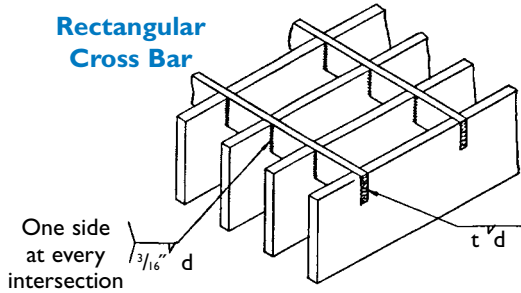


# WELDING STANDARDS

## HEAVY DUTY STEEL GRATING

### Rectangular Cross Bar



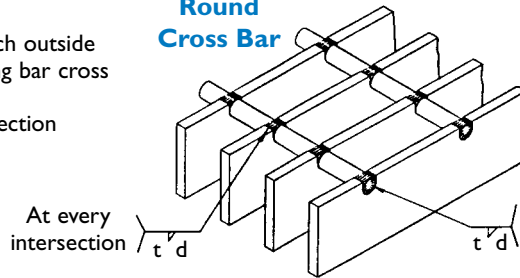
One side at every intersection

$t$  = Thickness of cross bar  
 $d$  = Depth of cross bar

The welding standards shown here apply to those gratings and treads having a clear opening of not less than  $\frac{3}{8}$ " between bearing bars and those galvanized as per ASTM A-123.

At each outside bearing bar cross bar intersection

### Round Cross Bar

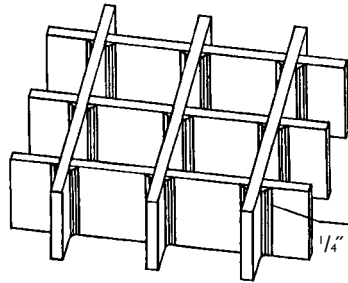


At every intersection

At each outside bearing bar cross rod intersection

$t$  = Thickness of bearing bar  
 $d$  = Diameter of cross rod

### Egg-Crate

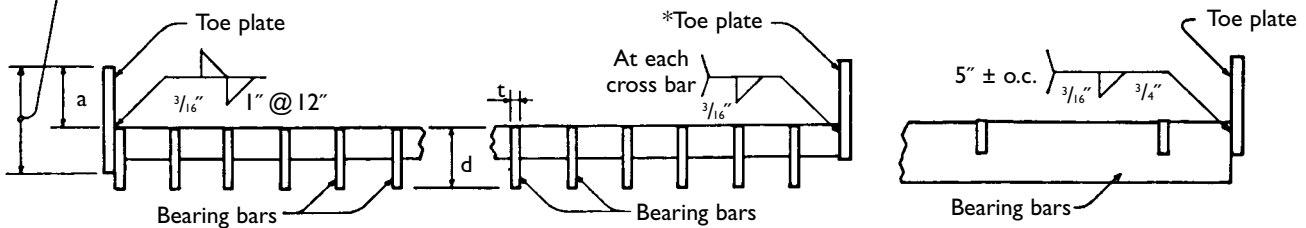


Two sides at every intersection

$d$  = Depth of bearing bars

## TOE PLATES

Depth of toe plate to be in multiples of  $\frac{1}{2}$ " with a maximum of  $a + d$ .



$t$  = Bearing bar thickness

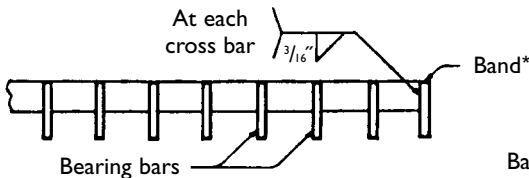
$d$  = Bearing bar depth

\*Example shown occurs at a diagonal or circular cutout.

## BANDING

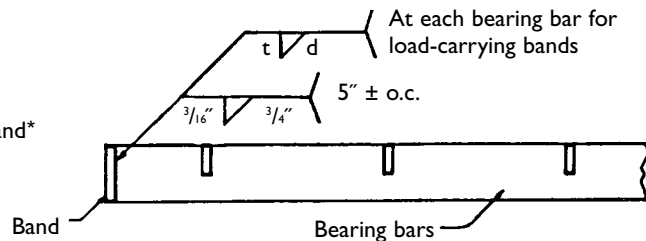
Minimum thickness =  $\frac{1}{4}$ "

For standard banding, band bar is same depth as bearing bars.



At each cross bar

For depth less than  $2\frac{1}{2}$ " weld one side at top. For depth  $2\frac{1}{2}$ " or greater, weld one side at top, opposite side at bottom; or weld exceeding one-half depth on one side only.



At each bearing bar for load-carrying bands

$5" \pm o.c.$

\*Example shown occurs at a diagonal or circular cutout. Since the outside bearing bar becomes the edge bar of a panel width, side bands are never specified.