| THERMITE WELD MATERIALS (ERICO PRODUCTS)				
PIPE	BOND CABLES		TEST CABLES	
SIZE	WELDER NO.	CARTRIDGE	WELDER NO.	CARTRIDGE
150mm TO 300mm	CAFSA-2CB	CA-32	CA HAA-1G	CA-15

THERMITE WELDING PROCEDURE

1. SCRAPE CRUCIBLE AND MOULD WITH SMALL IMPLEMENT TO REMOVE OLD SLAG DEPOSISTS.

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.
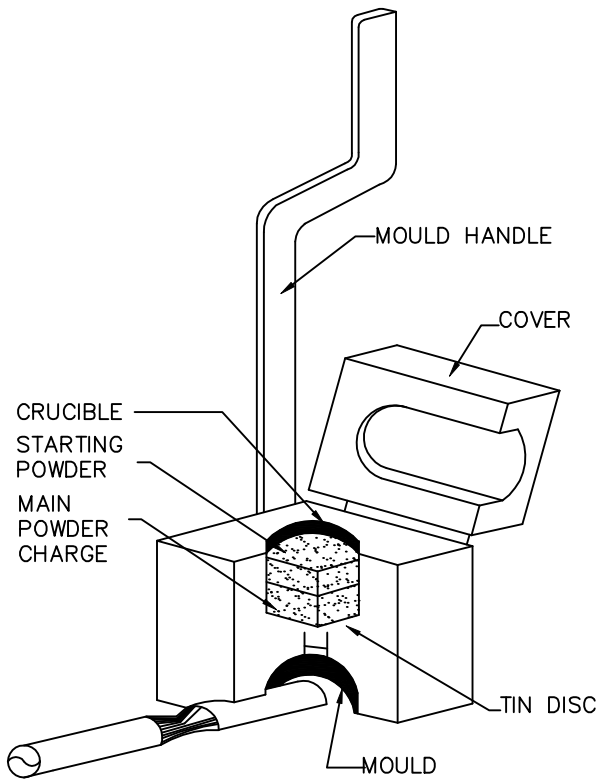
PIPE SURFACE PREPARATION

1. CUT A 100mm x 100mm SQUARE IN PIPE COATING, USING A SHARP KNIFE TO EXPOSE BARE METAL.

2. FILE A 50mm x 50mm AREA UNTIL PIPE METAL IS BRIGHT.

3. WIPE PREPARED SURFACE DRY AND CLEAN.

THERMITE WELDING PROCEDURE
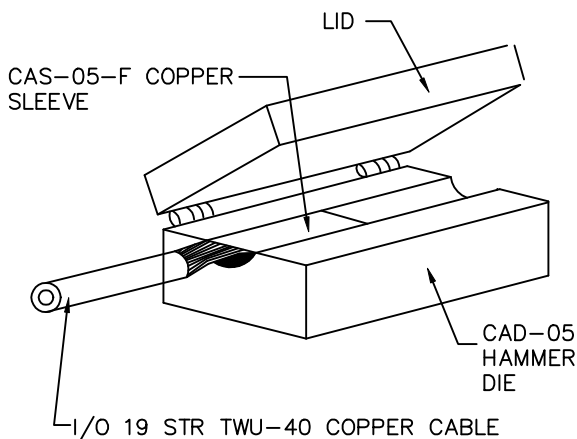
1. CUT I/O 19 STR. TWU-40 COPPER CABLE TO LENGTH REQUIRED.

2. PLACE CAS-05-F SLEEVE ON END OF CABLE.

3. INSERT SLEEVE INTO HAMMER DIE (AS SHOWN) CLOSE LID AND STRIKE LID WITH HAMMER.

4. REPEAT AT OTHER END OF CABLE.

COPPER CABLE BOND FABRICATION

METRIC
ALL DIMENSIONS SHOWN HERE ARE IN MILLIMETRES UNLESS OTHERWISE NOTED

APPROVED BY

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EXECUTIVE DIRECTOR TECHNICAL SERVICES

SCALE
N.T.S.

DATE: JUNE, 2001

REVISED:

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TORONTO
Works and Emergency Services

THERMITE WELDING OF METALLIC WATERMAINS