



## Repair Standards

### 02-012 – Reefer Floor Repairs - Welding

#### Disclaimer:

*Only a certified and experienced person using suitable tools should complete the repairs described below. Repairs should meet or exceed manufacturer's minimum specifications and should be in agreement with all safety and ecological regulations.*

#### Permissible upon return and does not require repair:

- Acceptable repairs.

#### Requires repair upon return:

- Holes, cuts or breaks in the aluminum floor board.

#### Safety Measures:

- Take appropriate safety precautions when working with fiberglass, polyester, epoxy or acetone.
  - Eyes should be covered with goggles.
  - Face should be protected by an OSHA approved respirator mask.
  - Hands should be protected by gloves.
- Take appropriate safety precautions when working with resins, solvents and insulation.
  - Read caution labels on each product used, in every use.
  - To reduce heat from welding, place a one-inch wide .063 aluminum bar beneath the seam before welding begins.
    - Be sure to have an abundance of water nearby to cool the welded area.
- Be sure that there is enough ventilation while working inside the trailer, without proper ventilation fumes could build up and cause harm.

#### Procedure:

1. Be sure that the area, to be repaired, is clean and ready for welding.
  - 1) The damaged area can be cleaned with a wire brush after it has been straightened back to its original shape.
    - i. If the area is not cleaned a deep, non-porous, weld cannot be guaranteed.
2. If a cut or tear is being repaired in the floor, use a hard disc grinder to v-groove the damaged area or grind the edges of a tear at 45-degrees.
3. Repair the damaged area with a welder to wholly seal the cut or tear.
4. Use a hard disc grinder to grind and smooth out the repaired area.



5. Clean up the grinded area with a soft disc grinder to get rid of any grinding marks left behind by the hard disc grinder.