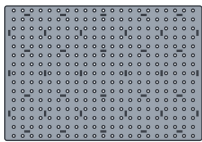


Lone Star Weld Table, 30 x 44 in



A 30 x 44 in welding table you build yourself on its own flat top. Seventeen laser-cut 3/16 in steel parts: a one-piece top with 315 clamp holes (16 mm, 2 in grid), a locked rib grid that never blocks a hole, and Lone Star end frames for legs. Every joint is tab and slot.

What's in the box



Top x1

Part WT44-01



Long rib x4

Part WT44-02



Cross rib x4

Part WT44-03



End frame x2

Part WT44-04



Stretcher x2

Part WT44-05



Foot pad x4

Part WT44-06

What you'll need

- MIG or flux-core welder (3/16 in steel; a 120 V machine works with multiple passes)
- Angle grinder with a flap disc and a grinding wheel
- Rubber mallet, framing square and a 4 ft straightedge
- A helper for flipping the table
- Welding helmet, gloves, jacket and safety glasses

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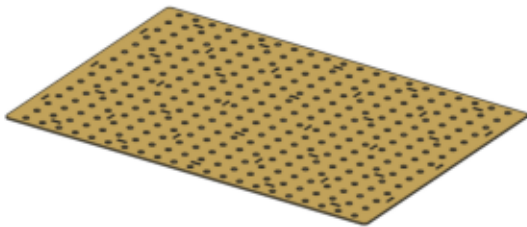
1

Lay the top face down

Lay the top face down on a flat concrete floor covered with cardboard, or on a flat bench. The top is your jig: everything else seats against it, so the work surface comes out flat.

TIP

It takes two people to move the top. Keep it flat; don't stand it on an edge.



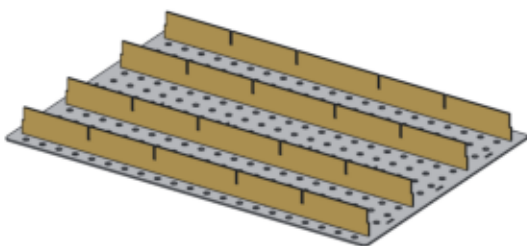
2

Stand the four long ribs

Push each long rib's tabs into a row of long slots, notches facing up (away from the top). The two outer rows are the side skirts. All four ribs are identical.

TIP

Tap each rib down with a mallet until it sits on the plate along its whole length.

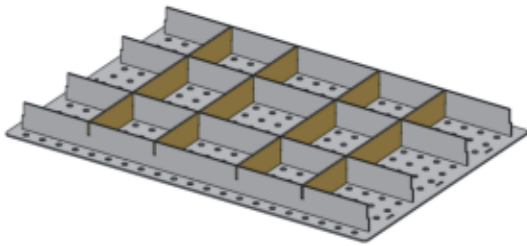


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3

Drop in the four cross ribs

Lower each cross rib into its row of short slots so its notches slide down over the long ribs where they cross. The ribs now lock each other square.



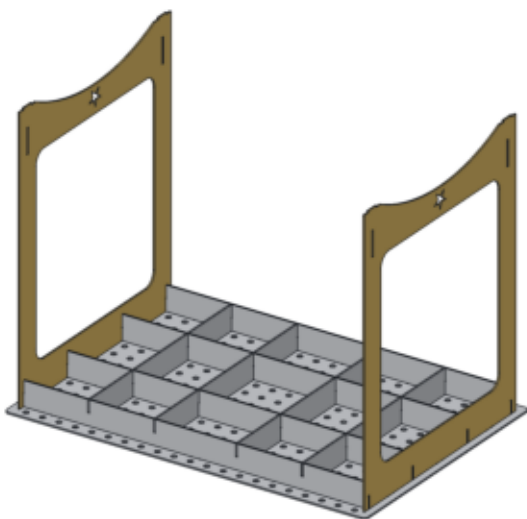
4

Drop on the end frames

Lower each end frame into the slots at the ends of the top, legs up, so its notches drop over the half-height ends of the long ribs.

TIP

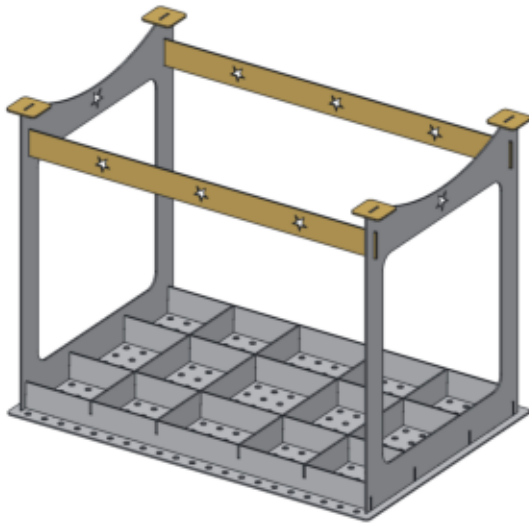
The frame is tall; have a helper hold it upright until the stretchers are in.



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5

Slide in the stretchers and set the feet



Slide each stretcher through the slot in one end frame's leg and on into the matching slot in the other. Drop a foot pad over the tab at the end of each leg.

6

Tack, flip and weld



Tack every rib crossing, the rib ends to the end frames, the stretchers and the foot pads. Flip the table onto its feet with a helper. Weld the top's tabs from above in short welds, starting at the center and working out, jumping around so no area gets hot. Grind the tabs flush.

TIP

Check the top with a straightedge as you go; if an area pulls, move to the far side of the table and let it cool.

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Finishing

- The parts ship bare with a light oil film. Degrease the frame before welding; leave a light film on the top to slow rust.
- Grind the top's tabs flush and dress the edges.
- Paint the frame and legs if you like, but keep paint off the top: the ground clamp needs bare steel.
- Wipe the top with paste wax or a light oil now and then to keep surface rust down.

Safety

- The finished table weighs about 164 lb. Lift with a helper and keep feet clear when flipping it.
- Clamp the ground lead to the table or the work, never to the legs' paint.
- Keep the area under the table clear of anything that can burn; spatter falls through the clamp holes.

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.