

GVP 07 Build-Up and Hard-Surfacing

BUILD-UP

Follow the [General Welding Guidelines](#).

Determine the area to build up, using a straight-edge or square. Jaws must not wear lower than the height of a new blade. Use a new blade to help determine build-up height for the jaw.

Build up the jaw to slightly higher than the original parent material profile with E7018. Apply single passes in each line with the grain of the steel, peening after each pass.

Protection strips, or raised areas under or around blade seats, must be built up and maintained during build-up procedure using E7018 or equivalent.

These areas should be maintained between blade height and 0.010 inch lower than blade height. These areas protect the bottom unused edges of the blades as well as reduce the chance for material to catch on the bottom of the blade during jaw open functions, which causes blades to move in their seats.

Denting, deformation or build-up higher than blades in these areas may cause upper jaw deflection, excessive blade gaps, wear to blade faces and undue stress to upper and lower jaws.

After build-up is complete, grind material to be flush with a new blade.

Note: Closely monitor areas above guide blade bolt countersinks and below front two upper blade bolt countersinks. These are high-wear areas. If allowed to wear too far, parent material starts to fold into the countersinks, and it becomes time-consuming to clean out this area when access is needed for blade rotation and replacement.

HARD-SURFACING PATTERNS

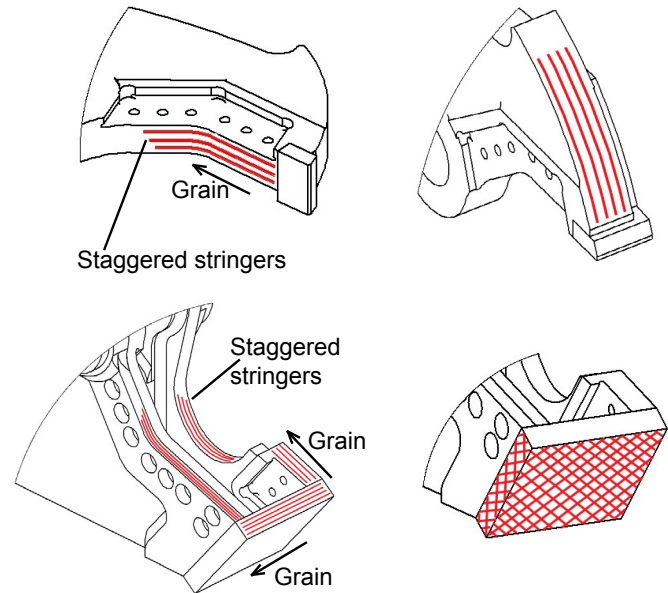
Where parallel lines are shown, apply single passes approximately 3/4 inch apart. Where crosshatch is shown, apply stringer beads at 45° angles to form 3/4 inch squares.

Hard-surfacing patterns are indicated by red lines in the drawings.

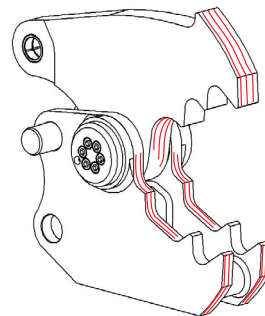
Do not crosshatch the curved areas of the jaws near the pivot. Use only straight stringers on these areas.

Follow the [Hard-Surfacing Instructions](#).

Shear Jaw Set



Cracker Jaw Set



This document is a quick reference only. It does not replace the product safety and operator's manuals, which must be followed by all operators and maintenance personnel.