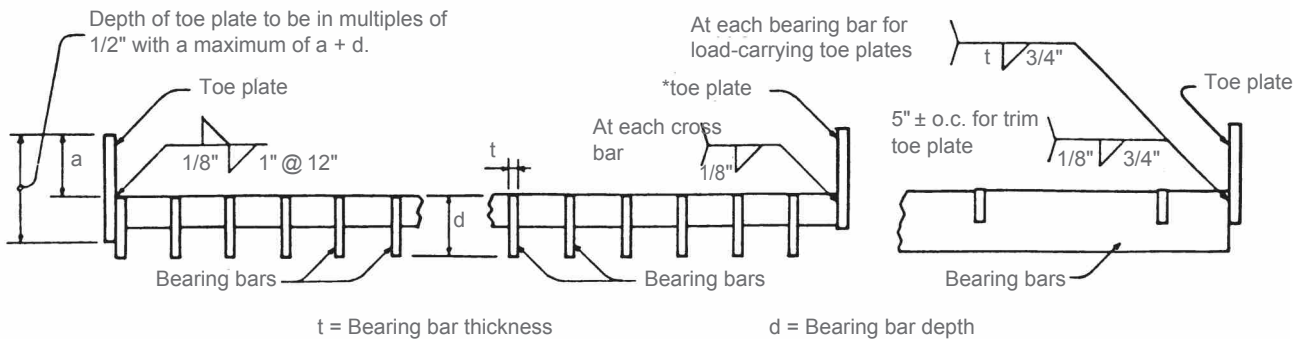


WELDING STANDARDS

Light Duty Steel Grating & Aluminum Grating

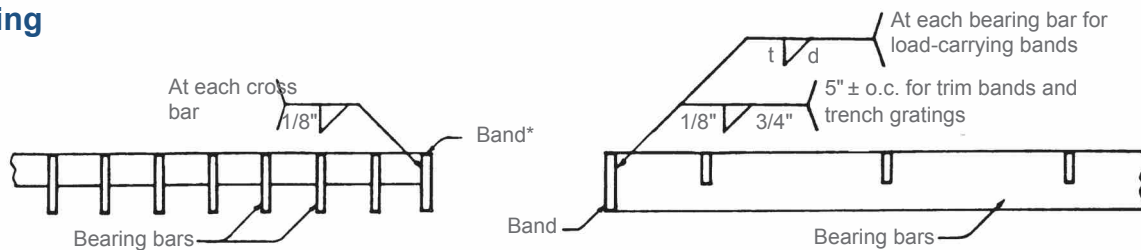
The welding standards shown here apply to those gratings and treads having a clear opening of not less than 5/8" between bearing bars and those galvanized as per ASTM A-123.

Toe Plates



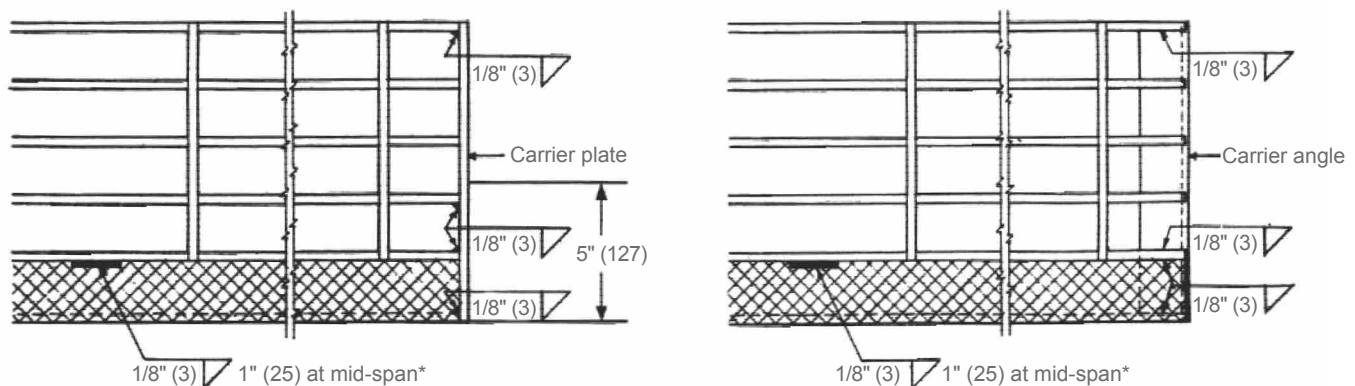
*Example shown occurs at a diagonal or circular cutout.

Banding



*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. Full depth banding will be provided unless otherwise specified.

Stair Treads



When carrier plates are used, the bearing bars and the nosing in the front five inches shall be welded to the carrier plate as shown.

