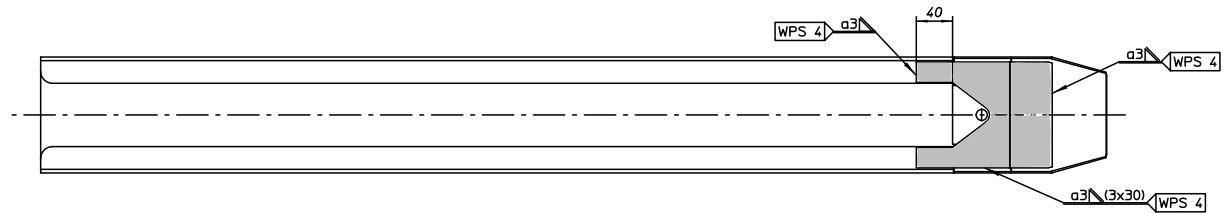


**Appendix KOOI-REACHFORKS welding instructions REE2-17 REE2-24 outer forks**

Technical drawing for partial wear plates:



Technical drawing for full wear plates:

**In case of a full wear plate: the plates cannot be replaced. Please replace the entire outer fork. See your manual for the parts list.**



Lasspecificaties t.b.v. klanten / Welding specifications for customer

WPS 4

| Algemene lasgegevens / General weld data                      |                             |   |                      |  |                     |                             |  |
|---|-----------------------------|---|----------------------|--|---------------------|-----------------------------|--|
| lassen slijstrip steunen                                      |                             |   |                      |  |                     |                             |  |
| Plaats / Location   | St. Jacobiparochie          |   |                      | Laspositie / Welding position  | PB                  |                             |  |
| pWPS-nr. van de fabrikant / pWPS-no. manufacturer             | 4                           |   |                      | Materiaaldikte / Material thickness  | 4 aan 50mm          |                             |  |
| Fabrikant / Manufacturer                                      | Meijer Special Equipment    |   |                      | <b>Proeflas gelast in het bijzijn van / Test weld welded in presence of :</b><br>Keurmeester of keuringsinstantie / Approved by RWA van den Berg IWE |                     |                             |  |
| Soort materiaalovergang / Type material transition            | S420MC - SAE15B35H (2-3)    |   |                      |  |                     |                             |  |
| Soort lasverbinding, lasnaadvorm / Type of weld               | Hoeklas / Corner weld a=5mm |   |                      |  |                     |                             |  |
| Lasnaadvoorbereiding / Welding preparation                    | Borstelen / Brushing        |   |                      |  |                     |                             |  |
| Vormgeving van de lasverbinding / Shape of weld               |                             |   |                      | Lasvolgorde / Welding order  |                     |                             |  |
|   |                             |   |                      |  |                     |                             |  |
| Lasgegevens / Weld data                                       |                             |   |                      |  |                     |                             |  |
| Laag / Layer  | Las proces / Weld process   | Middel. Toevm. / Diameter welding consumables | Stroom / Current (A) | Stroomsoort / Type current   | Voorloopsn. / Speed | warmte inb. / Heat transfer | Metaal overgang / Metal transition     |
| 1   | MAGW 135                    | 1mm   | 250                  | DC+  | 160mm/min           | 2KJ/mm                      | S420MC (30) - SAE15B35H (20) - (2 - 3) |
| Toevoegmateriaalaanduiding / Welding consumables designation  |                             |   |                      | EN 440: G3Si1  |                     |                             |  |
| Beschermgas / Protection gas:                                 |                             |   |                      | 80% Arg 20% CO2  |                     |                             |  |
| Backingsgas / Backings gas:                                   |                             |   |                      | n.v.t. / n/a   |                     |                             |  |
| Gasstroomsnelheid / Flow                                      |                             |   |                      | 15l/min  |                     |                             |  |
| Voorwarmtemperatuur / Pre-heating temperature                 |                             |   |                      | n.v.t. / n/a   |                     |                             |  |
| Tussenlaagtemperatuur / In-between layer temperature          |                             |   |                      | ≤250°C   |                     |                             |  |
| Opwarm- en afkoelnsnelheden / Heating and cooling down speeds |                             |   |                      | laswerk onder normale omstandigheden laten afkoelen / let weld cool down under normal circumstances  |                     |                             |  |

