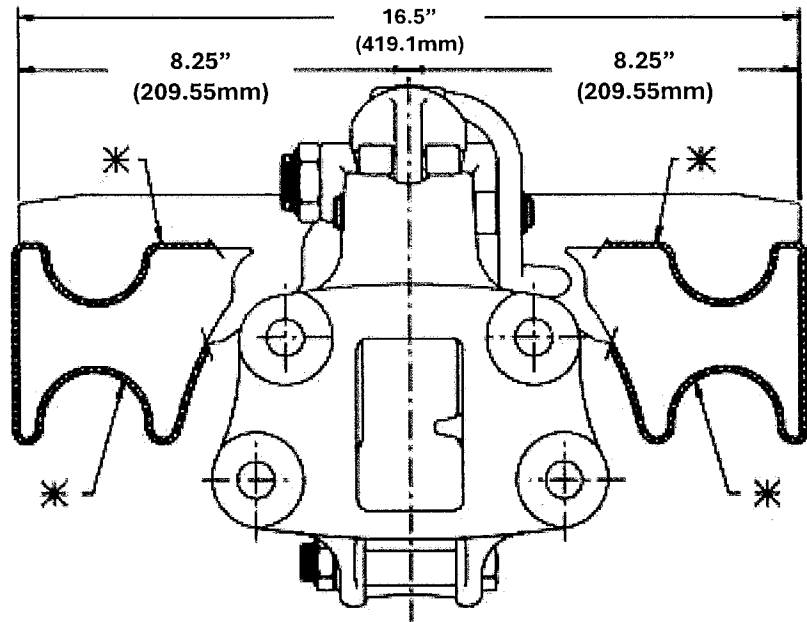
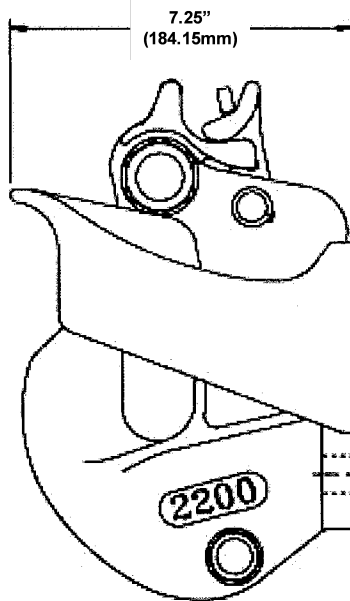




PREMIER MANUFACTURING CO.

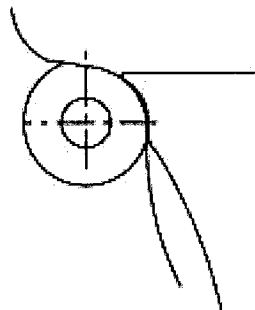
THE FIRST NAME IN QUALITY COUPLINGS

438 DRAWBAR GUIDE TO 2200L INSTALLATION GUIDE

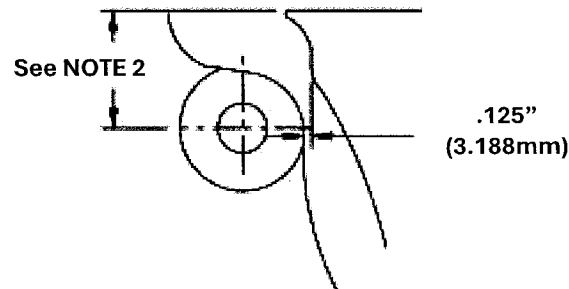


* -The cross hatched area on above drawing indicates perimeter of 438 that is to be welded.

To install 438 drawbar guides, follow steps 1 through 3 (see illustration below).



STEP 1



STEP 2

STEP 1: Match contours on coupling and top of guide's mounting base.

STEP 2: Once positioned, move 438 guide vertically (straight up), until top of guide's mounting surface is 1.718-1.875" from coupling's top hole center, and horizontally 1.25" away from 2200L body. The distance between the outer edges of the two guides should be 16.5".

STEP 3: Weld each drawbar guide to the trailer cross member/frame with a minimum 1/4" fillet weld around the indicated perimeter.

