

Cat® Base Edges With Butter Bead Weld Prep



No Need to Preheat, Saving Time and Money

Preheating a heat-treated, high-hardness part before welding will help prevent cracks. But preheating requires considerable time. Cat base edges with butter bead weld prep eliminate the need to preheat, reduce downtime and result in significant cost savings.

Butter bead weld prep is a layer of weld on a base edge that makes it possible to weld the edge onto buckets without preheating. Butter bead is applied to the back side of the base edge and to the top strap of the corner adapters. It is available on any base edge 40mm or thicker for Cat hydraulic excavators and wheel loaders.

Caterpillar. The difference counts.™

Cat Dealers define world-class product support. We offer you the right parts and service solutions, when and where you need them.

The Cat Dealer network of highly trained experts keeps your entire fleet up and running to maximize your equipment investment.

CATERPILLAR®

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The Proper Weld With Less Downtime

Base edges have the proper amount of butter bead weld because it is applied in the factory. You'll be able to weld base edges onto buckets in much less time because butter bead eliminates the need to preheat. Field reports indicate a significant time savings.

Base Edge Thickness (in mm)	Preheat Time (in hours)
< 40	3 to 6
40 – 45	8 to 12
50 – 60	12 to 16
> 65	16 to 20

The cost of downtime for preheating should be considered when comparing butter bead base edges to standard edges. Preheat time can vary depending on a variety of conditions including ambient conditions, the type of heat source and composition of the gas.

If new sidebars or corners are installed, they must be preheated as they are hardened parts. For details on this and other welding procedures, please see SMHS8078, "Instructions and Welding Procedures for Improved Cutting Edges on Wheel Loaders."

Available for Many Wheel Loaders and Excavators

Butter bead weld prep is available for base edges 40 mm or thicker on Cat wheel loaders and hydraulic excavators.

<u>Wheel Loaders</u>		<u>Hydraulic Excavators</u>	
966	972	318	320
973	977	322	325
980	988	330	345
990	992	350	365
994		375	385

Rely on Your Cat Dealer

You can count on your Cat dealer to support your specific needs for butter bead weld base edges and other Ground Engaging Tools by:

- Identifying signs of premature wear and suggest corrective action
- Suggesting operating techniques to reduce wear
- Offering other products like MAWPS, weld-on half arrows and pin-on side bar protectors
- Determining when non-genuine components offer a poor fit that could damage bucket edges
- Determining the best combination of components for your application to give you the lowest cost per hour



For more information, see us today or visit our web site at www.cat.com

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