SERVICE BULLETIN

NUMBER: 11-001-14

GROUP: Exhaust System

DATE: January 23, 2014

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SUBJECT:
Weld Length on Exhaust Hanger Bracket Too Short

OVERVIEW:
This bulletin involves inspecting the Selective Catalytic Reduction (SCR) inlet exhaust hanger bracket weld length and increase the weld length if too short.

MODELS:

2013	DD	Ram 3500 Cab Chassis
2013	DP	Ram 4500/550 Cab Chassis

NOTE: This bulletin applies to vehicles equipped with the 6.7L engine (Sales Codes ETK).

SYMPTOM/CONDITION:
The exhaust inlet hanger bracket on suspect vehicles may have the weld securing the bracket to the hanger too short. A short weld may lead to premature hanger failure.

DIAGNOSIS:
If a customer's VIN is listed in VIP or your RRT VIN list, perform the repair.

PARTS REQUIRED:

Qty.	Part No.	Description
AR (1)	68065844AB	Gasket, Exhaust Pipe
AR (1)	04627714AA	Gasket, DEF Injector

SPECIAL TOOLS/EQUIPMENT REQUIRED:

	TIG Welder

REPAIR PROCEDURE:

1. Raise the vehicle on a lift.
2. Locate the SCR inlet hanger bracket (Fig. 1).

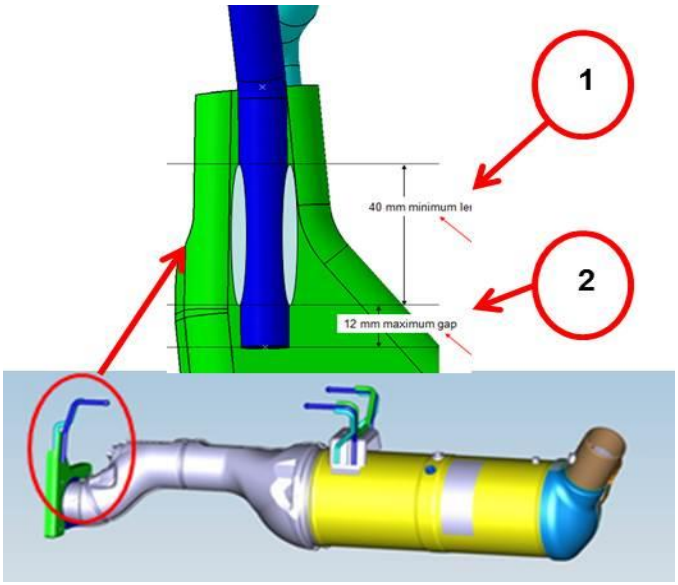

Fig. 1 SCR Hanger Bracket

1 - Minimum Weld Length is 40mm (1.57 in.)

2 - Minimum Weld Distance From Rod End is 12mm (0.47 in.)

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3. Measure the distance from the end of the hanger rod to where the weld starts to secure the rod to the bracket (Fig. 2).

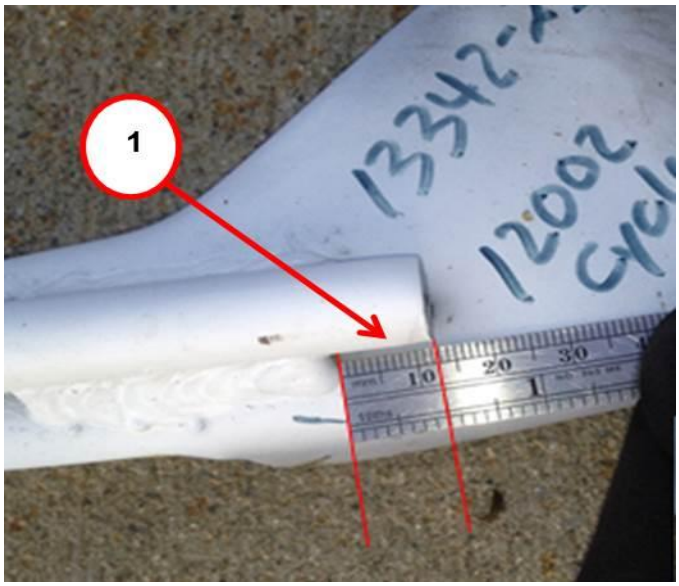

Fig. 2 Weld End Gap

1 - Minimum Weld Distance From Rod End is 12mm (0.47 in.)

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4. Is the distance 12mm (0.47 in.) or less?
   a. YES>>>Continue to the next step.
   b. NO>>>Proceed to Step #7 (dealer repair) or Step #19 (sublet repair).
5. Measure the length of the rod to bracket weld on each side of the rod (Fig. 3).

