



◀ ANDY WEYENBERG

Andy Weyenberg began welding at his father's business a few years before joining the Army. After going to school for Electro-Mechanical, he started working for Miller Electric Mfg. LLC as a technical service rep and training instructor. Andy has built and raced stock cars since he was a teenager — and now builds high-performance street vehicles while also managing the Miller motorsports program.

SKILL LEVEL: Advanced
TIME COMMITMENT: 8-10 hours

/ TOOLS AND MATERIALS



Multitatic® 220 AC/DC
multiprocess welder



Spectrum® 625 X-TREME™ plasma cutter,
Spectrum 375 X-TREME plasma cutter or
hole saw



4' x 8' sheet of 1/8" 5052 aluminum



36" 1x1x1/8" 6061 aluminum
square tubing (4)



Bandsaw (plasma cutter, jigsaw or
reciprocating saw will do)



Miter band saw



Variety of
c-clamps



Small flat disc, flap wheel grinder
or belt sander



3/32" 5356 filler metal



.035" 4943 aluminum wire
(when using your spool gun)



Protractor



Duct tape

WARNING: READ AND FOLLOW ALL LABELS AND THE OWNER'S MANUAL.

ELEPHANT STANDS

If your lift is occupied or you don't have one, learn how to make elephant stands. These taller wheel stands not only look like circus elephant stands but they will support and keep your vehicle elevated for you to work on.



AS SEEN ON REAL GARAGE
[YouTube.com/RealGarageWithAndy](https://www.youtube.com/RealGarageWithAndy)

STEP BY STEP

STEP
1



Cut five 19" x 48" pieces of your 4' x 8' sheet of 5052 aluminum and then trim four of them to 35". Save all the drop-off from this sheet. Everything will be used.

STEP
2



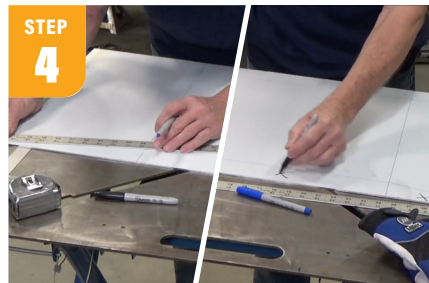
Measure and cut the last 19" x 48" piece into four pieces. If you choose to bend two of your sides, cut them 10-1/16" x 19" to compensate for the bend radius. If you choose to cut and weld all sides separately, cut them to 10" x 19". Remember to cut your extra/drop-off pieces to the exact same measurement.

STEP
3



On your 35" pieces, mark 10" in on both ends. Then from your 10" lines, mark 2", giving you 15" between the lines.

STEP
4



Take your ruler and mark the outside corners of the 19" sides to your 2" marks, creating an angle. Then draw a straight line between each 2" mark on the 10" lines. These are your cut lines encompassing two sides and the top of the elephant stand.

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STEP 5
Use your bandsaw, reciprocating saw or jigsaw to cut the pieces out.



STEP 6
Take your 10" x 19" side pieces and mark 2" in from each corner of the top 19" sides. Using your ruler, draw a line from the 2" marks to the bottom corners and cut it off. You should now have 15" length on the top side and 19" on the bottom.



STEP 7
Take your Spectrum 625 or 375 X-TREME plasma cutter and cut holes, which will allow the stand to weigh less and make it easier to carry. I cut a 3-1/4" hole in the middle and one 2-1/4" hole on each side, centered on the plate. A hole saw would also work but it would be much slower.



STEP 8
Debur and clean the holes using a small flat disc, flap wheel grinder or belt sander. Then slightly round the top corners of the side plates.



STEP 9
Using your metal bending tool or brake, bend the sides of the stands at the 15" marks to about 78 degrees.



STEP 10
Place your sides along the stand without fully overlapping the pieces. Once you have a good fit, use duct tape to help hold the seams together. Remember to remove the tape quickly after tack welding and use acetone to get rid of any tape residue.



STEP 11
Using your Multimatic 220 AC/DC, start welding the top joint and then the sides. I'm using 3/32" ER-5356 filler metal and the machine is set to 120 amps, 90 Hertz on frequency and 72% on balance.



STEP 12
Be sure to put a 2" weld on the bottom inside corners.



STEP 13
Using your miter band saw set at 12 degrees, cut and fit two pieces of the 1" x 1" square tubing to fit under the top. Mine measured 15-5/16" long. If you formed your sides in a brake, like I did, you will need to grind a round edge on each end of the square tubing to have clearance and fit inside the corner bends.



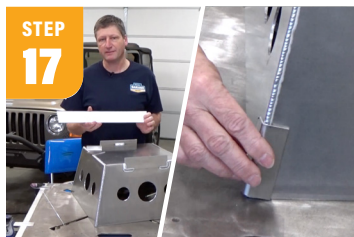
STEP 14
Place your square tubing inside and centered about 6" from the sides of the stand. Clamp them in tightly against the top plate and either TIG weld into place or use a spool gun. They don't have to be welded solid. I did three 2" to 3" welds on both sides of each tube and the ends.



STEP 15
Using the 8" x 19" drop-off piece, measure and cut eight pieces of 2-1/4" x 8". These will be tire stops in case the vehicle rolls on the stands.



STEP 16
Weld the stops extended halfway over the top (1" to 1-1/8"). Put a 2" to 3" weld on the inside and then weld the outside corners.



STEP 17
Finally, the last drop-off of your 4' x 8' sheet is about 3" wide, so cut 16 2" x 3" pieces and bend them in half at a 90-degree angle. Once welded on, make sure no welds extend past the bottom edge. Grind or file them flush if needed.



STEP 18
These elephant stands can hold up to 4,000 pounds. Be sure to know your vehicle weight, and use thicker material for heavier projects.



To get the latest welding project in your inbox, sign up for the Miller DIY newsletter.

millerwelds.com/resources/newsletters

