



## ABF Suspension Hanger Inspection/Repair

---

- Population: Based upon review of production records the suspect trailer population was manufactured during September through October of 2011 at the Great Dane Kewanee, IL plant
- Suspect Trailers: 698 trailers



## Inspection/Repair Criteria

- Inspect all 4 hangers (front and rear)
- Inspect all four I beam to hanger welds
  - look for rust at the toes of the welds, especially at the toe of the weld that is attached to the underside of the I-Beam sub-frame
  - The rust will appear as a fine line. The undercoat at this location will be worn away or removed by the corrosion process.
- Example images on following slides
- Any of these welds that exhibit poor fusion and/or penetration as illustrated in the following photos should be repaired
  - Repair: Completely grind out the existing weld and reapply double-pass welds (each pass 0.25” in size) where the original weld was.



# Inspection Procedure: Locating Welds

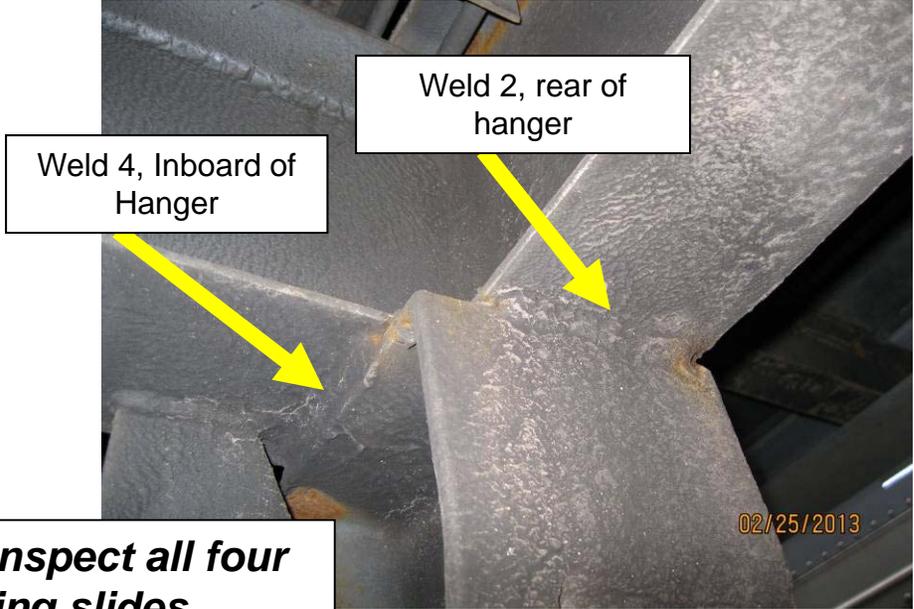
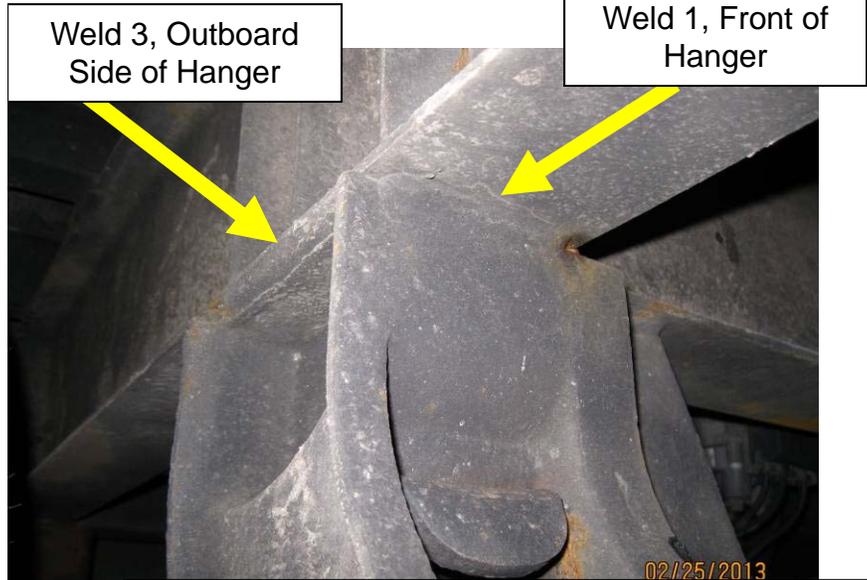
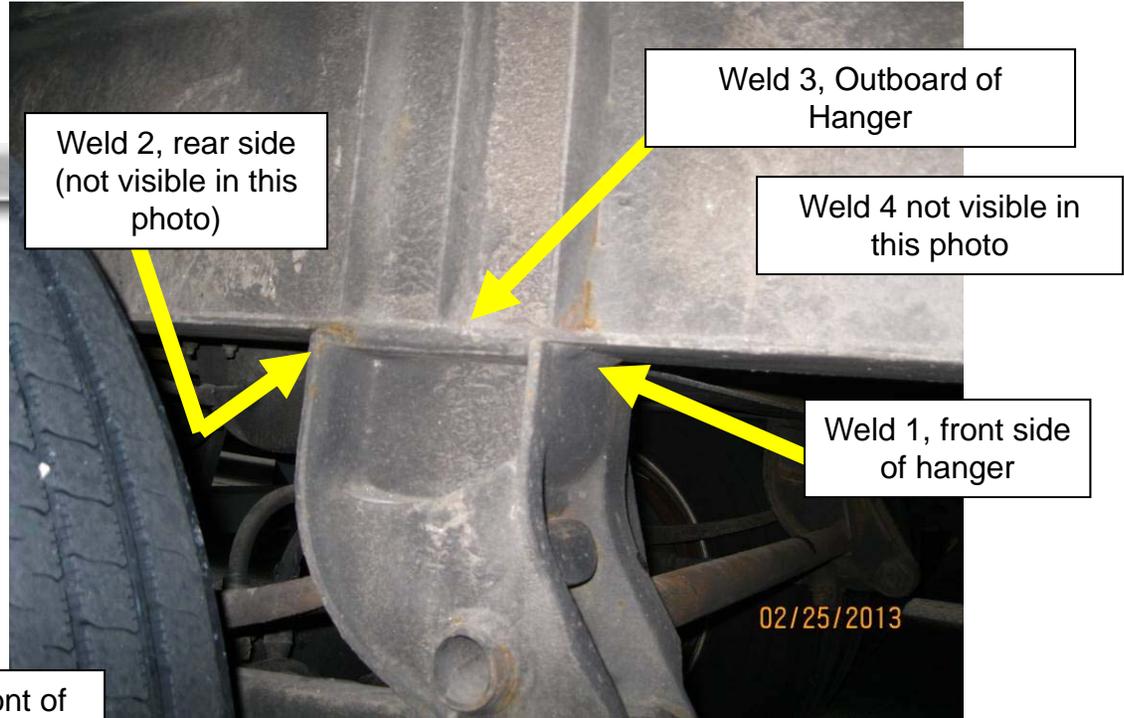
On each Hanger there are 4 welds that must be inspected.

