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ALUMINUM WELDING TYPICAL INSTRUCTIONS
And
ALUMINUM SKIN PATCHING INSTRUCTIONS

Revision Two : July 28, 2014

1. Ensure that all parts to be welded are in good condition and are oil free.
2. Properly align all parts to be welded. Refer to all applicable drawings prior to welding.
3. Welding and fabrication shall be in accordance with Aluminum Association specifications for aluminum – current edition. Welding shall be in accordance with part 7.1 using aluminum filler alloy 5556 with minimum shear strength of 20,000 psi. Minimum 3/8" welds shall be used at all load-bearing connections.
4. All structural aluminum shall be 6061-T6 aluminum.
5. Fillet welds along edges of plates shall be built out to obtain full throat thickness.
6. Use only parts manufactured by or approved by Efficiency Production, Inc.
7. Installation and fabrication shall be in compliance with all applicable Occupational and Health Administration Rules and regulations.
8. Plates used for patching skins must meet or exceed the thickness of the existing skin plates.
9. Each patch must overlap the opening by a minimum of 3" in all directions. Weld thickness shall be a minimum of 3/16" for non-load bearing elements.
10. Efficiency Production, Inc. and its subsidiaries and dba's shall not be held liable or responsible in any way materials and workmanship for repairs performed outside of our facilities.
11. The aforementioned are guidelines only