

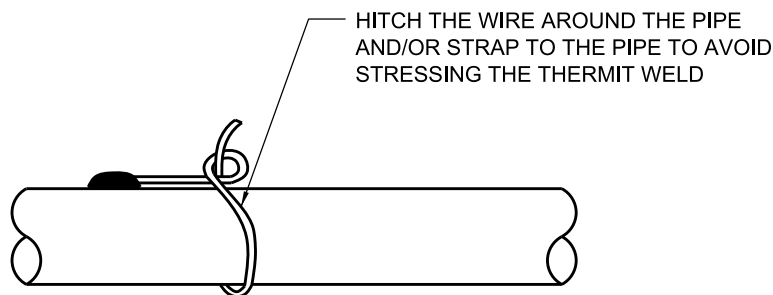
THERMITE WELDING PROCEDURE

PIPE SURFACE PREPARATION

1. CUT A 100 mm x 100 mm SQUARE IN PIPE COATING, USING A SHARP KNIFE TO EXPOSE BARE METAL.
2. FILE A 60 mm x 60 mm AREA UNTIL PIPE METAL IS BRIGHT.
3. WIPE PREPARED SURFACE DRY AND CLEAN.

THERMITE WELDING PROCEDURE

1. SCRAPE CRUCIBLE AND MOULD WITH SMALL IMPLEMENT TO REMOVE OLD SLAG DEPOSITS.
2. INSERT SMALL TIN DISC IN BOTTOM OF CRUCIBLE.
3. REMOVE CAP OF CARTRIDGE AND DUMP (NOT POUR) CONTENTS INTO THE CRUCIBLE, TAPPING THE BOTTOM OF THE CARTRIDGE TO ENSURE THE FINE STARTING POWDER IS ALL IN THE CRUCIBLE.
4. PLACE THE MOULD OVER THE PREPARED SURFACE AND INSERT THE CABLE AS SHOWN.
5. CLOSE THE COVER-INSERT FLINT GUN AND FIRE CHARGE, REMOVING GUN QUICKLY TO AVOID FOULING.
6. DO NOT REMOVE MOULD UNTIL WELD IS DULL RED.
7. REMOVE MOULD - KNOCK OFF SLAG SPRUE WITH EDGE OF FILE.
8. TAP WELDMENT SMARTLY WITH FILE TO ENSURE METALLURGICAL BOND.
9. CLEANED WATERMAIN SURFACE, WELD, AND EXPOSED COPPER WIRE TO BE COATED WITH MASTIC.
10. LEAVE SEVERAL COILS OF WIRE CLOSE TO CONNECTION POINT TO PROVIDE STRAIN RELIEF DURING BACKFILLING.



TYPICAL THERMITE WELD

All dimensions are in millimetres unless otherwise shown.



ENGINEERING AND CONSTRUCTION SERVICES STANDARD DRAWING

REV 2

APR 2013

THERMITE WELDING OF METALLIC WATERMAINS

T-1106.02

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SHEET 1