Weld 1: Front of Hanger

Weld 2: Rear of Hanger

Weld 3: Outboard of Hanger

Weld 4: Inboard of Hanger



**Note, Curb Side Front Hanger Shown. Inspect all four hangers. Repair as noted in following slides.**



## Completely grind away existing weld and apply a Double-Pass Weld:

This image from ABF Unit # 552575, CK222305, DOM 10/11, rear side of rear curb side hanger shown.

This is weld #2 as described in the previous "Locating Welds" slide.





## Completely grind away existing weld and apply a Double-Pass Weld:

This image from ABF Unit # 552795, CK222525, DOM 10/11, rear side of Curb Side front hanger.

This is weld #2 as described in the previous "Locating Welds" slide.





## Completely grind away existing weld and apply a Double-Pass Weld:



This image from ABF Unit # 552619, CK222349, DOM 9/11 , front side of front Road Side hanger. This is weld #1 as described in the "Locating Welds" slide.

Image Below: close up view of weld.





## Welding Equipment and Materials for this Repair:

---

### ***Recommended Weld Materials:***

Gas metal arc welding (GMAW or MIG)

Use Lincoln L-50 Electrode or Equivalent with

95% Argon / 5% oxygen or

75% Argon / 25% carbon dioxide

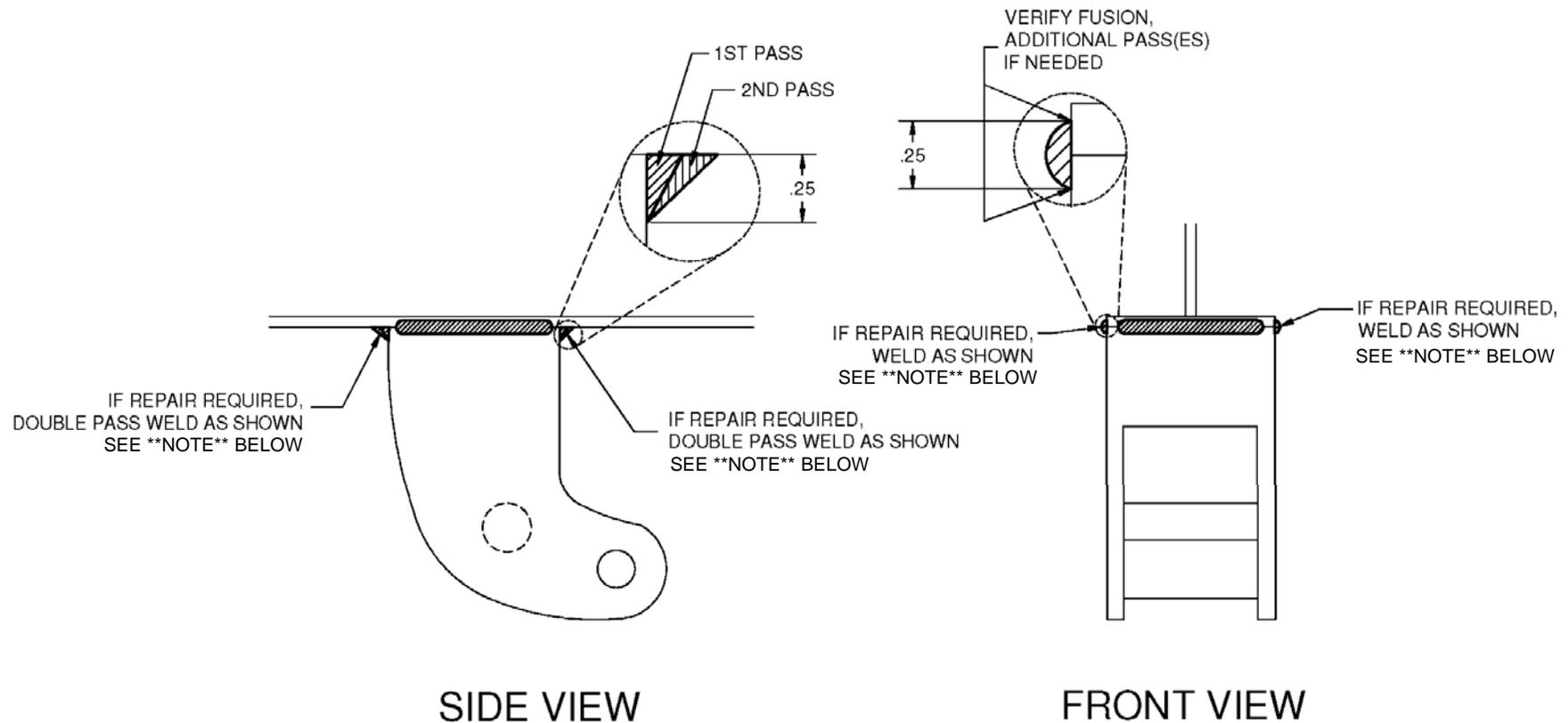
### ***Alternate weld materials:***

Shielded metal arc welding (SMAW)

Use E7018 Electrode or Equivalent



# Double-Pass Weld Application



**\*\*NOTE\*\*:** STOP ALL WELDS  $\frac{1}{4}$ " FROM THE EDGES TO PREVENT BLOW-THROUGH.

***Note, Front Hangers Shown. Inspect all four hangers (front and rear, road side and curbside) and repair if needed.***



# Questions?

Please Contact Great Dane  
Customer Service (912) 644-2260