



Domestic Weld On Hook

Warning and Welding Instructions

	WARNING		Improper use and care can result in bodily injury and / or property damage.
Do not use for lifting people or loads over people.			

To avoid injury:

- Inspect hook before each use.
- Do not exceed the WLL noted on hook
- Do not tip load hook or apply load to hook latch. Latch is provided to retain slack slings and chains only during hook-up.
- Apply load smoothly. Do not jerk or impact load hook.

Operating Instructions

- Inspect hook as noted below before each use.
- Connect load to hook load zone. See diagram for hook load zone. Do not jerk load.
- Do not apply load near hook tip or latch. Note that latch advises “Latch not to carry load”. Make certain latch operates properly and is closed.
- Do not side load hook. Apply load in line with hook.

Hook Inspection

Inspect hook components before each use and periodically as follows:

- Inspect for wear. Discard if worn more than 10% of the original dimension at any location.
- Inspect for distortion. Discard if throat opening is more than 15% of original opening or hook latch does not close properly.
- Inspect for twisting and bending. Discard if bent or twisted more than 10° from the plane of unbent hook.
- See catalog for dimensions.
- Inspect for cracks and excessive corrosion. Discard hooks that display these conditions.

- Inspect for proper operation and engagement of hook latch and closure of hook opening. Also check hook, nut, and screw for security. Replace latch as necessary and correct noted deficiencies before using hook.
- Use only Midland Forge replacement parts.

Welding Instructions

- Electrodes must be used with carbon or low-alloy steel. Designed to be used with buckets. Electrodes must not be wet.
- Use coated basic electrodes DIN E 51 5 B 120 20H AWS 7018-1 or equivalent
- Welding surfaces shall be cleaned thoroughly of rust, paint, mil-scale, oil, grease, or etc prior to welding.
- Preheat required for Weld-On hook to 400 – 600° F (204 – 316°C) and shall be maintained throughout entire process.
- At temperatures below 32°F (0°C) all welding surfaces shall be preheated.
- Welding operation shall be carried out continuously
- Welding surfaces shall be air cooled after welding. The join shall not be cooled by water. Use non-forced air cooling..
- There shall be no cracks or porosity on the weld after welding is complete.
- Welding operation shall be carried out by a qualified welder.

CAPACITY	SIZE OF FILLET WELD	MINIMUM PLATE THICKNESS
1 ton	0.250"	0.375"
3 tons	0.500"	0.500"
6 tons	0.500"	0.625"
10 tons	0.563"	0.750"

