

FORGED WELD-ON SHOULDER WELDING RECOMMENDATIONS

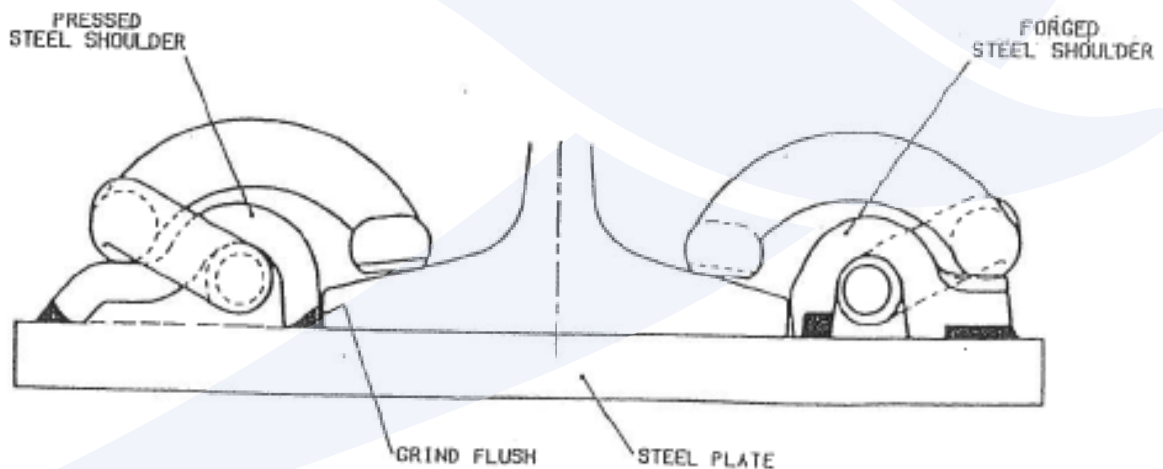
The following are basic recommendations for welding the Pandrol brand forged shoulder.

The welds on the front of the shoulder at the predetermined indents should fill the gaps, approximately 1/4", but not overflow into the clip housing. The welds along both sides of the shoulder should begin 1/4" behind the back edge of the clip housing and continue to the back edge. The welds on the back of the shoulder extend a minimum of 1" from each outer edge, to a maximum of the entire width of the shoulder. All of the welds should be a 3/8" fillet welds minimum and provide adequate penetration into both parts.

PRESSED STEEL WELD-ON SHOULDER WELDING RECOMMENDATIONS

The following are basic recommendations for welding the Pandrol brand pressed steel weld-on shoulder (WOS).

Both of the welds should be 3/8" fillet welds minimum, and provide adequate penetration into both parts. The weld on the front of the WOS should be ground flush so that it does not protrude into the rail seat area. Care should be taken not to undercut the front or rear chamfer as this will effect the toe load of the clip.



NOTE,
ALL WELDS 3/8" FILLET MINIMUM

