

Slide Box Weld Repair

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Subject: Repair of SAF-Holland Ultra-Lite and Dura-system mechanical slide box with small cracks at cross member to side sill attachment weld end.

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SAF has determined that the cracks typical to those seen in this document are not structural in nature and are not likely to cause a failure. However, there is a possibility that these cracks will propagate across the entire cross-member. In our experience, we have never seen a crack in this area result in a failure where the slide box actually breaks into two pieces. If this were to happen, this would result in a structural failure and it would be addressed under our standard warranty coverage for this suspension system.

If cracks are found please refer to the following instructions to address cracks at the cross member welds:

- Remove slide pad.
 - Clean area to determine crack size and location.
 - If crack is less than 1.5" in length the following repair can be performed (Fig 1).
 - Grind weld material and crack until crack is no longer visible.
 - Fill in removed material with weld (see weld instructions below).
 - Grind top of finished weld to be flush with side sill of slide box.
 - Re-attach slide pad.
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- If any crack is more than 1.5" in length replace slide box.
 - If cracks reappear in a repaired area replace the box.

Fig 1



Fig 2



Fig 3



Welding Standards

Scope

This specification applies to all components supplied by SAF-HOLLAND®, and its products. The customer assumes full responsibility for weld integrity if weld material and procedures differ from those listed below.

Workmanship

All welding on SAF-HOLLAND® products MUST be performed by a welder qualified according to the appropriate AWS standard for the weld being made or an equivalent standard. It is the responsibility of the customer to provide good workmanship when welding on SAF-HOLLAND® products.

Material

Items to be welded are made from low carbon or high-strength alloy steel are to be welded with AWS filler metal specification AWS A5.18, filler metal classification ER-70S-3, ER-70S-6 or equivalent.

NOTE: Any substitution for filler material from the above standard must comply, as a minimum, with the following mechanical properties:

Tensile Strength - 72k psi (496 MPa)

Yield Strength - 60k psi (414 MPa)

% Elongation - 22%

The recommended welding gas for gas metal arc welding (GMAW) is 90% Argon / 10% CO₂. If a different gas is used, welds must comply with penetration requirements (Figure below).

Procedures

DO NOT break arc at the end of the weld. Back up all finish welds at least 1/2" (12.7 mm) or a sufficient amount to prevent craters at the end of the weld.

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Weld Size

If weld size is not specified, the effective throat of the weld must be no smaller than the thinnest material being welded (Figure below).

