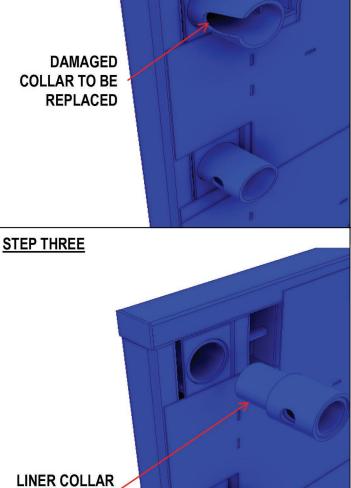
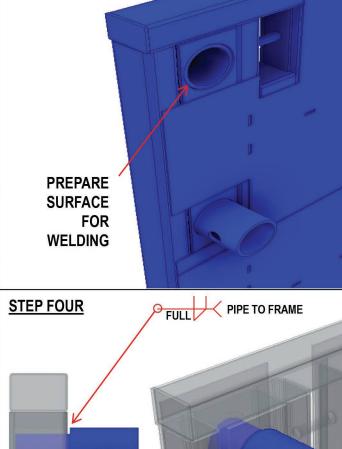
Repair Specification: Liner Collar STEP ONE

ASSEMBLY





INSIDE PIPE

STEP TWO



GENERAL COLLAR REPAIR SPECIFICATION: This specification applies to the following

- the Structural Welding Code for Steel AWS D1.1-90
- A certified welder shall perform all welding.
 - 70,000 psi welding rod or wire shall be used to complete the welds.
- 3/16" steel sheet with a 55,000 psi minimum yield strength cut away from the collar
- The Replacement Collar shall be manufactured by GME.

types of trench shield

PROCEDURE:

grinding wheel.

- Identify collar that needs replacing.
- Cut old collar out, being carful not to cut into the vertical tubes. Clean the area to be

welded thoroughly with a wire brush or

- Insert assembly into collar opening in frame, making sure in leaving a gap between frame and outer pipe (collar) to insure full penetration weld.
- See details in step four illustration for gap and welding details.



Drawing No: REPAIR-017