NOTE 1: DO NOT WELD THE DRAWBAR GUIDES TO THE 2200L COUPLING.

NOTE 2: 1.718" (43.64mm) to 1.875" (47.62mm). Closer to the 1.875" gives the best performance.

WLK C&P2/12



438 Drawbar Guides

WELDING PROCEDURES

WELDING PROCEDURE SPECIFICATION (WPS) Yes (X)
PREQUALIFIED (X) QUALIFIED BY TESTING (X) or PROCEDURE
QUALIFICATION RECORD (PQR) Yes (X)

GMAW		Identification #: PMEM-1
Revision 0 (Date: 2/1/00)		By: PI
Authorized By:		Date:
Welding Process(es): GMAW		Type: Manual: Semi-Automatic: (X)
Supporting PQR No(s): N/A Prequalified		Machine: Automatic:
JOINT DESIGN USED		POSITION
Type: All Fillets, Butts (See Attached)		Position of Groove: 1G, 2G
Single (X) Double Weld (X)		Vertical Progression: Up (X) Down ()
Backing: Yes (X) No (X)		ELECTRICAL CHARACTERISTICS
Backing Material: M1-P1-S1 Group 1 & 2		Transfer Mode (GMAW) short-circuiting ()
Root Opening: — Root Face Dimension: —		Globular (X) Spray (X)
Groove Angle: — Radius (J-U): —		Current: AC () DCEP(X) DCEN () Pulsed ()
Back Gouging: Yes (X) No (X) Method: Mech/Thermal		Other
BASE METALS		TECHNIQUE
Material Spec.: M1-P1-S1 1026 Carbon Steel		Stringer or Weave Bead: String or Weave
Type or Grade: Group 1 & 2		Multi-Pass or Single Pass (per side): Single, Multiple
Thickness: Groove: 1/8"-1 1/8" Fillet: Unlimited		Number of electrodes: Single
Diameter (Pipe): 4" minimum		Electrode Spacing: Longitudinal: —
FILLER METALS		Lateral: —
AWS Specification: A5.18		Angle: —
AWS Classification: E70S-1		Contact Tube to Work Distance: 3/4" ±1/8"
SHIELDING		Peening: Recommended
Flux: Gas: CO ₂		Interpass Cleaning: Mechanical
Composition: 100%		POSTWELD HEATTREATMENT
Electrode-Flux (Class) Flow Rate: 30-50 cfm		Temp.: —
Gas Cup Size: 1/2" Dia.		Time: —
PREHEAT		
Preheat Temp.: Min.: 100°F		
Interpass Temp.: Min.: 100°F Max.: 500°F		

WELDING PROCEDURE							
Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed
		Class	Diam.	Type & Polarity	Amps or Wire Feed Speed		
All	GMAW	E70S-X	0.035	DCEP	190-230	22-31	13 ±1 IPM
All	GMAW	E70S-X	0.045	DCEP	260-290	27-31	13±1 IPM

WELDING PROCEDURE SPECIFICATION (WPS) Yes (X)
PREQUALIFIED (X) QUALIFIED BY TESTING () or PROCEDURE
QUALIFICATION RECORD (PQR) Yes ()

