

General Welding Instructions

Previous surface cleaning should be performed on parts to be welded, removing paint, grease, oxide or other elements. The presence of pollutants containing hydrogen (grease, paint or organic matter) could be the cause of delayed breakages. Cleanig can be performed mechanically using a metallic brush, if this is not enough light grinding can be applied.

Preheating the welding area up to 140-180 °C (280-356 F). We recommend using a gas torch. Prolonging heating, without exceeding limits indicated, until the welding area maintains the indicated temperature.

If for any reason the welding process was stopped and it wasn't possible to maintain temperatures, preheating should be performed again before restarting the process.

During the welding process. Temperatures above 250 °C (482 F) should not be exceeded outside the areas directly affected by welding [Zat]. Passes should be spaced so as to maintain temperature within the preheating and the maximum temperature limits.

Addition Material

Tubular thread (Flux Carel) **should be used with certified low hydrogen content**.

Recommended maximum diameter: 2.4 mm / 0.09 inches. Manufacturer recommendations should be followed.

Tubular thread recommended:

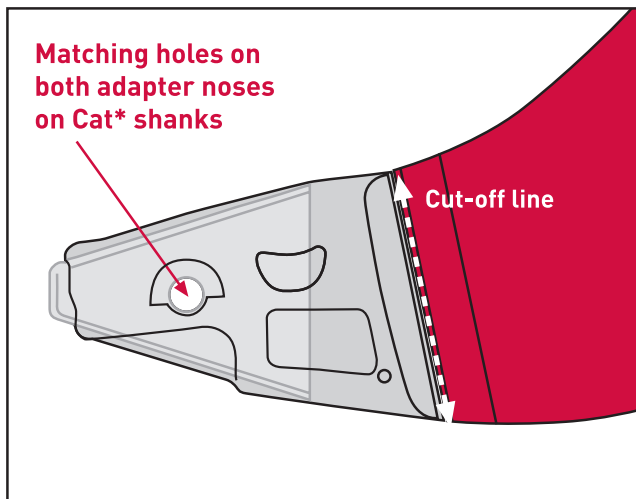
ASME/AWS: E 70 T1 (Rutile type tubular thread)

ASME/AWS: E 70 T5 (Basic tubular thread with high mechanical properties)

DIN: SG B1 C 5254 (DIN 85591 standard)

Gas mixture Ar + 25% CO₂ should be used. You should specify that you can not have any humidity. Minimum recommended flow would be 16.52 l / m

MTG Systems RipMet Assembly and Disassembly Instructions

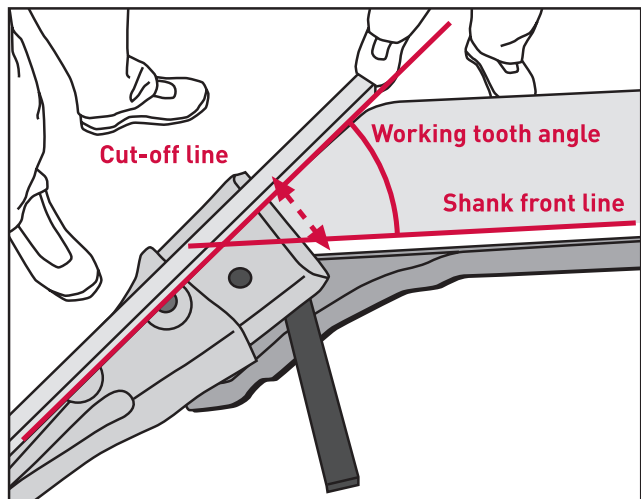


A1. When the original nose/adapter is maintained:

Place the MTG Systems RipMet nose/adapter on the shank in the same original position. Holes will match when replacing a Cat* nose. For other kind of noses and all adapters, follow the original profile.

Draw the resulting cut-off line on the shank.

Preheat the area to be cut up to 180° and cut through the line. Without allowing cooling, perform the welding chamfer similar to that of the MTG Systems RipMet nose/adapter.

