

Cross-Rod Intersection Performance

To monitor and verify proper performance of cross-rod welds, the following testing procedure is recommended by the NAAMM Metal Bar Grating Division.

Frequency (as a minimum)

1. Start of shift
2. Middle of Shift
3. Change of Material (cross bar and bearing bar size, heat lot (where possible))
4. Change of machine parameters

Location of Testing on Panel (as a minimum)

1. First and second cross bars
2. Middle cross bar
3. Last and second last cross bars

Location of Testing on Cross Bar

1. Between the first and second bearing bars
2. Between the last and second last bearing bars
3. Between the middle bearing bars

Cross Bar Repair

To be limited to 5% of panel

For each failure a minimum of 2 cross bars in front, and 2 cross bars behind the failure location must be checked.