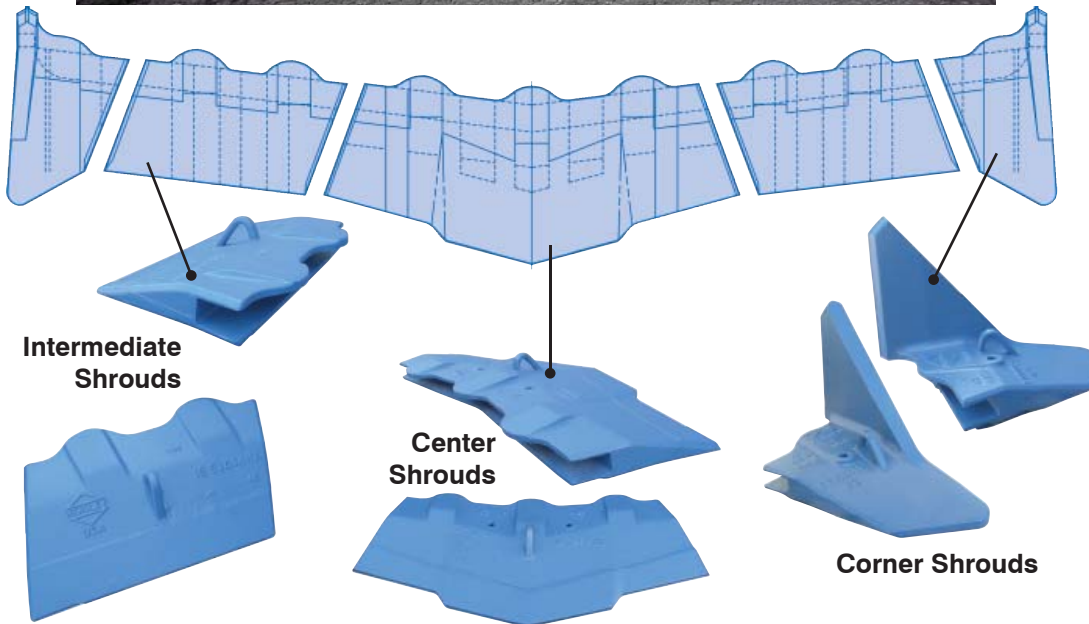




# Cast Alloy Lip Shrouds for LHD Trams



Photo courtesy of Atlas Copco



**H**ensley cast alloy lip shrouds provide maximum wear and protection for bucket lips used on LHD (load-haul-dump) tram loaders.

**H**ensley has designed these shrouds with the following features:

- Extra material in high wear areas.
- Sharp contour for better penetration.
- Versatility to fit several different bucket widths.

**T**hese features add up to longer wear life and increased production between lip shroud change-outs.

**I**nstallation is fast and easy. Just trim the shrouds to the required length, then follow our simple welding instructions.

**U**se Hensley cast alloy lip shrouds on your next lip change-out.

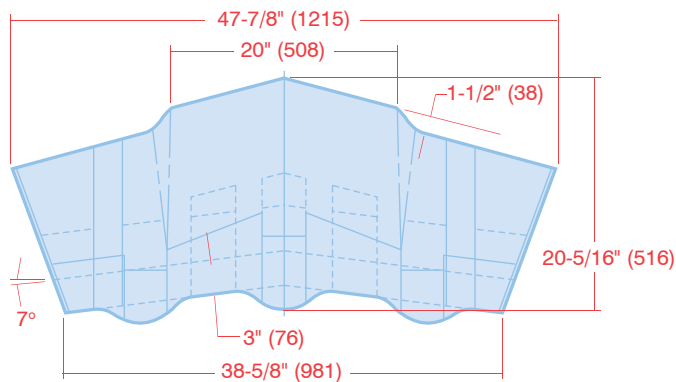
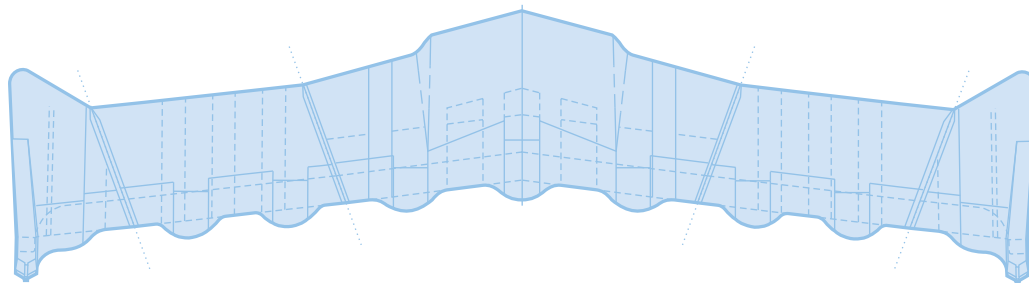


