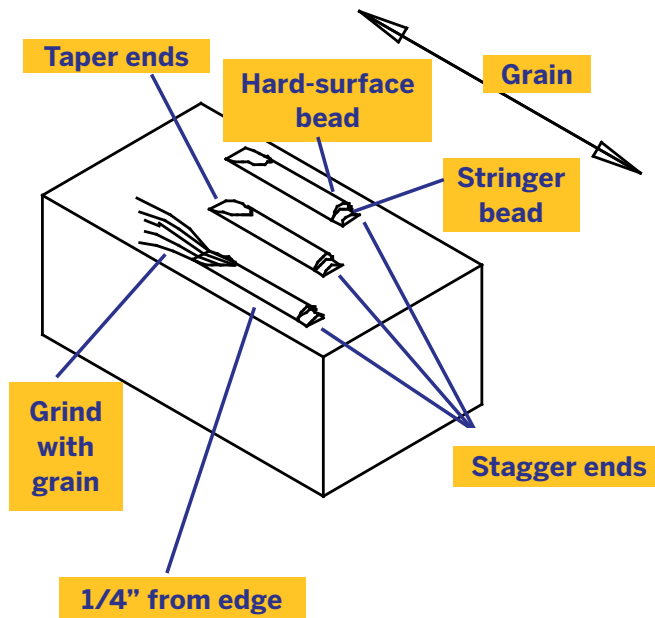


Hard-Surfacing

Do not apply hard-surfacing directly to the parent material as this could cause toe cracking and the hard-surfacing will break away.

Procedure

- Follow the [General Welding Guidelines](#).
- Apply a single pass stringer bead pattern, with the grain, using E7018 electrode. Peen each pass.
- Do not apply a stringer directly on the edge. Start the first pass 1/4" from the edge.
- Stagger the ends of the stringer welds so they do not end in a straight line.
- Cap each stringer bead with one pass of GenWire or GenRod to hard-surface. Do not apply more than two layers of hard-surfacing. Peen each pass.
- Grind the ends of all stringer welds with the grain to taper 1" to 1-1/2" (25 - 38 mm) to the parent material.



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.