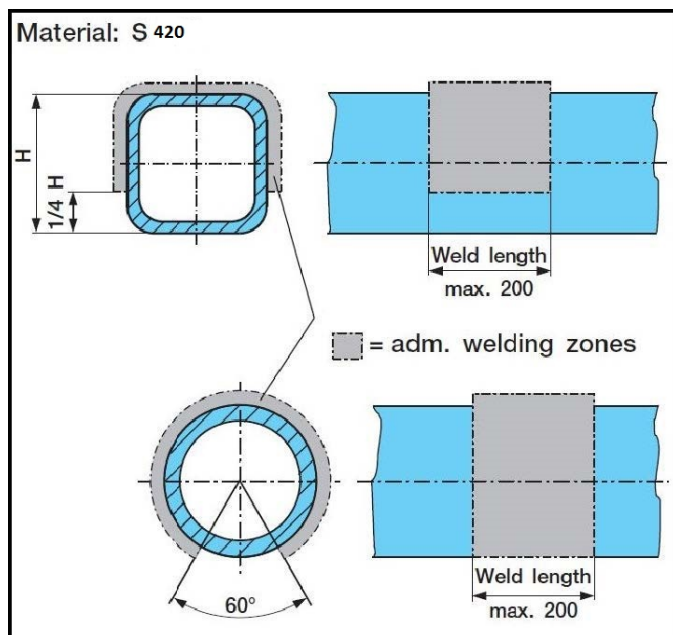


## Welding Guidelines for BPW Axle Beams



### General

When installing trailer axles, it may be necessary to subsequently weld components onto the axle beam.

### Welding Methods

- Inert gas welding - Welding wire quality: -  
G4Si (DIN EN 40)  
G4Si1 - EN ISO 14341-17  
ER70S-6 - SFA/AWS A5.18
- Manual arc welding - Rod electrodes: -  
E46 (DIN EN 4999)  
E46 5332 H5-EN ISO 2560 - A  
E7018-1H4R - SFA/AWS A5.1

The mechanical quality values must correspond to the base material S 420.

Max. Weld thickness is 5 Δ (DIN EN ISO 5817)

Avoid end craters and undercuts.

### Miscellaneous

Do not alter the camber or tracking of the axles except within BPW tolerances. After welding is completed the toe-in and camber must be recorded.

Observe the welding zones and weld lengths shown in the above diagram. It is not permitted to heat the air suspension hanger brackets for alignment work.

### BPW Transpec Warranty Statement for Axle Beams

The warranty for BPW axle beams as fitted to a non-BPW suspension (airbag or mechanical) is limited to any defects of the axle beams manufacture, including the welded connection of the stub axle to the axle beam and of the camshaft and booster brackets, so long as the axle is loaded within its rated capacity. BPW Transpec can supply capacity ratings on request as applicable to BPW axles used with BPW airbag or BPW mechanical suspensions. BPW axles are supplied with an identification tag showing the nominal rated capacity based on standard spring centres. This nominal capacity relates to the bearing capacity and the axle beam capacity when fitted with conventional spring suspensions at recommended spring centres. The nominal rated capacity has no relevance to the axle beam capacity when fitted to an airbag suspension. Please contact the suspension supplier for further details regarding the capacity and spring centres of non-BPW suspensions.

Any fitment of BPW axles (round or square beam) to a non-BPW suspension (of any manufacture) that requires the welding of the spring seats to the axle beam by a third party shall be excluded from any warranty with regards cracking of the axle beam excepting a defect in axle manufacture.

\* For any welding on the axle beam - like fitting a new axle seat - the BPW axle beam must be pre-heated to 150° before welding commences and after completion of the welding the beam must be allowed to cool gradually until room temperature is regained. When in doubt please contact your local BPW agent

\* The above information is provided solely for guidance and BPW Transpec accepts no liability for the use or misuse of this information

For more information consult the latest **BPW Operator's Manual** - available on request.

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