Photo courtesy of Atlas Copco



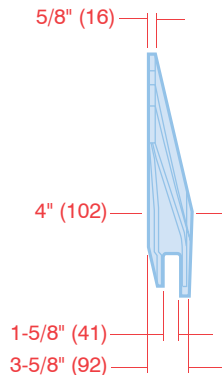
# Cast Alloy Lip Shrouds for LHD Trams

## Welding Instructions



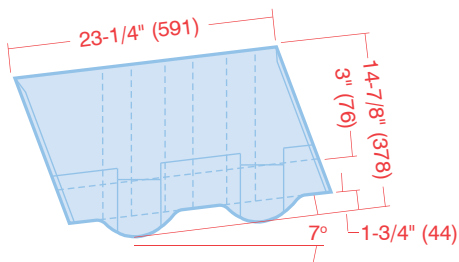
### Center Shroud

18-7252HX (370.0 lbs./168.0 kg.)



### Center Shroud

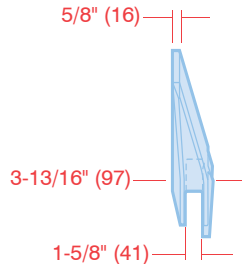
End View



### Intermediate Shroud

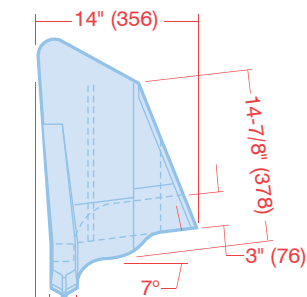
Left Hand Shown;  
Right Hand Opposite

18-5370HX (143.0 lbs./64.9 kg.)



### Intermediate Shroud

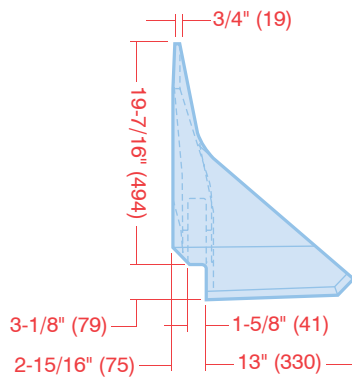
End View



### Corner Shroud

Left Hand

ET10015LHX (150.0 lbs./68.1 kg.)



### Corner Shroud

End View

(Read all instructions carefully before welding.)

The material of the cast lip assembly is Hensley alloy #3, which has been heat-treated to a hardness of approximately 477 Brinell. The alloy is a chrome/moly steel with approximately 0.28% carbon. The material is weldable if the proper precautions are followed.

#### Recommendations:

- Use E7018 low hydrogen rod or E70 wire. Be sure the welding materials are free of moisture.
- Preheat to 350° - 500° F (175° - 257° C).
- Interpass temperature should not exceed 500° F (260° C).
- Start at the center of the blade and weld toward the edges of the bucket.
- Use 2" (51mm) minimum tack welds on both sides.
- Weld both sides alternately between passes.
- Remove all slag subsequent to weld passes.
- Post-heat the entire assembly uniformly to 350° - 400° F (176° - 204°C) and cover with a thermal blanket. This serves as stress relief and to temper any martensite that may have formed during cooling from the weld. This is important as the steel contains a significant amount of alloy.

Your Authorized Hensley Dealer

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www.hensleyind.com

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