



# Excel Craft Private Limited

WELDING DIVISION

## CASE STUDY OF GRIZZLY BAR

**CUSTOMER** : SREE NIMISHAMBA INDUSTRIES

**COMPONENT** : GRIZZLY BAR

**MATERIAL** : Plate of 25mm thickness (IS 2062).

**JOB DONE BY** : Mr. Samir Rahate

**Date** : 07/11/2019 to 12/11/2019



PHOTO- A

### **PROCEDURE FOLLOWED TO CARRY OUT THE JOB BY EXCEL CRAFT TECHNICIANS:**

**PRODUCTS USED:** EXCEL BOND 004, EXCEL HARD 082.

### **PROCEDURE:**

1. **JOB HOLDING:** The Plate was clamped on the table to avoid the Distortion. As shown in photo- A.



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2. **Welding:** MS Plate of 25mm thickness was build up and welded with EXCEL BOND 004 (17mm build up) and EXCEL HARD 082(4mm for hardness). The hardness was about 55-60 HRc.

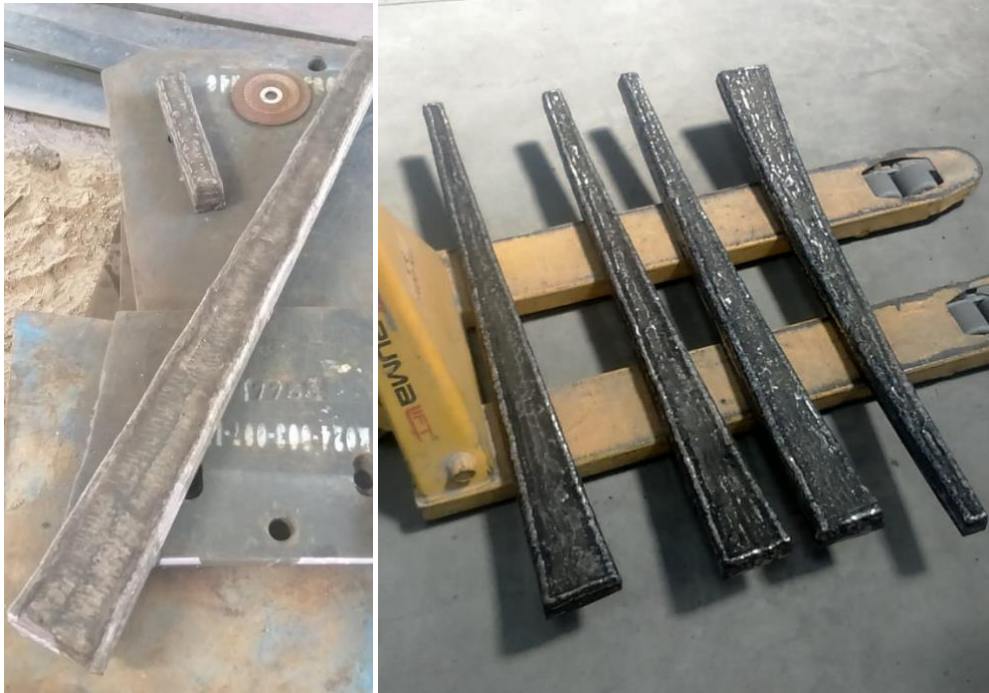


PHOTO- B (Job completed)

3. **MACHINING:** After the jobs attained room temperature, Straitening was done on press and then machined to size from back side.