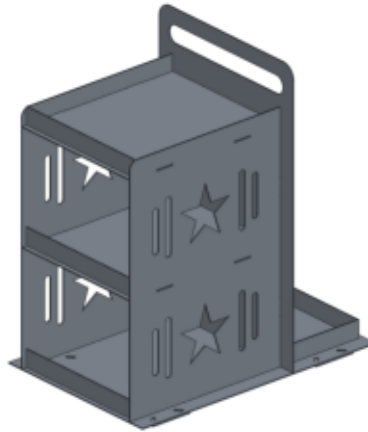
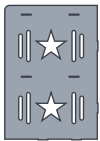


Lone Star Weld Cart, 30 in

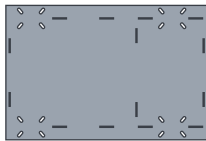


A rolling cart for a MIG welder and one gas bottle that you weld yourself. Sixteen laser-cut 10 ga steel parts lock together with tabs and slots: a two-shelf body with a push handle, and a base that carries the bottle deck and takes four 4 in plate casters.

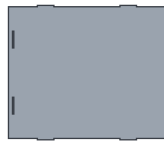
What's in the box



Side panel x2
Part WC30-01



Base x1
Part WC30-02



Shelf x2
Part WC30-03



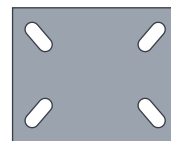
Back wall x1
Part WC30-04



Lip strip x4
Part WC30-05



Deck cheek x2
Part WC30-06



Caster pad x4
Part WC30-07

What you'll need

- MIG or flux-core welder (a 120 V machine handles 10 ga)
- Angle grinder with a flap disc
- Clamps and a framing square
- Rubber mallet and a flat file
- Wrenches for the caster bolts
- Four 4 in plate casters rated 150 lb or more each, two with brakes (not included)
- Sixteen 3/8 in (or 5/16 in) bolts, 1 in long, with nuts and washers (not included)
- Two chains with snap hooks, about 30 in each, for the gas bottle (not included)
- Welding helmet, gloves, jacket and safety glasses

Lone Star Weld Cart, 30 in

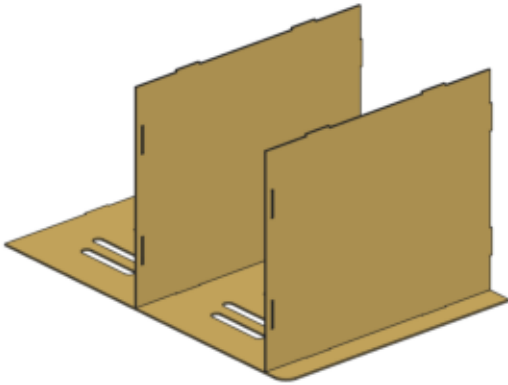
1

Lay down a side panel and stand the shelves in it

On a flat floor, lay one side panel down with its rounded corner at the front top. Stand both shelves in its two rows of slots, tabs down, lip slots at the front.

TIP

The shelves are identical; either one goes in either row.



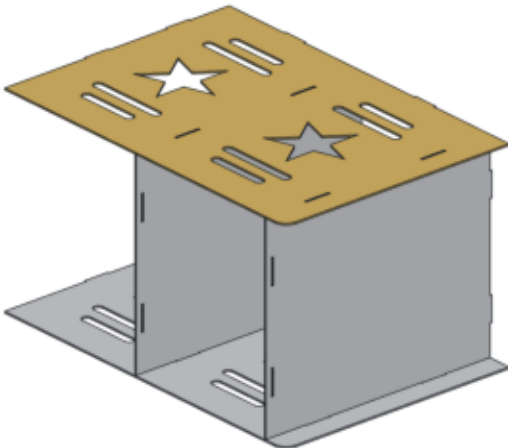
2

Close the box with the other side panel

Lower the second side panel onto the shelf tabs, rounded corner at the front top, so all four tabs come through its slots. Tap it down evenly with a mallet.

TIP

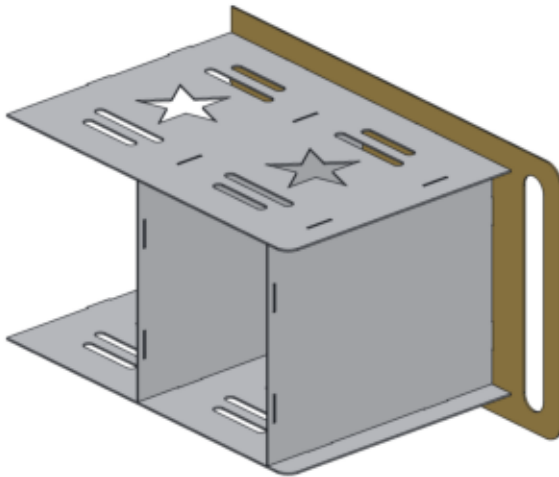
Both side panels go on the same way round. If the rear tabs point the wrong way, turn the panel end for end.



