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Welding Instructions for Cutting Edges

1. Cut off old blade leaving a re-weld surface that is free and clean of all slag.
2. Grind or cut to a bevel; the blade and re-weld surface; both top and bottom. Clean off all slag.
3. Fit the new blade 1/16" to 1/32" from the re-weld surface.
4. Both the blade and re-weld surfaces should be preheated to a temperature of approximately 400 degrees for an area of four (4) to six (6) inches.
5. Use Grade 7018 low hydrogen or austenitic stainless steel welding rod.
6. Tack weld blade into place on approximately 6" centers.
7. Turn blade to weld bottom first. Stagger the welds approximately 12 inches; weld opposite ends; working toward the center. Weld in fillet weld manner. The process should be repeated on the top side.
8. Peen the weld metal while it is hot to reduce stress and to minimize distortion or warping.
9. The weld area should have normal air cooling.
10. Allow blade and weld to cool to room temperature (approximately 75 degrees) before using.