

GDR Build-Up and Hard-Surfacing

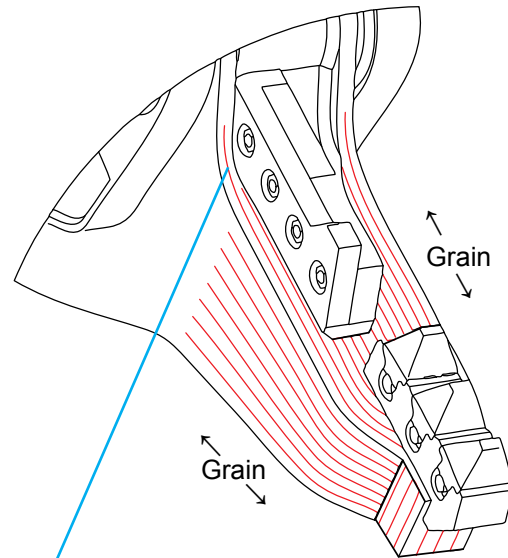
Follow the [General Welding Guidelines](#).

Determine the area to build up, using a straight-edge or square. Do not allow jaws to wear to more than a 3/4 inch radius on edges of tool.

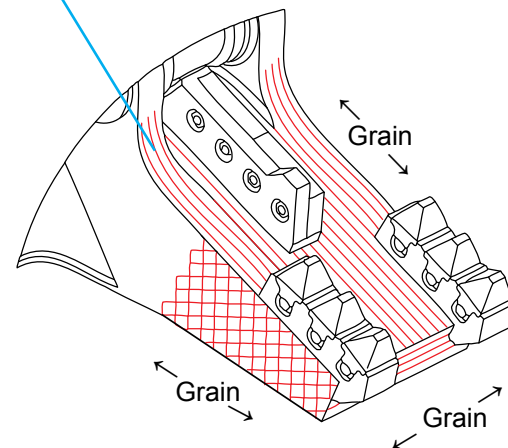
Build up the jaw to slightly higher than the original parent material profile with E7018. Apply single passes in each line with the grain of the steel, peening after each pass.

See drawings for grain, as indicated by arrows. (Red lines indicate hard-surfacing pattern.)

After build-up is complete, grind material to be flush with the flat surfaces of the tool or, if building up a blade seat, grind material to be flush with a new blade.



DO NOT CROSSHATCH HERE



HARD-SURFACING PATTERNS

Where parallel lines are shown, apply single passes approximately 1 inch apart. Cover exposed faces with a crosshatch pattern with stringer beads at 45° angles to form 1 inch squares.

Hard-surfacing patterns are indicated by red lines in the drawings. Crosshatch may be used in place of straight stringers on any flat areas of the jaws and on the outside of the upper jaw.

Do not crosshatch the curved areas of the jaws near the pivot. Use only straight stringers on these areas.

Follow the [Hard-Surfacing Instructions](#).

This document is a quick reference only. It does not replace the product safety and operator's manuals, which must be followed by all operators and maintenance personnel.