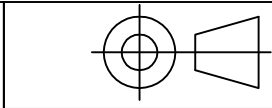


DRAWING LIMITATIONS:
CRACKS IN CHASSIS WEB ONLY
CRACK LENGTH < 30mm



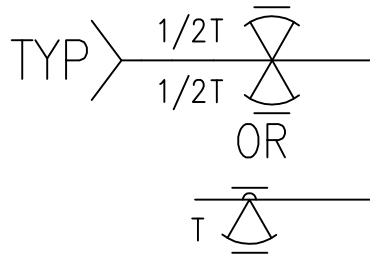
DO NOT SCALE – IF IN DOUBT ASK

ALL DIMENSIONS IN MILLIMETRES
TOLERANCES CLASS II UNLESS
OTHERWISE SPECIFIED
WELD SYMBOLS TO AS1101.3–1987

WELDING OF STEEL SECTIONS TO COMPLY WITH AS/NZS1554
PART 1(CATEGORY SP)

1. –WELDING AND JOINT PREP. TO COMPLY WITH SECTION 4.
–WELDER TO BE CURRENTLY CERTIFIED TO CLAUSE 4.11.2
IN APPROPRIATE POSITIONS AND TECHNIQUES USED.
(ALL POSITIONS AND STEELS UP TO CLASS 3 MIN.)
–WELDING CONSUMABLES TO COMPLY WITH SECTION 4.5
FOR THE TYPE AND GRADE OF MATERIALS USED.
–INSPECTION TO BE CARRIED OUT AS PER SECTION 7.
2. CHASSIS MATERIAL TO BE IDENTIFIED BEFORE REPAIR
ADDITIONAL MATERIAL TO BE EQUIVALENT
3. REMOVE ALL BURRS AND SHARP EDGES, DRESS WELD
TERMINATIONS
4. ENSURE WELDING COMPATIBILITY OF MATERIAL.
THIS REPAIR IS ONLY SUITABLE FOR CHASSIS
MATERIAL UP TO 350 MPa YIELD. CONSULT
AN ENGINEER WITH THE CHASSIS CATEGORY IF
HIGHER YIELD MATERIAL IS USED
5. STEEL PLATE TO MEET AS/NZS 3678 &/OR 3679
OR EQUIVELANT (UNLESS SPECIFIED)

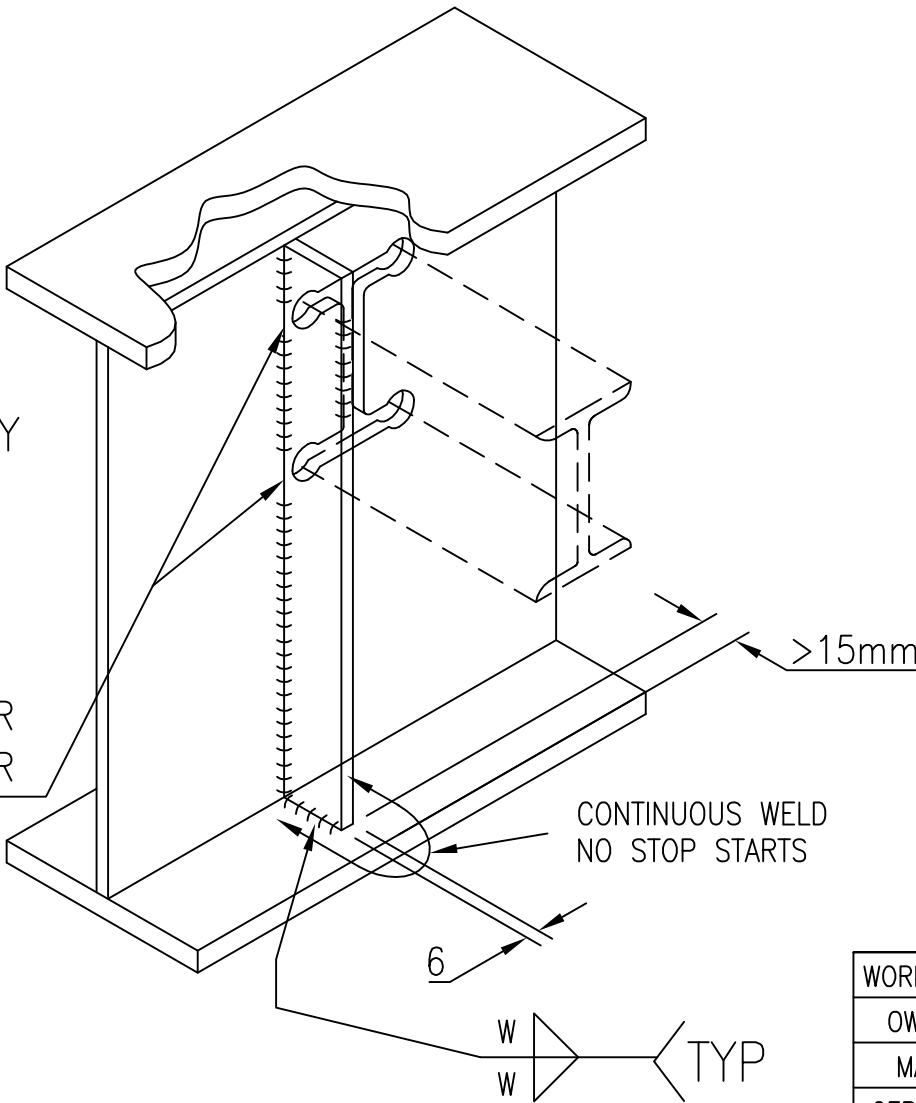
TOE CRACK
GRIND OUT, DRILL $\phi 3\text{mm}$ HOLE
AT END OF CRACK AND RE-WELD



TOE CRACK DETAIL

INSTALL STIFFENER ON ONE SIDE ONLY
 T = THICKNESS OF WEB (mm)
 W = MIN = 4mm
MAX = $1.5 \times T$

DO NOT WELD STIFFENER TO CROSSMEMBER
WELD/BACKFILL WEB CUTOUT BEHIND STIFFENER



REINFORCEMENT DETAIL

WELD SYMBOLS TO AS/NZS 1554.1

SYMBOL	JOINT	TABLE
	B-C2a	E1
	B-C3	E1
	F1	E3

C			
B			
A		FIRST ISSUE TO CLIENT	
ISSUE	DATE	CHANGES MADE	BY

WORKSHOP	
OWNER	
MAKE	MODEL
CERTIFIER	CERT. No.
JOB #	

ttmf
N7 Truck Trailer Manufacturers Federation Inc.

WEB CRACKS AT X-MEMBER CUTOUTS
RSJ CROSSMEMBER AND CUTOUT. MATERIAL YIELD < 350 MPa

4 – MRCP – C003

Sheet:
3/3

Drawn: R.F.

Issue: B

Chkd:

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Job: 12726

Ref: MRCP-C003

Scale: NTS

Date: 2/11/2015

Date: