

Welding Instructions Long Reach Forks

Pre-Heating:

1. Preheat fork to 400° F. using a soft flame.
Do Not leave unattended. **Do Not** Exceed 500° F.
2. Use a 400° F. tempil stick frequently on the heated surface until it melts.

Welding:

1. Use Standard welding procedures using low hydrogen filler wire (7018 or equivalent).

Post-Heating:

1. Wrap welds with insulation to slow cooling to approximately 8 hours.

NOTE: MAGNAFLUX ALL WELDS.