Lone Star Weld Cart, 30 in

3

Add the back wall



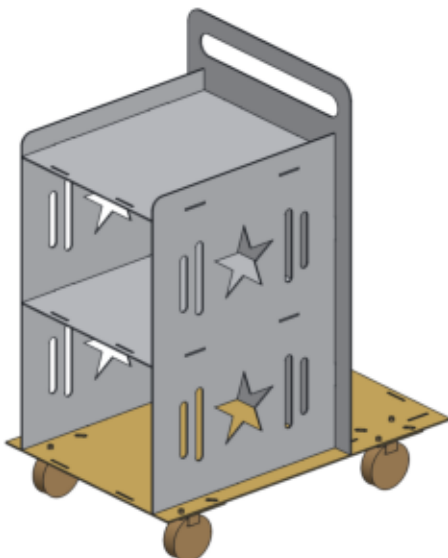
Slide the back wall onto the rear tabs of both side panels and both shelves, handle at the top. Clamp it, check the box with a square at the front corners, then tack every tab of the body.

TIP

Tack lightly and on alternate corners so the box stays square.

4

Put the casters on the base and set the body on it



Turn the base over. At each corner, lay a caster pad over the four slots and bolt a 4 in plate caster through the pad and the base: four bolts per caster, nuts and washers on the inside. Put the two braked casters at one end. Turn the base right side up and lock the brakes. Then stand the body up and lower it onto the base, back wall over the slots 19-1/2 in from the front, so the bottom tabs drop through. Tack them from underneath.

TIP

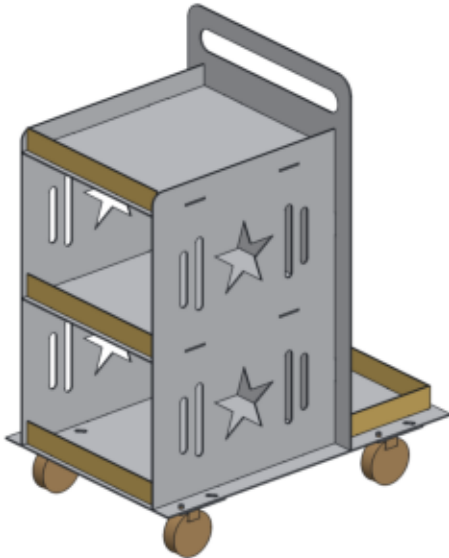
The caster slots run diagonally and fit either common hole pattern; slide each bolt to the end that matches your casters.

The body weighs about 70 lb. Get a helper, or tip it onto the base from the front edge.

Lone Star Weld Cart, 30 in

5

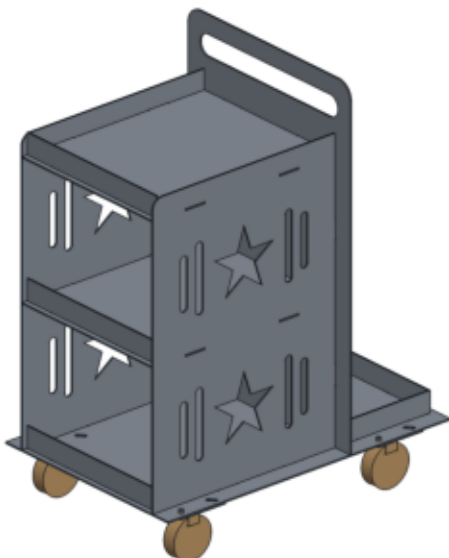
Add the lips and the bottle deck



Drop a lip strip into the slots at the front of the base and of each shelf. Drop the fourth into the slots at the rear of the deck, then the two cheeks into the deck's side slots so they meet the fence and the back wall. Tack them all.

6

Weld it out



Weld the side panels to the shelves, back wall and base with short stitch welds, alternating sides so the heat spreads evenly. Weld the lip strips, the deck fence and cheeks, and the caster pads. Grind the tabs flush where they show.

TIP

Weld the shelf tabs from outside the side panels and the back-wall tabs from behind, where the joints are easy to reach.

Remove the casters before welding the pads, or shield the wheels from spatter.

Lone Star Weld Cart, 30 in

Finishing

- The parts ship bare with a light oil film. Wipe them down with a degreaser before welding.
- Grind off spatter, then paint with any enamel or rattle-can paint; the cart doesn't get hot.
- Paint the shelves too, or leave them bare with a coat of oil; a rubber mat on the top shelf keeps the welder from sliding.

Safety

- Chain the gas bottle at both chain heights before you roll the cart, and never move it with the bottle loose.
- Load: one welder up to about 100 lb on the top shelf and one bottle up to 125 cu ft. Keep heavy spools on the lower shelves.
- Lock the caster brakes before loading the bottle or working at the cart.
- Roll it slowly over door sills and cords; a cart with a full bottle is top-heavy.
- Weld in a ventilated area cleared of anything that can burn, with a helmet, gloves and long sleeves.

This is a kit of raw steel parts. You build the finished product, and the quality of your welds and your judgment about where and how you use it are yours. Weld with proper ventilation and protective gear.