



Operating and welding instructions for weld-on hook GK 8 (Last update: 26.06.2017)

General principles of use:

Loads falling due to failure and / or incorrect use of lifting devices or their individual parts entails an indirect risk to the body or health of the persons who are in the danger area of lifting operations. This operating manual contains those aspects relating to safe use combined with the good practice for handling the weld-on hooks. Prior to using the weld-on hooks, qualified personnel must instruct the authorized persons. Weld-on hooks may neither be used in acids nor exposed to any acid vapors. Please note that acids or acid vapors are released in certain production processes.

Assembly instructions:

The position of the weld-on hooks on the load must be designed in such a way that there is a flat contact surface, which is appropriate to handle the expected application of force.

The weld-on hooks must be attached to the load in such a way:

that they can be easily reached to attach and remove the hoisting equipment without any problems.

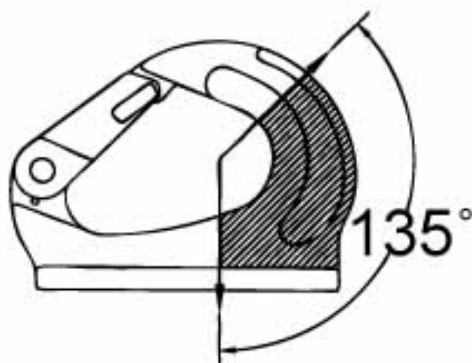
that no hazards (crushing, shear, catch or impact hazards) are created which endanger or impede the slinger or the transport.

that inadmissible stress, e.g. by means of eccentric loads and thus uneven load distribution, taking into account the center of gravity (EN 818-6), are avoided.

that the hoisting equipment is not negatively affected by other components and that damage, e.g. by sharp edges, is excluded.

The number and arrangement must be selected in such a way that the load cannot change its position unpredictably during transport.

The position of the weld-on hook must be such that the slinger is attached in the range of 135 degrees only.



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Maximum load weight "G" for different hoisting types for weld-on hook GK 8

Hoisting type									
Number of ropes/chains	1	1	2	2	2 symmetrical		3; 4 symmetrical		2; 3; 4
angel	0°	90°	0°	90°	0°-45°	45°-60°	0°-45°	45°-60°	asymm.
Load-bearing capability in tons	1,12	1,12	2,24	2,24	1,5	1,12	2,35	1,68	1,12
Load-bearing capability in tons	2	2	4	4	2,8	2	4,2	3	2
Load-bearing capability in tons	3	3	6	6	4,2	3	6,3	4,5	3
Load-bearing capability in tons	5	5	10	10	7	5	10,5	7,5	5
Load-bearing capability in tons	8	8	16	16	11,2	8	16,8	12	8
Load-bearing capability in tons	10	10	20	20	14	10	21	15	10

Welding:

- Welding may be carried out by qualified hand welders only in accordance with DIN EN ISO 9606-1.
- The material of the hook to be welded on is 1.6522.
- At the beginning of the welding process, the plate of the hook is welded. The seam is created, starting from the centre of the plate. A fillet weld must be welded on all the way to the base plate of the weld-on hook.
- Welding should be carried out in temperatures of approx. 20 degrees. Welded seams must be protected against drafts.
- The weld metal is to be inserted into the full cross-section (see height of the base plate)
- Seam transitions must be created without notches.
- Prior to creating the top seam, slag or impurities must be removed.

After the welded seam has been cleaned, a visual inspection of the welded seam with regard to cracks, notches and inclusions must be carried out. In case of doubt, a surface crack test must be carried out.

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Welding procedures + additives for Europe, the USA and Canada for the working materials structural steels, low alloy steels

MAG / MIG	EN ISO 14341 G4Si1 e.g. Castolin 45250	AWS : A 5.18 ER 70 S-6 e.g. Eutectic MIG-Tec Tic A88
E-hand DC	EN499 E 426 B32 H5 e.g. Castolin 6666 or 6666N – observe drying instructions	AWS : A 5.5 E8018-G E7016 e.g. Eutectic 6666/35066 CP
E-hand AC	EN499 E 380 RR 12 e.g. Castolin 35086 CP 6600	AWS : A 5.1 E 6013 e.g. Eutectic Beauty Weld II
WIG	DIN 8575 WSG CrMo1 e.g. Castolin 45252 W	AWS : A 5.18 ER 70 S-6 e.g. Eutectic TIG-Tec-Tic: A 88

LOAD-BEARING CAPACITY IN DIFFERENT TEMPERATURES:

The indicated load-bearing capacity of the weld-on hooks applies to application temperatures from minus 20 to plus 200 degrees Celsius without deduction. When used in other temperature ranges, appropriate tests have to be carried out for the corresponding room operating temperature in advance. The load-bearing capacity must therefore be recalculated.

Inspection and maintenance:

Weld-on hooks must be inspected by an expert after assembly at least once a year. Before use, e.g. by the slinger, weld-on hooks must be examined visually for cracks, deformations and severe corrosion. List of possible inspection criteria:

- Completeness of the weld-on hook including the safety catch
- Observe the load-bearing capacity
- Immediate prohibition of use in case of cracks on the component or the welded seam
- Immediate prohibition of use, if the bracket member is damaged. The current test regulations apply.
- Immediate prohibition of use in case of severe corrosion.

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