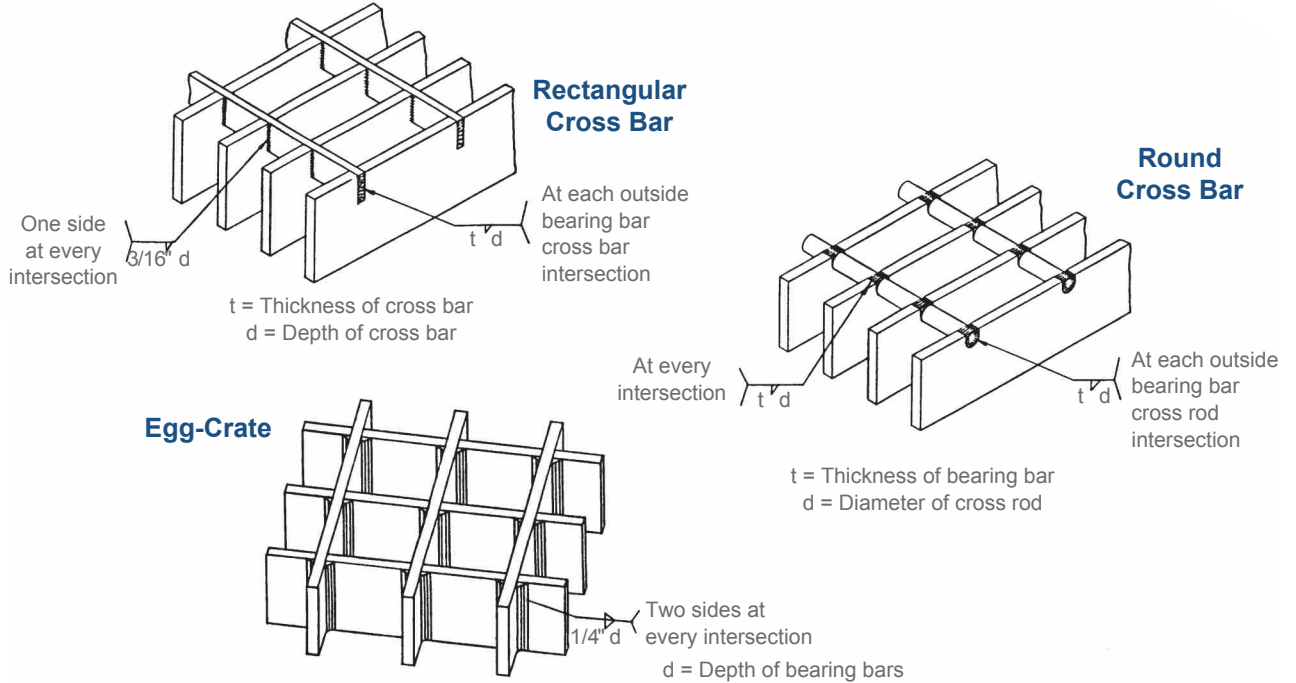
On treads over 9-3/4" (248) wide, weld end of center bar also.

*Treads spanning 4' (1.2 m) or more shall have two welds, located at the third points.

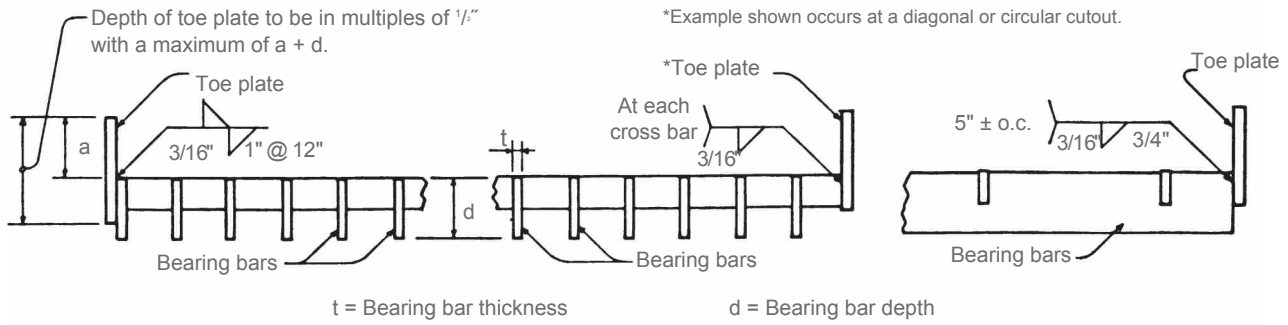
WELDING STANDARDS

Heavy Duty Steel Grating

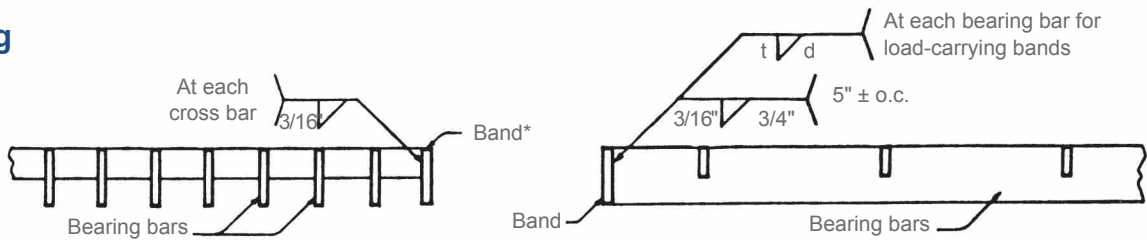
The welding standards shown here apply to those gratings and treads having a clear opening of not less than 5/8" between bearing bars and those galvanized as per ASTM A-123.



Toe Plates



Banding



For depth less than 2-1/2" weld one side at top. For depth 2-1/2" or greater, weld one side at top, opposite side at bottom; or weld exceeding one-half depth on one side only. Minimum thickness = 1/4" For standard banding, band bar is same depth as bearing bars.