

## TECH TIP: FUEL BUNG WELDING

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Use the following tools to weld fuel cap bungs to aluminum fill necks and tanks to prevent the bung from cooling out of round after welding. By using these tools, a shorter, lighter bung can be used on the tank, and the fill caps will fit perfectly.

Part number: M-3300-T      Description: M-3300-B WELD TOOL  
Used to weld the 3” bung

Part number: M-3201-T      Description: M-3201-B WELD TOOL  
Used to weld the 2 3/4” bung

Place the Weld Tool, small end up into the filler neck. Place the bung to be welded on the small end of the Weld Tool. Use about 150 amps on welder because the Weld Tool is a “heat sink” and it will require more heat to weld.

Turn the filler neck, Weld Tool, and bung upside down on the table. Make sure the filler neck is sitting level on the bung. Tack the bung in 4 spots making sure the filler neck sits level on the bung after each tack.

Step weld the filler neck to the bung with the Weld Tool inside the filler neck and bung, this will prevent the bung from cooling out of round.

Wait for part to cool before pushing the Weld Tool out. Dress the weld down to finish the filler neck and bung assembly.

You can also use the tools when installing the bung only in a tank without the filler neck. In this case set the bung into the hole in the tank and insert the Weld Tool small end first down into the bung. Tack and weld bung in place as stated above. Again, this will keep the bung from cooling out of round, allowing the filler cap to still fit perfectly!

Call for price and availability on weld tools.