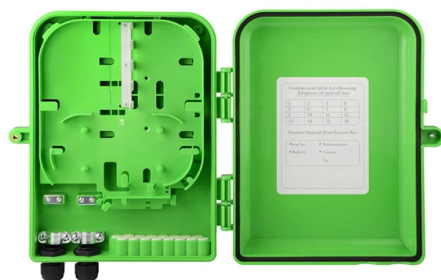


How to weld the corner pieces of the cable tray



Overview

Proper preparation is essential when welding corner joints to ensure a strong, clean, and aesthetically pleasing result.

Key Takeaways

Properly welding cable tray corners requires careful preparation, precise alignment, and controlled welding to ensure structural integrity and durability. Preparation of Materials

Before welding, clean the metal surfaces thoroughly to remove rust, paint, oil, or oxidation, as contaminants can weaken the weld and cause porosity . Use an angle grinder or wire brush to smooth the edges. For mitered corners, grind the edges to ensure a flush fit, which allows for a uniform weld and prevents gaps . Accurate cutting at the correct angle (typically 90 degrees for standard corners) is essential to maintain proper alignment and structural strength .

Alignment and Fit-Up

Position the corner pieces carefully using a square or measuring tools to ensure the pieces meet at the intended angle . Clamp the sections securely to prevent movement during welding. For thicker materials, consider using a backing plate or full penetration weld to enhance strength . Proper fit-up reduces the risk of burn-through on thin materials and ensures consistent weld penetration on thicker trays.

Welding Technique

Select a welding method compatible with the tray material, such as MIG, TIG, or Stick welding . Begin with tack welds at key points to hold the pieces in place. Then, weld along the edges in a continuous, uniform bead, maintaining consistent heat and speed to avoid weak spots . For open corner joints, the gap allows deeper penetration, while closed joints require precise control to prevent undercuts . Multiple passes may be necessary for thicker trays to achieve full fusion.

Post-Weld Inspection and Finishing

After welding, inspect the joints for gaps, cracks, or weak spots . Remove slag or residue using a wire brush or grinder. Check that the welded corner can bear the required load and that the alignment remains correct. Apply anti-corrosion coatings if necessary to extend the lifespan of the cable tray system . Proper inspection ensures both safety and compliance with industrial standards.

Key Tips

- Use appropriate safety gear including gloves, helmet, and protective clothing.
- Ensure welding equipment settings match the tray material thickness.
- Avoid rushing; patience and precision are critical for strong, clean corner welds .
- For industrial installations, consider portable welding kits for on-site work to maintain consistency . By following these steps—preparation, alignment, controlled welding, and thorough inspection—you can achieve strong, durable, and visually clean corner welds for cable tray systems, ensuring both structural stability and long-term reliability.

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For practice, beginners often use mild steel plates around 3 mm thick, which balance strength with ease of welding

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