



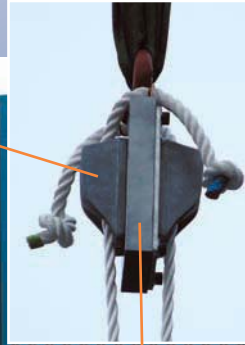
# Welding aluminium cleats

Our aluminium cleats are easily welded to provide a strong and permanent fixing.

Where an alloy cleat needs to be fixed to an aluminium surface welding can be less expensive than drilling holes and bolting on a cleat.

- **Applications** - These Include aluminium fishing boats and oil rigs.
- **How Strong** - Our van weighs about 1300 kgs (1<sup>1</sup>/<sub>4</sub> tons). Two CL220VB cleats were welded to plates, which were then bolted to the lifting eye.

The van was lifted under carefully controlled conditions - don't try this at home! The suitability of cleats should be tested for each application.



**Available cleats:** Any of our alloy cleats can be supplied in a suitable finish for welding by adding VB (vibro finish) to the part number. Painted or anodised cleats are **not** suitable for welding.

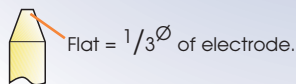


CL220VB

Cleat and rope after lifting the van. When cleats are welded as suggested, tests show that the rope fails, not the weld.



**Welding suggestions:** Clean the cleats with acetone prior to welding.  
 Recommended process - TIG.  
 Recommended gun - W450 water cooled.  
 Recommended rod - 4047 10 - 12% silicone.  
 2.4mm (<sup>3</sup>/<sub>32</sub>" ) diameter.  
 Suggested electrode, 3.2mm (<sup>1</sup>/<sub>8</sub>" )Ø white spot electrode.  
 Shielding gas - Argon.



CL211 Mk1VB

**How much weld?** All our strength tests show that only the ends of the cleat have to be welded.



CL219VB