



PRODUCT ADVISORY

2017-04

MODEL(S): Front Discharge Mixer Truck

SUBJECT: Procedure for Repairing Barrel Cracks

Procedures for Repairing Concrete Barrel Cracks

Use the following instructions to repair cracks in the outer skin of the concrete mixing barrel. This procedure is specifically intended to repair the fracture and not to reinforce the area around the fracture. The added heat of reinforcement through multiple pass welds could result in change to the mechanical properties of the base material and lead to further fracture at a later time.

--WARNING--

**READ, UNDERSTAND, AND HEED ALL SAFETY INFORMATION FOUND
IN THE OPERATOR'S MANUAL.**

1. Before repair, move the machine to a level surface, engage the parking brake, and stop the engine.
2. Chock the wheels.
3. Disconnect both terminals to the batteries before performing any welding.
4. Disconnect ECM (Electronic Control Module). The ECM connector is located on the engine.
5. Disconnect TCM (Transmission Control Module) or electronic control modules if so equipped.
6. If the engine is a MTU, disconnect the ACM (Aftertreatment Control Module)
7. Pressure wash the area surrounding the fracture
8. Remove any paint within 2" of the fracture. Use a soft pad grinder or sander (Figure 2.)
9. Using a grinder or similar means, notch the barrel skin surface along the line of the fracture. The material should be removed to a depth of approximately 2/3 of the barrel skin (1/8") deep. (Figure 1.)

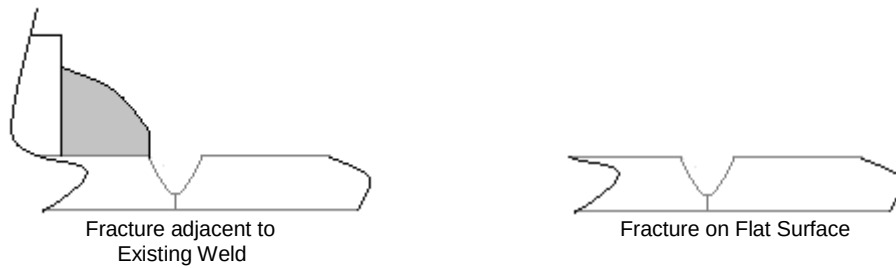


Figure 1.

**-CAUTION -
ALWAYS WEAR PROPER PERSONAL PROTECTIVE EQUIPMENT
APPROPRIATE FOR THE PRESCRIBED ACTIVITY**

10. Clean all debris from the fracture area and examine closely to assure the fracture does not propagate beyond the prepared area
11. At each end of the fracture, drill a 1/8" diameter hole through the barrel skin material.

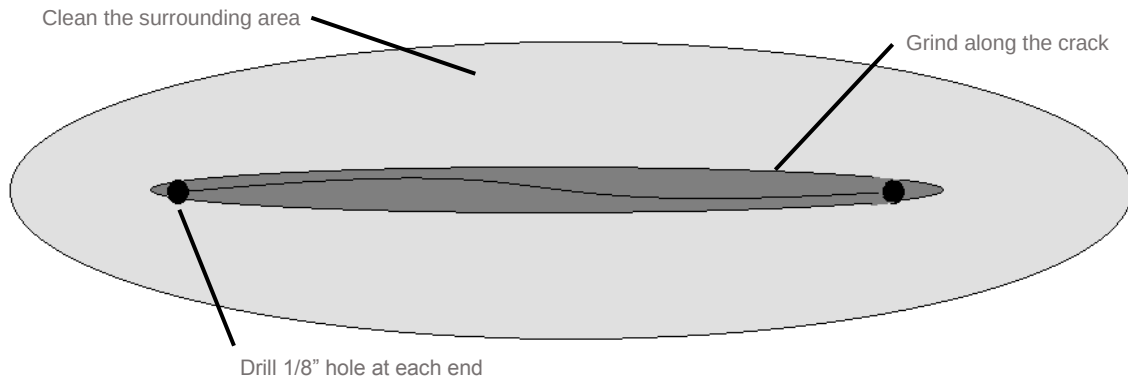


Figure 2.

12. Clean all debris from the prepared area and examine closely to assure the fracture does not propagate beyond the drilled holes
13. Preheat the fracture area with a torch until the material around the fracture begins to darken
14. Use ER70S-6 MIG Wire or 7018 stick rod (or brand equivalent) when performing this weld.

Note: MIG wire machine welders not recommended due to minimal tolerance for contamination that may be present in a field repair situation. If a MIG wire machine is the only solution, use the aforementioned wire and pay close attention to cleanliness preparation of the area.

15. Weld the area in a single pass, with a 3/16" butt weld. (Figure 3.)



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Figure 3.

16. Inspect finished weld for porosity, smoothness, and quality.

Note: If porosity is evident in the weld, remove the weld and begin the process again. Do not attempt to repair the weld using multiple passes to cover a porous weld.

17. Repaint the repair area to protect against corrosion

This concludes the procedure. If you have questions, please contact a TEREX at 260.497.0728 and ask for a Field Service Representative.

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