

## ProCraft Weld-on Lifting Points

These versatile weld-on points are commonly used for lifting, towing and lashing points on vehicles, equipment and machinery. The welding block allows the ring to swivel through 180°, providing a flexible lifting point for a multitude of lifting applications. Each part is forged and tempered, and manufactured and proof load tested to EN 1677-4. Ensure welding and installation instructions are followed.

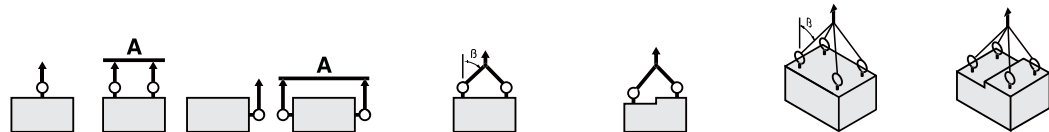
Stock Code	Number Code	Nominal Size	Working Load Limit Pounds 4:1 FOS	Dimension Inches								Weight per Piece Pounds
				A	B	C	D	E	F	G	H	
71WOP-1	P2154	1 ton	2,000	1.6	1.6	3.3	2.6	1.4	1.2	1.5	0.5	0.9
71WOP-2	P2154	2 ton	4,000	1.6	1.7	3.4	2.8	1.6	1.3	1.6	0.6	1.2
71WOP-3	P2154	3 ton	6,000	1.8	1.7	3.9	3.1	1.7	1.4	1.8	0.7	1.6
71WOP-5	P2154	5 ton	10,000	2.1	2.4	5.1	3.9	2.0	1.9	2.4	0.9	3.1

### Welding procedure

1. The welding should be carried out by a qualified welder according to CSA standards or to your specific statutory regulations.
2. The welding should not be carried out until establishing that the machine or product where the lifting eye shall be assembled, conforms to the strength requirements.
3. The surfaces must be clean (no oil, rust, paint, varnish etc.).
4. The weld must be suitable for the application of load. It should take up to 2.5 times the working load limit without permanent deformation and 4 times the working load limit without breaking.
5. In temperatures under 10° C (50°F) the surface of the weld is to be warmed slightly.
6. Saddle material is equivalent to SAE/AISI 1024, DIN 1.0570 or EN S355J2.
7. Weld material is to have a minimum tensile strength of 70,000 PSI (such as AWS A5.1 E-7018). Follow the electrode manufacturer's recommendations.
8. The complete welding operation must be carried out continuously so that the parts do not have time to cool. Weld the full length of dimension "E" on both sides of the base.
9. Do not rapidly cool the weld.
10. A thorough inspection of the weld should be performed. No cracks, pitting, inclusions, notches or undercuts are allowed. If doubt exists, use a suitable NDT method, such as magnetic particle or liquid penetrant to verify.

### Inspection

The lifting point should be complete, free moving and clear of deformation of the component parts. Mechanical damage, such as notches, particularly in high stress areas, evidence of corrosion or cracks in the fittings. Wear should be no more than 10 % of cross sectional diameter. Cracks or other damages to the welding.



Number of legs	1	2	1	2	2	2	2	3 or 4	3 or 4	3 or 4
Angle	0°	0°	90°	90°	0°-45°	45°-60°	Unsymm	0°-45°	45°-60°	Unsymm.
WLL Ton										
71WOP-1	1	2	1	2	1.4	1	1	2.1	1.5	1
71WOP-2	2	4	2	4	2.8	2	2	4.2	3.0	2
71WOP-3	3	6	3	6	4.2	3	3	6.3	4.5	3
71WOP-5	5	10	5	10	7.0	5	5	10.5	7.5	5