



Use full-strength welds.

Fig. 18-44 Castor frame.

TABLE 18-5 Rule-of-thumb fillet weld sizes where the strength of the weld matches the plate.

| Dimensions in Inches | | | | Dimensions in Millimeters | | | |
|----------------------|--------------------|---------------------------|---------------------------|---------------------------|--------------------|---------------------------|---------------------------|
| Plate Thickness | Strength Design | Rigidity Design | | Plate Thickness | Strength Design | Rigidity Design | |
| | Full-strength Weld | 50% of Full-strength Weld | 33% of Full-strength Weld | | Full-strength Weld | 50% of Full-strength Weld | 33% of Full-strength Weld |
| Up to .25 | .12 | .12 | .12 | Up to 6 | 3 | 3 | 3 |
| .25 | .19 | .19 | .19 | 6 | 5 | 5 | 5 |
| .31 | .25 | .19 | .19 | 8 | 6 | 5 | 5 |
| .38 | .31 | .19 | .19 | 10 | 8 | 5 | 5 |
| .44 | .38 | .19 | .19 | 11 | 10 | 5 | 5 |
| .50 | .38 | .19 | .19 | 12 | 10 | 5 | 5 |
| .56 | .44 | .25 | .25 | 14 | 11 | 6 | 6 |
| .62 | .50 | .25 | .25 | 16 | 12 | 6 | 6 |
| .75 | .56 | .31 | .25 | 20 | 14 | 8 | 6 |
| .88 | .62 | .38 | .31 | 22 | 16 | 10 | 8 |
| 1.00 | .62 | .38 | .31 | 25 | 16 | 10 | 8 |
| 1.12 | .88 | .44 | .31 | 28 | 22 | 11 | 8 |
| 1.25 | 1.00 | .50 | .31 | 32 | 25 | 12 | 8 |
| 1.38 | 1.00 | .50 | .38 | 35 | 25 | 12 | 10 |
| 1.50 | 1.12 | .56 | .38 | 38 | 28 | 14 | 10 |