

## Rear Hinge Repair

This document details the proper steps to perform a welding repair for any cracks, separations, or other weld issues found during the daily inspection of the rear hinge assembly detailed in Technical Bulletin 001.

### Safety Precautions:

- Body should be fully lowered and secured onto the chassis frame prior to performing any repair work.
- Prior to any welding, all batteries must be disconnected from the chassis and/or a surge protector must be installed.
- Failure to follow these instructions could lead to damage to the work truck, or serious injury, or death to personnel. Follow all safety and maintenance instructions provided with your dump body in the operator's manual.

### Supplies Needed:

- Required and appropriate personal protective equipment
- Certified Welder
- Electrode \ Wire – er-70S-6Cu or equivalent. (Spec. AWS A5.18 er-70S-6).
- Shielding Gas – UN1956 (95% Argon – 5% Oxygen).
- Acetylene torch with wash-out tip.
- 4-1/2" Grinder with grinding disc and wire wheel\cup brush.
- Die grinder and carbide bits (If compressed air is available).
- Brake cleaner.
- Welding blanket.
- Rubber mat (mud flap)
- "C" Clamps
- Surge protectors

### Process:

#### Removing old weld bead.

- Position weld blankets \ mats to prevent damage to the body-chassis and components mounted in the rear hinge area.
- Using an acetylene torch with a "Wash Out tip". Remove the old weld down to the base metal of the bushing, block and the angle iron base.
- Using a 4-1/2" grinder or a die grinder remove all slag, paint, grease etc.

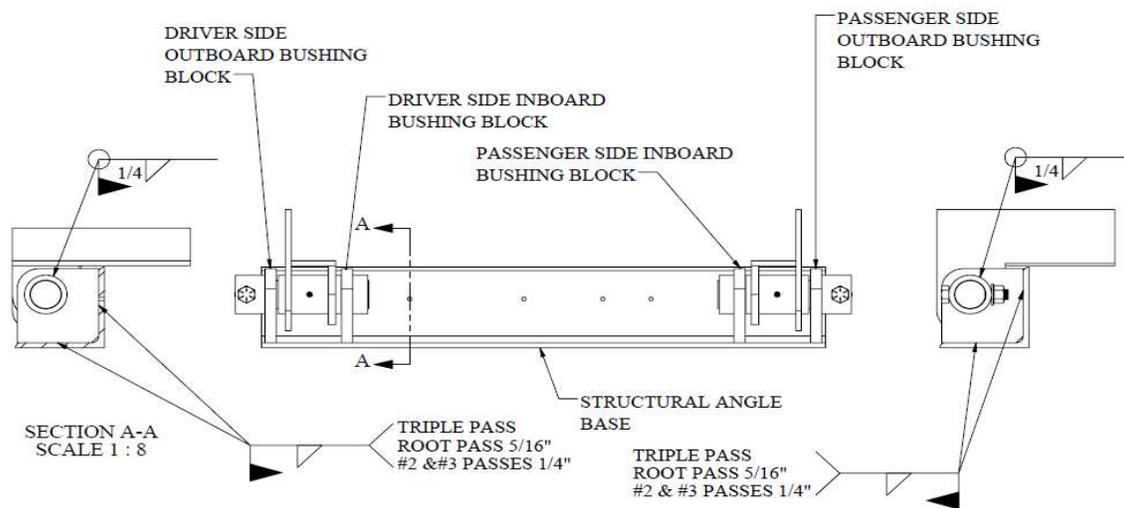
#### RE-Weld Procedure:

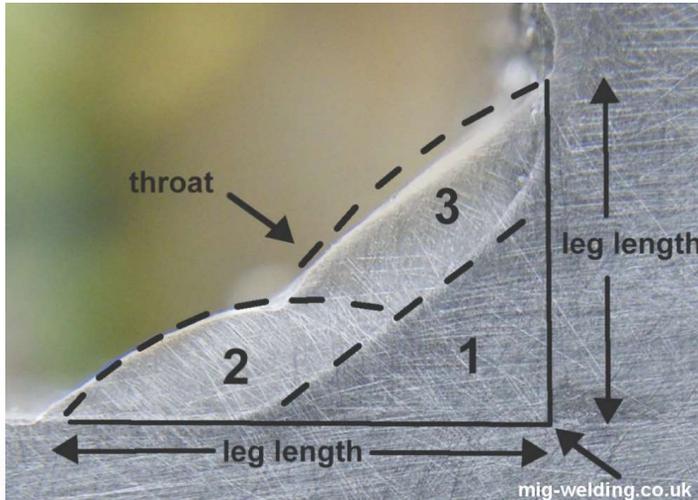
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- Triple pass weld both horizontally and vertically the bushing blocks to the angle iron base. The root pass should have a 5/16" throat. The 2<sup>nd</sup> and 3<sup>rd</sup> passes should be 1/4".
- Follow the same procedure on the bushings welded to the bushing blocks with the exception of single pass weld bead.
- Porosity limits shall be as noted in the chart below.
- All welds should have smooth transitions and proper fusion\penetration.
- See drawing below for detailed weld specifications.

VIEW FROM BEHIND THE BODY





Porosity shall not exceed
.75" total in any 12" of weld
.69" total in any 11" of weld
.63" total in any 10" of weld
.56" total in any 9" of weld
.5" total in any 8" of weld
.44" total in any 7" of weld
.38" total in any 6" of weld
.31" total in any 5" of weld
.25" total in any 4" of weld
.19" total in any 3" of weld
.13" total in any 2" of weld
.06" total in any 1" of weld

**After repair:**

- When welds have cooled, paint black using aerosol cans.
- Please see Technical Bulletin 001 for instructions on how to perform the required daily inspection prior to operations.

