



Technical Bulletin

F-Series Paper Roll Clamp Short Arm Wear Tiles

This sheet describes the procedures to install hard surface wear tiles to the short arm tip castings. Kit part no. 206588 includes 4 wear tiles.



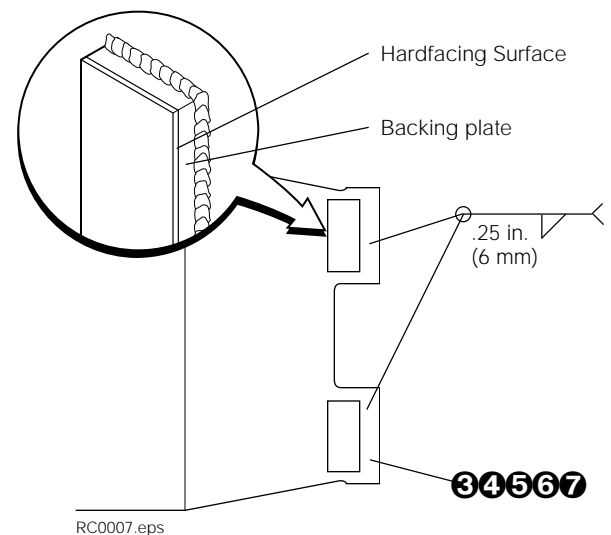
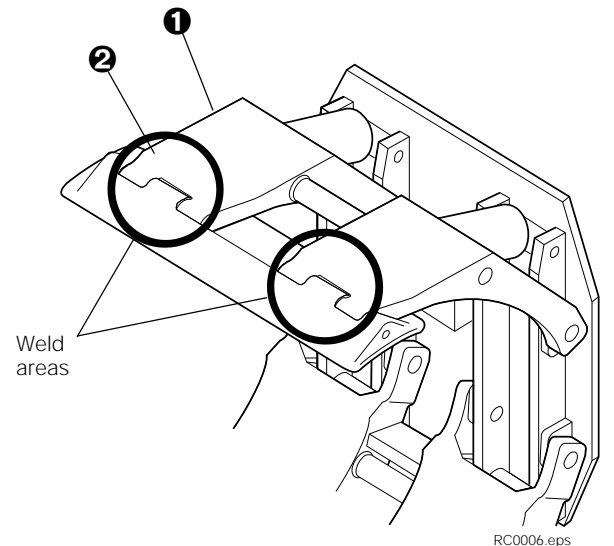
WARNING: Welding must be performed by a qualified welder familiar with this type of fabrication. Always weld in a well ventilated area. Protect yourself and others from arc rays, fumes and gases.

- 1 Rotate the clamp to the horizontal roll handling position with the short arm upward. Lower the clamp to the ground.
- 2 Clean the arm tip casting surfaces to be welded. Remove paint, rust, grease, scale and other contaminants.
- 3 Locate the wear tiles on the arm tip casting as shown. Clamp in place with a "C" clamp.
- 4 Preheat the weld area to 100° F (38° C) before welding.
- 5 Weld the wear tile backing plate to the arm tip casting using one of the following weld methods:

WELD METHOD A – Attach the ground wire to the short arm. Weld using FCAW (Flux Core Arc Weld) AWS E70T-1 1/16 in. (1.5 mm) diameter wire with 100% CO₂ shielding gas at 35–50 CFH. Use DC+ polarity set at 26–30 volts and 260–325 amps. Apply the fillet holding a close arc. Do not oscillate or use a wash bead pattern. Let the welds slow cool.

WELD METHOD B – Attach the ground wire to the short arm. Weld using SMAW (Shielded metal arc welding) E-7018 low hydrogen 1/8 in. (3 mm) electrodes. Use DC+ polarity or a AC welding machine set at 130–325 amps. **Do not use electrodes exposed to moisture without first re-drying them at 200° F (75° C) for 2 hours.** Apply the fillet holding a close arc. Do not oscillate or use a wash bead pattern. Let the welds slow cool.

- 6 Remove slag and inspect the welds. The following defects are not allowed: undercut, overlap, stress cracks and porosity.
- 7 Clean the weld area and repaint.



NOTE: This information should not be interpreted as the basis for warranty claims unless so designated.
Part No. 206587

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