



# **USER MANUAL**

## **WELD ON POINT COMPACT**

CODE: 103901, 103902, 103904, 103906, 103909



**1300 100 120**

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Australian Lifting Centre Pty Ltd

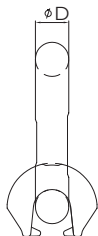
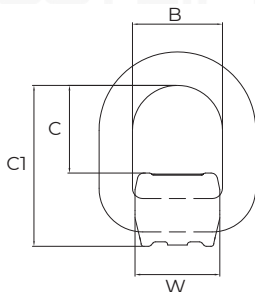
## ■ Weld on Point Compact (Type WPC)

Austlift WPC type weld on lifting points can be welded on any carbon steel surface as a lifting point, or to be used as a fixed anchor point for spreader beam attachment. Can also be used as an anchor point for load restraint applications.

- Marked with chain size, batch number, grade, WLL, Austlift branded with manufacture quality mark.
- Batch tested, test certificates available upon request.
- This document hold the welding instructions.



## ■ Specifications



WLL (T)	CODE	Wt. (kg)	DIMENSIONS (mm)				
			B	C	CI	D	W
1	103901	0.4	40	40.5	70.5	13	37
2	103902	0.48	42	48.5	81.5	14	40
4	103904	0.69	46	49	84	17	42.5
6	103906	1.5	55	57	104.5	22	51
9	103909	2.5	70	67.5	124.5	26	66

## ■ Welding Instructions

### **Warning**

**Under no circumstances should you exceed the work load limit of this product.**

**WLL reduction must be taken into account when using in a cold or hot environment.**

- Do not use these products in an acidic environment.
- Contact your supplier for advice if these products are used in a corrosive environment.
- Do not treat this product with electric or hot dip galvanising at any time.

TEMPERATURE	-40° to 200°C	200° to 300°C	300° to 400°C	Over 400°C
<b>WLL Reduction</b>	None	10%	25%	Do not use

### WARNING

This chart provides the basic information of size of supporting material. The thicker the material, the bigger the plate that can be used. Please contact your nearest distributor for further information.

PRODUCT	Max. WIDTH OF PLATE (mm)	Max. HEIGHT OF PLATE (mm)	Min. THICKNESS OF PLATE (mm)	Min. THICKNESS OF FILLET WELD (mm)
WPC-1-8	800	800	11	7
WPC-2-8	1050	1050	15	8
WPC-4-8	1290	1290	19	10
WPC-6-8	1560	1560	24	15
WPC-9-8	1780	1780	30	18

## General

To properly install and weld an Austlift weld-on lifting point it requires a competent person who has experience in the lifting or load restraint industry and in addition requires a qualified, experienced welder to perform the welding job.

## Positioning

The following precaution should be observed when you are positioning the fitting.

- This product shall be in the correct position to withstand all angles of the load strain.

- Positioned so that it cannot cause any damage to the product or other parts of the equipment to which it is welded.
- The use of this product can not cause any injury to persons operating equipment.
- Cannot cause any unintentional unhooking when in use.
- Placed in a position so that it can be easily hooked and unhooked safely.
- The product does not hinder any operation e.g. lifting or excavation.
- If this product is used for an excavator it should be welded in the middle upper part of the bucket.
- A qualified person shall certify that the product can be taken into service.

## **Welding**

### **1. Material**

Take note of the tensile strength of supporting material to weld to. The following is a guide to determine the correct height, length and thickness to ensure the right strength of support material in mild steel.

### **2. Electrodes**

Any welding of this product should be carried out by a qualified person. Electrodes or wire shall be for use with low alloy or non-alloy steel.

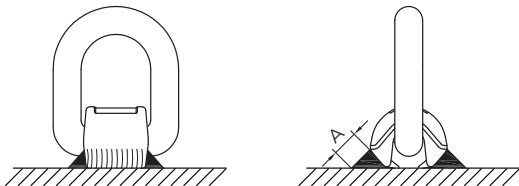
Electrodes must be free from any moisture and wire free from rust before any kind of welding is to be carried out. Recommended welding electrode; AS/NZS 1553 or equivalent.

### 3. Welding

Make sure all areas to be welded are cleaned and free from rust, paint, dirt, etc.

- The surface to be welded should be preheated. Ensure correct welding procedures are adopted in this case.
- First position the lifting point then tack weld all four corners.
- Continuously weld the bottom joint and fill weld all around. Make sure the lifting point is welded to the ends of the bow.
- To reach maximum penetration, ensure that the welding torch or electrode is held at a 45° degree angle.
- It is recommended that you weld the top joint of the lifting point with a larger electrode.
- Ensure that there are no cracks or pores in the welds or welded area.
- Allow the weld to cool at room temperature. Do not use water or a fan to cool the weld.
- All bare and unwelded areas should be painted to avoid rust.
- All moving parts should be well lubricated after welding.
- MIG welding has less penetration than others and it is not recommended for welding G80 components.





Triple weld runs may have to be conducted in order to reach minimum weld fillet area (A).

## **Inspection**

**A qualified person should inspect components regularly to maintain safe operating procedures.**

- Check for bends, nicks, wear, stretching or elongation of the components.
- Check for any signs of corrosion.
- Check for any scoring or cracks on all welds and components.
- Check the latch, rivet and spring. Latch shall be working properly.

### **WARNING**

The components should be taken out of service immediately if it shows any of the above faults.



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