

From:	Product Management	Date:	28-05-2014
For:	Sales	Ref:	PI-03-03 EN
Article:	EXCEL <sup>®</sup> Excavator Hook, grade 8 (GH)	Revision:	0
Subject:	Instructions for use - EXCEL <sup>®</sup> Excavator Hook, grade 8 (GH)		
Note:	Main dimensions, general info and warnings can be found in our latest catalogue.		



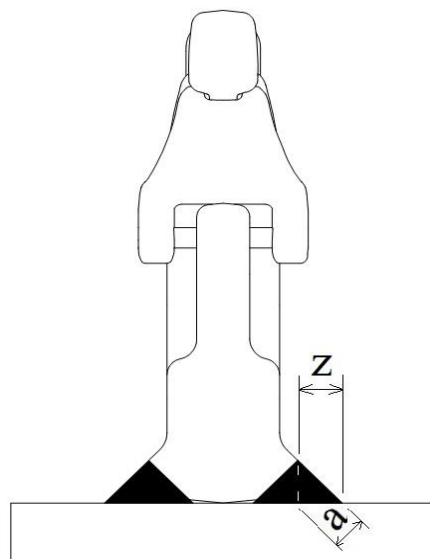
GH

### EXCEL<sup>®</sup> Excavator Hook, grade 8

- Material : alloy steel, grade 8, quenched and tempered
- Safety Factor : MBL equals 4 x WLL

#### 1) Instructions for welding

- The surface on which the Excavator Hook is to be welded (support material) has to be free from rust, paint and degreased prior to welding. It must be flat and must be able to transfer the load.
- The percentage of carbon of the support material must be 0.25-0.40%.
- The welding filler material must be chosen based on the support material to ensure a successful and efficient welding.
- The hook must be positioned that the weld is loaded only in shear. No bending moment can be permitted on weld seam.
- In ambient temperature of 10°C and below, pre-heating of the weld area prior to welding must be carried out.
- The welds must be sufficiently strong to take the required loads.
- A minimum weld-seam width must be maintained to give adequate weld strength (see table)
- Start both, the root pass and final weld pass from the centre of the support to be welded.
- Before starting the final weld pass, clean well the root pass to avoid inclusions.
- The complete welding operation must be carried out continuously so that the parts does not have time to cool.
- Welding must be done in accordance with DIN 5817 resp. 15429, by a qualified welder according to EN 287-1.



Size	Weld size a (mm)	Weld size z (mm)
GH0.75	5	7
GH1	5	7
GH2	7	9
GH3	7	9
GH4	8	11
GH5	9	13
GH8	10	14
GH10	12	16
GH15	14	20

VAN BEEST B.V. Manufacturer and Supplier of wire rope and chain fittings. Reg. trade marks 'Green Pin' and 'Excel'



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- MIG welding :

Electrode : wire diameter 0,8 - 1,2 as per EN 14341.

Important : do not weld in the open air during bad weather.

- Manual electric welding :

Direct current supply welding.

Electrode : root pass and final weld pass, type E5154 B 10 as per EN 2560, used in accordance with the manufacturers recommendations.

- Alternating current supply welding :

Electrode : as per EN 2560, modified for alternating current use.

HV welding and final weld pass, type E5155 B 10, for example Thyssen SH green K52V.

- For information :

The transformer set point voltage must be at least 70V.

## 2) Inspection and Proof Load

- Excavator Hook has to be regularly checked visually. They must be inspected at least annually by an expert.
- A visual inspection is necessary before use.
- Depending on local regulations it is recommendable to proof load the welded hook at 2.5 x WLL before first use and during regular inspections.

## 3) Use limitations

- Never exceed the WLL indicated on the Excavator Hook.
- Do not use a Excavator Hook that is rusted, bent, show any visual damage, or has been immersed in an acidic solution. A visual inspection is necessary before use.
- The Excavator Hook must not be used in contact with basics or acids.
- Please contact us for special use conditions.

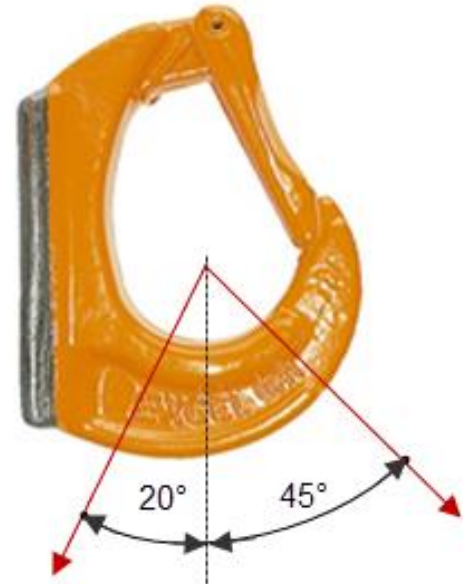
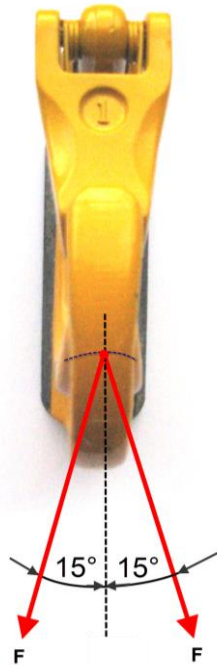
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Side load max.: 15 degrees.

Operation range: max. 45 degrees.



If you have further questions, please do not hesitate to contact us.  
Kind regards,

Van Beest Product Management

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