

## GXT Build-Up and Hard-Surfacing

### BUILD-UP PATTERNS

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.

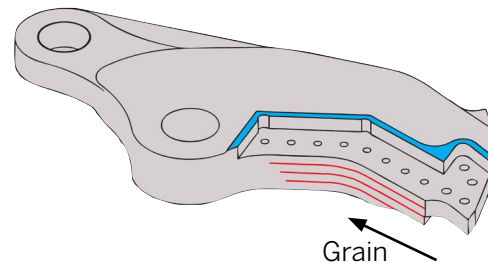
Protection strips, or raised areas under or around blade seats, must be built up and maintained during build-up procedure using E7018 or equivalent.

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.

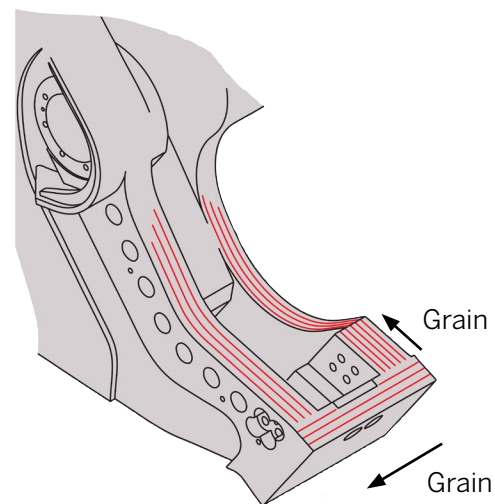
Denting, deformation or build-up higher than blades in these areas may cause upper jaw deflection, excessive blade gaps, wear to blade faces and undue stress to upper and lower jaws.

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.



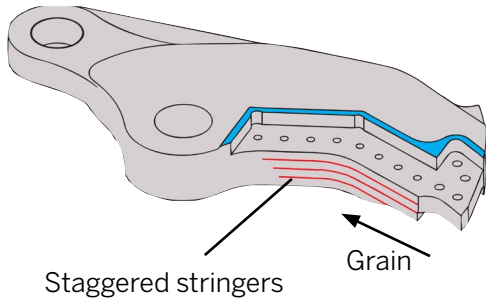
Area highlighted in blue illustrates protection strip.



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.

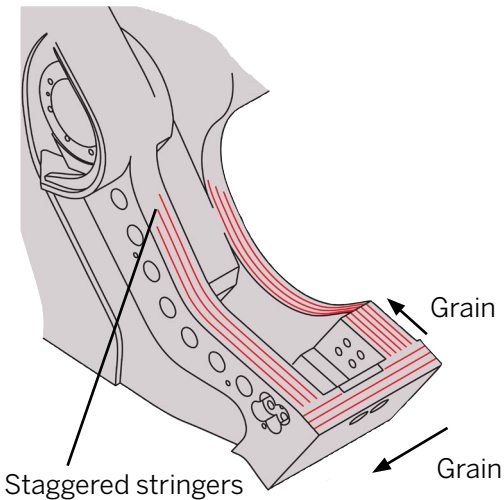
# GXT Build-Up and Hard-Surfacing

## HARD-SURFACING PATTERNS



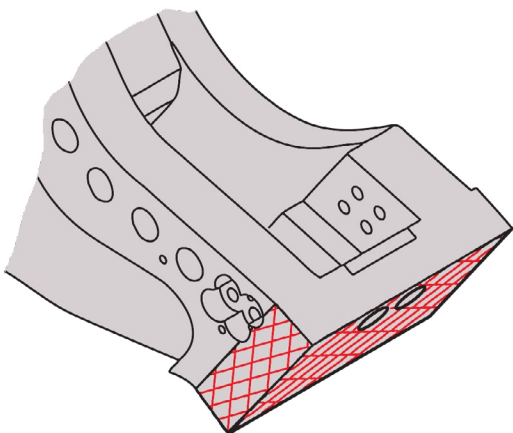
### Upper Jaw

Single passes approximately 1 inch apart. Begin just behind the piercing blade seats and continue toward the throat. Use three to five stringers, depending on the shear model.



### Lower Jaw

Single passes approximately 1 inch apart. Work across the top of the chin plate and along the lower jaw toward the throat. Use two to three stringers, depending on the shear model.



### Lower Jaw Chin

Crosshatch the chin plate with stringer beads at 45° angles to form 1 inch squares.

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