SMAW		Identification #: PMSMA-1
Revision 0 (Date: 2/1/00)		By: PI
Authorized By:		Date:
Welding Process(es): SMAW		Type: Manual: (X) Semi-Automatic:
Supporting PQR No(s): N/A (Pre-Qualified)		Machine: Automatic:
JOINT DESIGN USED		POSITION
Type: All Fillets-Butts (See Attached)		Position of Groove: All
Single (X) Double Weld (X)		Vertical Progression: Up (X) Down ()
Backing: Yes (X) No(X)		ELECTRICAL CHARACTERISTICS
Backing Material: M1-P1-S1, Group 1 & 2		Transfer Mode (GMAW) short-circuiting ()
Root Opening: — Root Face dimension: —		Globular () Spray ()
Groove Angle: — Radius (J-U): —		Current AC () DCEP (X) DCEN () Pulsed ()
Back Gouging: Yes (X) No (X) Method: Mech/Thermal		Other
BASE METALS		TECHNIQUE
Material Spec.: M1-P1-S1 1026 Carbon Steel		Stringer or Weave Bead: String and Weave
Type or Grade: Group 1 and 2		Multi-Pass or Single Pass (per side): Multiple/Single
Thickness: Groove: 1/8"-1 1/2" Fillet: Unlimited		Number of electrodes: Single
Diameter (Pipe): 4" Minimum		Electrode Spacing: Longitudinal: N/A
FILLER METALS		Lateral: N/A
AWS Specification: A5.1-A5.5		Angle: N/A
AWS Classification: E7018		Contact Tube to Work Distance: N/A
SHIELDING		Peening: Recommended
Flux: Gas: N/A		Interpass Cleaning: Mechanical Only
Composition: N/A		POSTWELD HEAT TREATMENT
Electrode-Flux (Class) Flow Rate: N/A		Temp.: N/A
Gas Cup Size: N/A		Time: N/A
PREHEAT		
Preheat Temp.: Min.: 100°F		
Interpass Temp.: Min.: 100°F Max.: 500°F		

WELDING PROCEDURE							
Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed
		Class	Diam.	Type & Polarity	(Amps) or Wire Feed Speed		
All	SMAW	E7018	3/32"	DCEP	70-110	19-22	As Required
All	SMAW	E7018	1/8"	DCEP	90-150	20-24	Required
All	SMAW	E7018	5/32"	DCEP	120-190	20-24	

WELDING PROCEDURE SPECIFICATION (WPS) Yes (X)
PREQUALIFIED (X) QUALIFIED BY TESTING () or PROCEDURE
QUALIFICATION RECORD (PQR) Yes ()

FCAW		Identification #: PMFC-1
Revision 0 Date: 2/1/00		By: PI
Authorized By:		Date:
Welding Process(es): FCAW		Type: Manual: (X) Semi-Automatic:
Supporting PQR No(s): N/A (Pre-Qualified)		Machine: Automatic:
JOINT DESIGN USED		POSITION
Type: All Fillets-Butts (See Attached)		Position of Groove: AB
Single (X) Double Weld (X)		Vertical Progression: Up (X) Down ()
Backing: Yes (X) No(X)		ELECTRICAL CHARACTERISTICS
Backing Material: M1-P1-S1, Group 1 & 2		Transfer Mode (GMAW) short-circuiting ()
Root Opening: — Root Face Dimension: —		Globular (X) Spray (X)
Groove Angle: — Radius (J-U): —		Current: AC () DCEP(X) DCEN () Pulsed ()
Back Gouging: Yes (X) No (X) Method: Mech/Thermal		Other
BASE METALS		TECHNIQUE
Material Spec.: M1-P1-S1 1026 Carbon Steel		Stringer or Weave Bead: String and Weave
Type or Grade: Group 1 and 2		Multi-Pass or Single Pass (per side): Multiple/Single
Thickness: Groove: 1/8"-1 1/2" Fillet: Unlimited		Number of electrodes: Single
Diameter (Pipe): 4" Minimum		Electrode Spacing: Longitudinal: N/A
FILLER METALS		Lateral: N/A
AWS Specification: A5.20		Angle: N/A
AWS Classification: E70T-1/E71T-1		Contact Tube to Work Distance: 3/4" ±1/4"
SHIELDING		Peening: Recommended
Flux: Gas: CO ₂		Interpass Cleaning: Mechanical Only
Composition: 100%		POSTWELD HEAT TREATMENT
Electrode-Flux (Class) Flow Rate: 30-50 cfm		Temp.: N/A
Gas Cup Size: 1/2" Dia. Min.		Time: N/A
PREHEAT		
Preheat Temp.: Min.: 100°F		
Interpass Temp.: Min.: 100°F Max.: 500°F		

WELDING PROCEDURE							
Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed
		Class	Diam.	Type & Polarity	(Amps) or Wire Feed Speed		
All	FCAW	E70T-1	0.045	DCEP	180-280	24-28	As Required
All	FCAW	E71T-1	0.052	DCEP	190-300	24-29	
All	FCAW		0.068	DCEP	210-350	24-29	
All	FCAW		5/64"	DCEP	250-400	26-30	

