



## *Lashing Eye Type APA*

### Welding Instructions

1. The welding has to be carried out by a welder examined acc. to DIN EN 287-1.
2. The welding should not be carried out until establishing that the machine where the lashing eye shall be assembled, conform with the provisions of the EC Machinery Directive
3. The surfaces must be clean (no oil, paint, varnish etc.).
3. The weld must be suitable for the application of load. It should take up 2.5 times of the working load limit without permanent deformation and 4 times of the working load limit without breaking.
4. In temperatures under 0° C (32°F) the surface of the weld is to be warmed up slightly.
5. The material of the welding stand is St 52-3, casted and sand blasted. The material of the eye is a high-grade steel acc. to DIN 17115 quenched and tempered. It should not be heated over 400 °C.
6. The regulations acc. to EN 288-1 are in force for the welding.
7. At least a wire electrode acc. to DIN EN 440 eg. G35 2 MG 3 Si is sufficient to MAG-welding. If manual arc welding is carried out, an electrode acc. to EN 499 eg. for example E53 2 B22 H10 is sufficient.
8. **The weld metal (a) must be put in the whole cross-section (see on draft).**

