Welding, Application and Usage Instructions for weld-on hooks

IMPORTANT SAFETY INFORMATION – READ, UNDERSTAND AND FOLLOW

Assembly Instruction:

- When welding the hook to carbon or low alloy steels <40% carbon, use the following recommendations
- Before welding, the welding surface (hook and support structure) must be clean and free of rust, grease, paint, lubricants, etc.
- Fillet size should be minimum size corresponding with WLL of hook as shown in the following table
- The support structure that the hook is attached to must be of suitable size to allow for proper attachment and to support anticipated loads

Welding Instruction:

- Welding is to be performed by qualified welder using procedures in accordance with American Welding Society (AWS) and/or ASME
- Welding electrodes to be in accordance with AWS A5.4 E-312-16 or table below

NFA 81-343 E-29-R26	**ISO 358** E-29-R26
AWS (5.4) E 312-16	**DIN 8556** E 30-09R26
DIN 8556 W Nr. 1.4337	

- Do not rapidly cool the weld
- Before painting, carefully examine the weld. If necessary, use a suitable NDE method, such as dye penetrant or Mag Particle to verify

Minimum thickness: bearing surface and welding seam (fillet)

WLL ton	Part#	Bearing Surface (in.)	Welding Seam (in.)
1.0	WBH01C	3/16	3/16
2.0	WBH02C	1/4	1/4
3.0	WBH03C	5/16	5/16
5.0	WBH05C	3/8	3/8
8.0	WBH08C	1/2	1/2
10.0	WBH10C	1/2	1/2
16.0	WBH16C	5/8	5/8
20.0	WBH20C	5/8	5/8

Before Use:

- A visual periodic inspection of the weld shall be performed on the weld, use NDE method if necessary
- Ensure there are no cracks, nicks, excessive wear, gouges or deformation
- Load should be centered in the base of the hook, along the main axis, parallel to the support surface
- Hook must always support the load, never by the latch. Never tip load or side load.
- Never apply more force than the hooks' assigned WLL
- See ANSI/ASME B30.10 "hooks" for more information

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