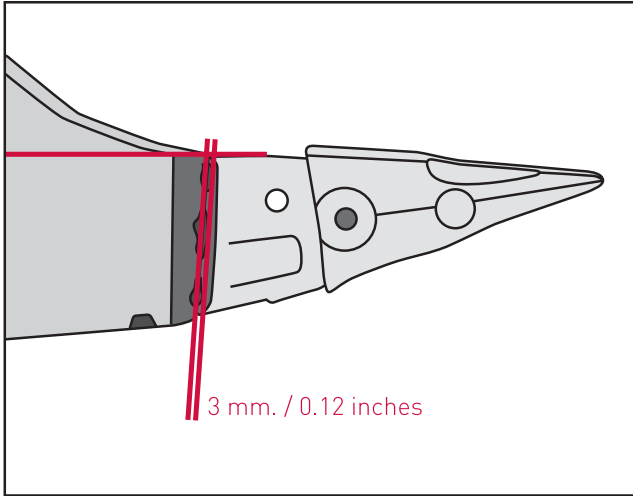


A2. When the original nose/adapter is not maintained:

Place the tooth/nose or tooth/adapter set on the shank, set the desired working angle for the tooth and mark the cutting line. MTG Systems RipMet allows a working tooth angle between 30° and 45°.

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MTG Systems RipMet Assembly Instructions



Place the nose/adaptor with the shank. There must be a distance of 3mm/0.12 inches between the nose/adaptor and the shank. If the welded lengths are a slightly different, the front lines must match.

Cut the nose ring flat.

Assemble the tooth and the shroud on the shank to make sure that the set can be correctly assembled.

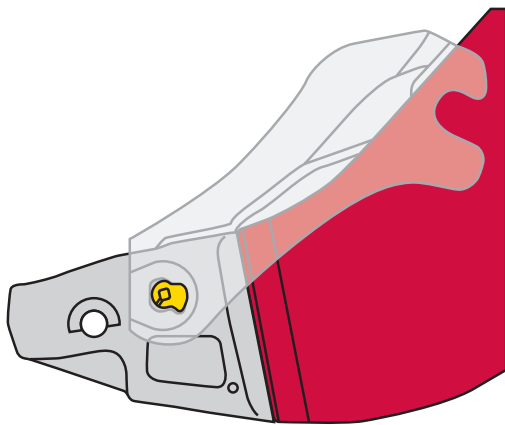


Weld alternatively on both sides to correct deformities. Grinding should be performed longitudinally to the shank using a fine-grained grinding wheel to avoid scratches in the transversal direction of the shank.

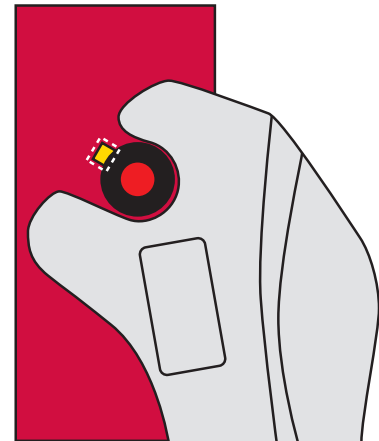
In the end, leave a small welding over-thickness and perform grinding so that we obtain a smooth flat surface (to avoid interference with the adapter!).

Once the process is completed, verify if there are any cracks. If any, clean and re-weld the area.

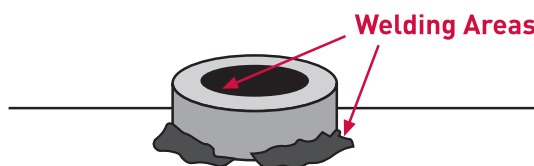
Assembly Instructions for the Adapter Base (when using MTG Systems RipMet noses)



A. Insert the retainer into the nose cavity. Place the shroud, the pin and turn clockwise.



B. Place the shroud base and perform welding points.



C. Disassemble the shroud and finish welding, both on the outside and inside of the base.