG ELECTRONICS BACK.

