NOTES:

1. ALL WELDS SHALL USE LOW HYDROGEN FILLER ROD 7018 OR EQUIVALENT.
2. ALL WELDS SHOULD BE 3/8" FILLET MINIMUM, AND PROVIDE ADEQUATE PENETRATION INTO THE SHOULDER AND PLATE.
3. WELD MUST NOT INTERFERE WITH EITHER RAIL OR PANDROL CLIP.
4. RAIL SEATS SHALL BE FREE OF EXCESS WELD, SLAG, AND SPATTER.
5. SHOULDER SHALL BE FALLENG TO BE SELDOM DURING FINE WELDING TO PREVENT THE SHOULDER FROM RISING DURING FINAL WELDING.
6. PRE-HEAT 2799 FORGED SHOULDER TO 300ºF BEFORE WELDING.
NOTES:
1. ALL WELDS SHALL USE LOW HYDROGEN FILLER ROD TO 1B OR EQUIVALENT.
2. ALL WELDS SHOULD BE 3/8" FILLER WELDS MINIMUM, AND PROVIDE ADEQUATE PENETRATION INTO BOTH SHOULDER AND PLATE.
3. WELD MUST NOT INTERFERENCE WITH EITHER RAIL, PANDROL CLIPS OR RAIL PAD.
4. RAIL SEATS SHALL BE FREE OF EXCESS WELD, SLAG AND SPLATTER.
5. SHOULDERS SHALL BE TACKED OR CLAMPED DOWN PRIOR TO FINAL WELDING TO PREVENT THE SHOULDER FROM RISING DURING FINAL WELDING.
6. 6.33+0.06/0.02 FOR 7-1/2" RAILS
   6.23+0.06/0.02 FOR 6" RAILS

SCALE 3:1

3/8".


3/8".

THE WELD ON THE FRONT OF THE SHOULDER AT THE BEVEL SHOULD BE FILLED, BUT NOT OVERFLOW INTO RAIL SEAT AREA, GROUND FACE OF WELD IN RAIL SEAT TO BE FLUSH WITH SURFACE OF SHOULDERS. ALSO GRIND WELD ON CONCOURS OF SHOULDERS TO PERMIT FULL SURFACE BEARING FOR RAIL PAD. CARE IN GRINDING MUST BE EXERCISED TO PREVENT ANY NOTCHING OF THE WELD OR SHOULDER.
NOTES:

1. ALL WELDS SHALL USE LOX H2O2 OR ALUMINA FILLER ROD 7018 OR EQUIVALENT.

2. ALL WELDS SHALL BE 3/8" FILLET WELDS MINIMUM, AND PROVIDE ADEQUATE PENETRATION INTO BOTH SHOULDER AND PLATE.

3. WELD MUST NOT INTERFERE WITH EITHER RAIL, SAFELOK CLIP OR RAIL PAD.

4. RAIL SEATS SHALL BE FREE OF EXCESS WELD, SLAG AND SPLATTER.

5. SHOULders SHALL BE TACKED OR CLAMPED DOWN PRIOR TO FINAL WELDING TO PREVENT THE SHOULDER FROM RISING DURING FINAL WELDING.

6. PRE-HEAT SHOULders TO 300° BEFORE WELDING.

SCALE 3/4

SAFELOK BRAND CAST STEEL (INSULATED)
WELD-ON SHOULder

CAST STEEL (INSULATED)
WELD-ON SHOULder

TYP 38620

6.4950 in for 6" RAIL BASE
6.1820 in for 5 1/2" RAIL BASE

THE MELD ALONG SIDE OF THE SHOULDER EXTENDS THE Entire LENGTH OF THE SHOULder UP TO DImENSION SHOWN

TO MIN

THE MELD ON THE INSIDE FRONT FACE OF SHOULder EXTENDS THE Entire WIDTH OF FACE

NO WELD BEYOND THESE LINES