**STEP ONE**

- Damaged Height Adapter Beam and or Damaged Connection Plates.

**STEP TWO**

- Corresponding Height Adapter Leg Assembly and or Height Adapter Extension.

**STEP THREE**

- Determine the damage area required repair.

**STEP FOUR**

- Locate and cut the damaged beam section from height adapter leg section.

**SPECIFICATIONS:**

- All welding shall be performed according to the Structural Welding Code for Steel - AWS D1.1-90.
- A certified welder shall perform all welding.
- 70,000 psi welding rod or wire shall be used to complete the welds.

**PROCEDURE:**

**STEP ONE**

- Determine the damage area required repair.

**STEP TWO**

- Locate and cut the damaged beam section from height adapter leg section.

**STEP THREE**

- Once the damaged section has been completely removed from height adapter, prepare the surface for welding per Structural Welding Code AWS D1.1-90. The remaining beam flange(s) must be fully beveled at a 45° per Full penetration groove weld detail as shown in detail.

**STEP FOUR**

- Once all the above steps have been completed, weld GME supplied connection plate(s) per weld details shown to appropriate beam section(s).