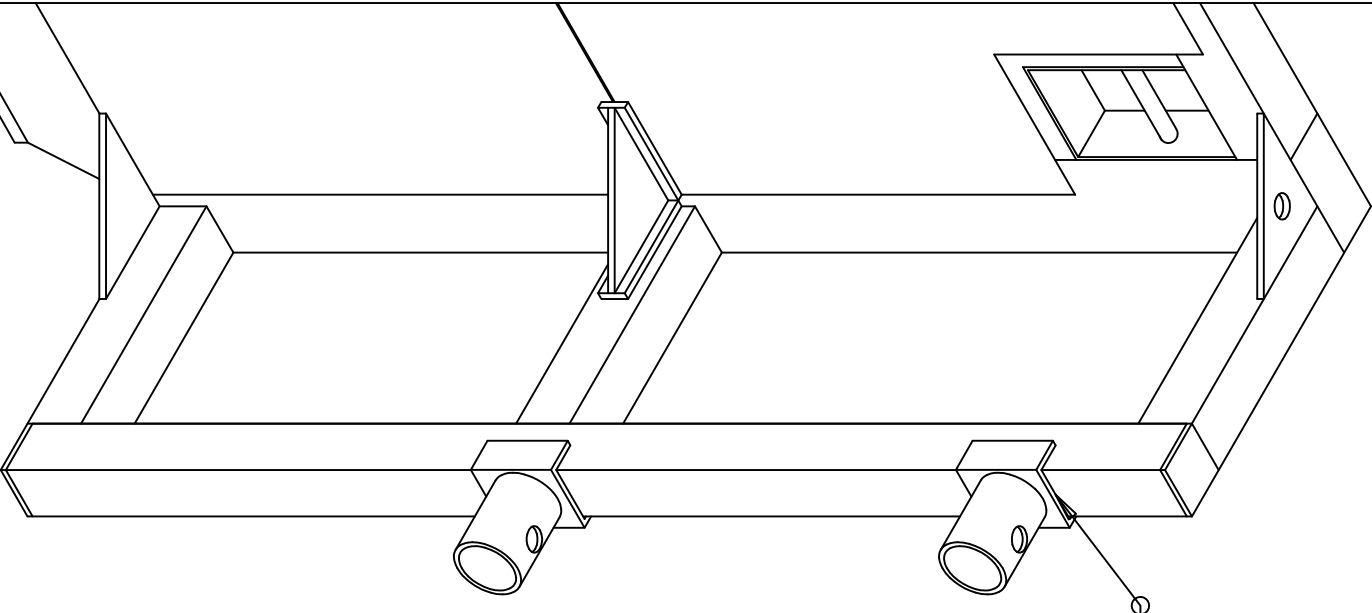


**STEP ONE**



WELD COLLAR TO FRAME IN ALL ACCESSIBLE AREAS.

**MANHOLE COLLAR REPAIR SPECIFICATION:**  
 This specification applies to the following types of trench shields:  
 MH SHIELDS


**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.
- 1/8" steel sheet with a 55,000 psi minimum yield strength shall be used to replace the skin plate cut away from the collars.
- The Replacement Collar shall be manufactured by GME.

**PROCEDURE:**

1. Cut damaged collar from the man hole end return, being careful not to cut into the vertical tubes.
2. Clean the area to be welded thoroughly with a wire brush or grinding wheel.
3. Weld the replacement collar to the tubes in all accessible locations using a continuous 3/16"

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