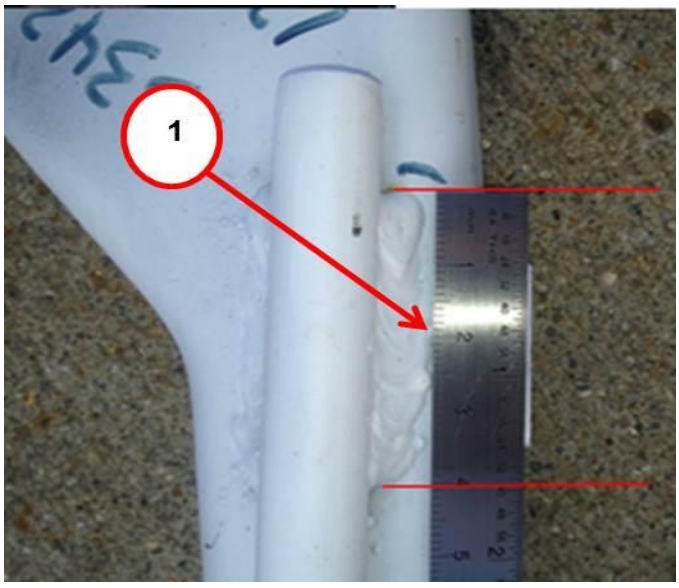

Fig. 3 Weld Length

1 - Minimum Weld Length is 40mm (1.57 in.)

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6. Is the length of the rod to bracket weld 40mm (1.57 in.) or longer on each side?
   a. YES>>>Inspection complete. No additional work is necessary.
   b. NO>>>Proceed to the next step.

NOTE: This procedure requires the use of a TIG welder. If the dealership does not have a TIG Welder, it is recommended that the dealer remove the SCR following Step #19 - Step #22 and sublet the repair.

7. Disconnect both positive and negative terminals from both batteries.
8. Disconnect the urea supply line by pinching the white tabs together and pulling connector off of the urea injector (Fig. 4). Clean and dry any drained urea that may come out of supply line.

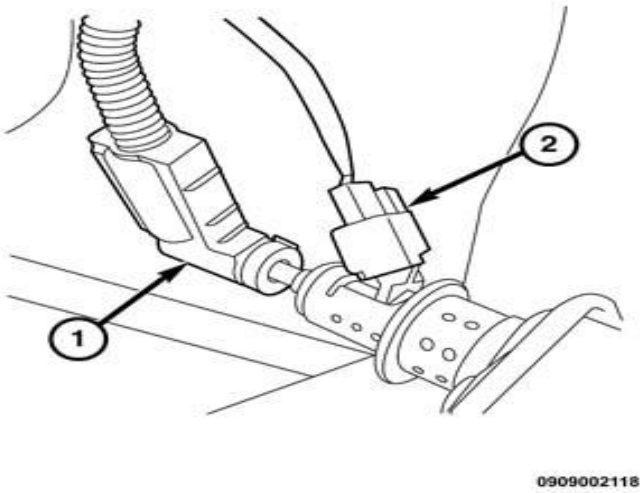

Fig. 4 DEF Injector

1 - DEF Injector Urea Line

2 - DEF Injector Electrical Connector

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9. Remove the rubber isolator connected to the hanger rod to be repaired.
10. Disconnect the electrical harness from the urea injector.
11. Disconnect the electrical harness from all of the sensors (4 sensors total).
12. Using a clean rotary wire-brush, remove any rust and/or debris from the area to be welded and the area where the ground clamp will be attached. Attach the ground clamp to either the hanger rod or the bracket.
13. Add additional flare-groove weld length with GTAW (“TIG” weld) using a 90-degree torch with a stub back-cap adding 409SS wire to reach a minimum required length (60mm (2.36 in.)) on each side of the hanger rod (Fig. 5). The GTAW power supply should be set to a mode with High Frequency (HF) in Start Only: HF shuts off shortly after the arc is established. This gives better protection to electronic system components.

