

Welding procedure

To produce a good quality Welding, it is recommended that the end of the casing and the end of the ring bit are beveled and clean of any paint, rust, etc... The ring bit is used to centralize the driver bit and receive the energy from the DTH hammer. For these reason, it is very important that the ring bit is aligned so it is centered with the casing. The ring bit and the casing must be perfectly parallel.

A) Align the casing and the ring bit so that the two parts are parallel. You can use a custom build device to facilitate the alignment. See attached pictures.

B) Use welding rod type: 7018

C) Fill the joint between the casing and the shoe with one, two or 3 passes depending of the width of the joint. For butt weld joint, you may want to leave a gap between the parts before welding. Preheating is not necessary.

D) Once the welding done, we recommend to reduce the weld bead equal to the casing. This will reduce friction between the casing and the hole during drilling thus saving the swivel joint of the ring set.