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STEEL WELDING TYPICAL INSTRUCTIONS

1. Ensure that all parts to be welded are in good condition and rust free.
2. Properly align properly all parts to be welded. Also, see all the applicable drawings related to the job.
3. Fillet welds shall be built out to obtain full throat thickness where applicable. Full length welds for the brackets (minimum 3/8", SMAW) are highly recommended.
4. Gas metal arc welding A.W.S., A5.18, ER70S-X electrodes, Fv-21(ksi.) shall be used or equivalent. Minimum 3/8", SMAW using E70-XX electrodes shall be used in all circumstances.
5. Do not attempt to replace any parts of the assembly with parts not supplied by Efficiency Production, Inc. All Efficiency Production, Inc. parts are: Structural Tubing ASTM - A500 Fy (min.) = 55 ksi; all Structural Steel (skins) are ASTM - A572, Fy (min.) = 60 ksi. except struts, gusset plates end plates, which are ASTM -A36, Fy (min.)=36 ksi and comply fully with AISC – ASD Manual.
6. Installation and site fabrication shall be in compliance with the current and applicable Occupational and Health Administration Rules and Regulations.

Enclosure: (if any)