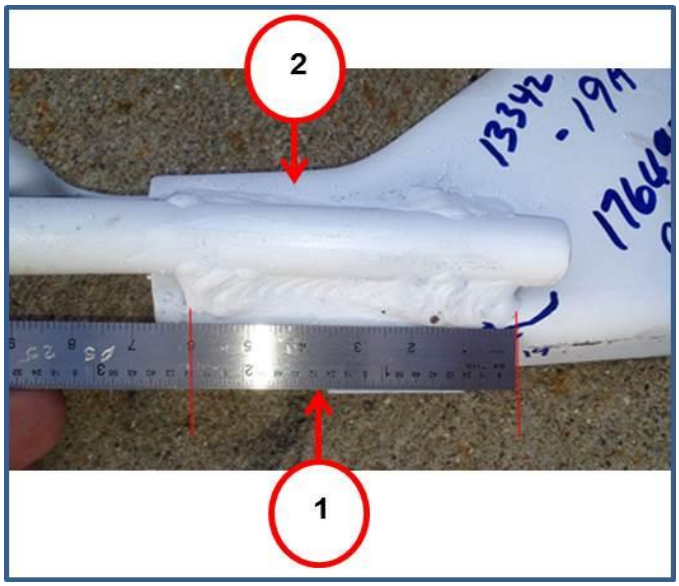

Fig. 5 Reinforce Weld to a Length of 60mm

1 - Increase Weld Length to 60mm (2.36 in.)

2 - Increase Weld Length to 60mm (2.36 in.)

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14. Remove the welding ground clamp.
15. Reconnect the rubber isolator onto the hanger (verify that the hanger rod is cool as to not damage the rubber).
16. Connect the urea supply line and electrical harness to urea injector.
17. Connect the electrical harness for all sensors (4 sensors total).
18. Reconnect both batteries.

NOTE: The following steps will need to be performed only if the bracket welding procedure will be sublet.

19. Remove the SCR Catalyst. Refer to DealerCONNECT>Service>TechCONNECT>Service Info>11 - Exhaust System>CATALYST, Selective Catalytic Reduction (SCR)>Removal>REMOVAL for additional information.

NOTE: Have the sublet welding facility follow Step #20 and Step #21 to add the required weld length.

20. Using a clean rotary wire-brush, remove any rust and/or debris from the area to be welded and the area where the ground clamp will be attached. Attach the ground clamp to either the hanger rod or the bracket.
21. Add additional flare-groove weld length with GTAW (“TIG” weld) using a 90-degree torch with a stub back-cap adding 409SS wire to reach a minimum required length (60mm (2.36 in.)) on each side of the hanger rod (Fig. 6). The GTAW power supply should be set to a mode with High Frequency (HF) in Start Only: HF shuts off shortly after the arc is established. This gives better protection to electronic system components.

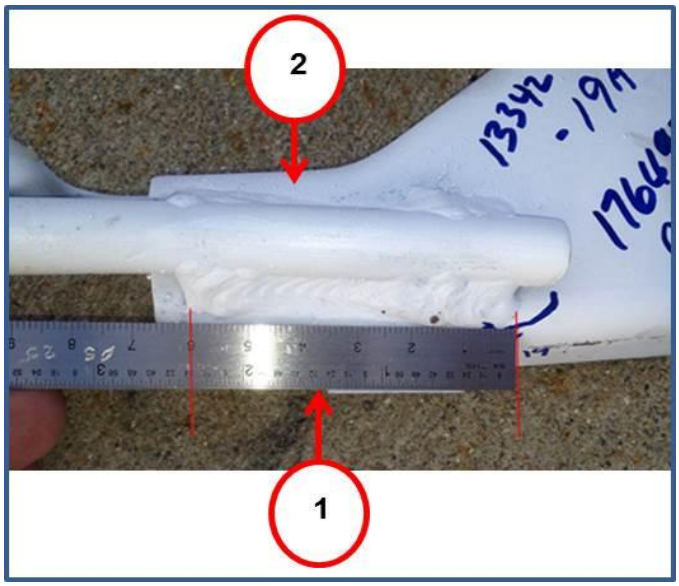

Fig. 6 Reinforce Weld to a Length of 60mm

1 - Increase Weld Length to 60mm (2.36 in.)

2 - Increase Weld Length to 60mm (2.36 in.)

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22. Install the SCR Catalyst. Refer to DealerCONNECT>Service>TechCONNECT>Service Info>11 - Exhaust System>CATALYST, Selective Catalytic Reduction (SCR)>Installation>INSTALLATION for additional information.

POLICY:
Reimbursable within the provisions of the warranty.

TIME ALLOWANCE:

Labor Operation No:	Description	Skill Category	Amount
11-50-01-9C	Support / bracket, exhaust system - Inspect Only (2 - Skilled)	10 - Diesel	0.2 Hrs.
11-50-01-9D	Support / bracket, exhaust system - Inspect and Weld (2 - Skilled)	10 - Diesel	0.7 Hrs.
11-50-01-9E	Support / bracket, exhaust system - Inspect and Remove for Sublet Weld Repair (2 - Skilled) -Sublet Repair $50.00 maximum	10 - Diesel	1.1 Hrs.

FAILURE CODE:

ZZ	Service Action