WELDING PROCEDURE FOR PLOW FINGERS

1. All welding shall be done with \( \frac{3}{4} \)" diameter low hydrogen SMAW electrodes Type E6011 or E6018.
2. Prior to welding, remove the galvanized coating in the weld area by grinding.
3. Weld pass one in Areas A and B first, then Area C, followed by passes two and three in same order as shown in Detail "B".
4. Remove all weld slag and other residue between passes.
5. Allow at least 5 minutes cooling time between each of the nine welding passes.

GENERAL NOTES

- Do not galvanize PLOW FINGERS.
- Varies with skew and expansion opening.
- Minimum in closed position.
- Every Snow Plow Finger shall have full and direct bearing on the plate that is located under the movement side of the Finger. No clicking noise will be allowed.
- Modify if lane width differs from 12 ft.
- Only last PLOW FINGER on device with curved end.