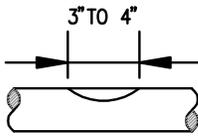
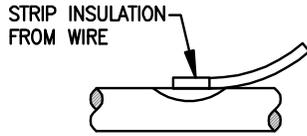


EXOTHERMIC WELDING PROCEDURES

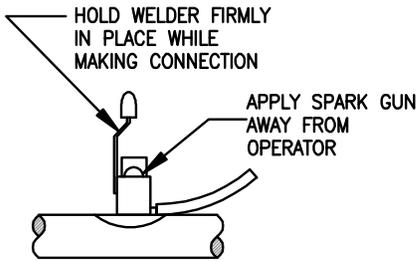
REMOVE PIPELINE COATING—
FILE PIPE TO BRIGHT METAL
AND DRY ANY MOISTURE
WITH A TOWEL



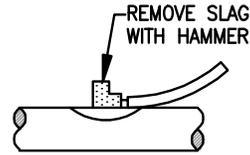
STEP 1



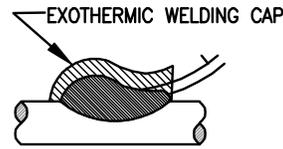
STEP 2



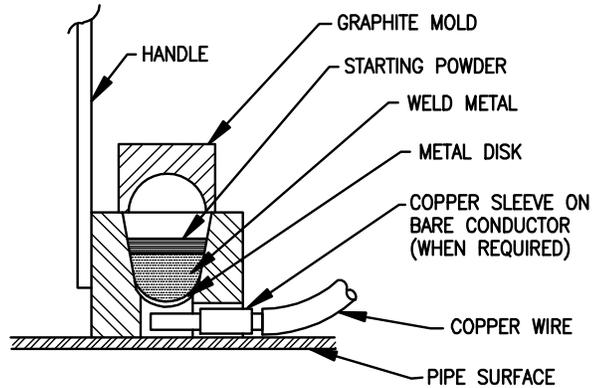
STEP 3



STEP 4



STEP 5



GENERAL WELDING PROCEDURE

1. WHEN USING #10 TO #14 AWG SOLID WIRE, IT WILL BE NECESSARY TO INSTALL A COPPER SLEEVE OF ADEQUATE SIZE OVER THE BARE END OF THE WIRE AND CRIMP IN PLACE BEFORE ATTEMPTING TO MAKE THE CONNECTION. THE WIRE SHOULD PROTRUDE AT LEAST 1/8" FROM THE END OF THE SLEEVE.
2. INSERT THE CONDUCTOR INTO MOLD NOTING ANY SPECIAL INFORMATION UNDER "POSITIONING" FOR APPLICATION TYPE IN THE MANUFACTURER'S INSTRUCTIONS PACKAGED WITH THE WELDER.
3. INSERT STEEL DISK IN BOTTOM OF CAVITY INSIDE MOLD. DUMP THE WELD METAL INTO MOLD, BEING CAREFUL NOT TO UPSET THE STEEL DISK. TAP THE BOTTOM OF THE TUBE TO LOOSEN ALL THE STARTING POWDER AND SPREAD IT EVENLY OVER THE WELD METAL. PLACE A SMALL AMOUNT OF STARTING POWDER ON THE TOP EDGE OF MOLD UNDER COVER OPENING FOR EASY IGNITION.
4. CLOSE COVER AND IGNITE WITH THE FLINT GUN. MOVE FLINT GUN AWAY QUICKLY TO PREVENT FOULING OF THE FLINT GUN.
5. AFTER IGNITION, HOLD THE WELDER IN PLACE FOR A MOMENT TO ALLOW THE WELD TO SOLIDIFY. AFTER THE WELD HAS COOLED, REMOVE THE SLAG AND TEST THE CONNECTION BY TAPPING WITH A CHIPPING HAMMER.
6. COAT THE CONNECTION, EXPOSED COPPER WIRE, AND THE ENTIRE PREPARED SURFACE. COVER WITH AN EXOTHERMIC WELDING CAP.
7. REMOVE ALL SLAG FROM THE WELDER BEFORE MAKING WELD. CLEAN THE COVER AND MOLD AFTER EVERY WELD.
8. WET OR DAMP MOLDS WILL PRODUCE POROUS WELDS. MOLDS MUST BE DRIED OUT BEFORE ATTEMPTING TO WELD.
9. UNSUCCESSFUL WELDS ARE TO BE ABANDONED AND MOVED TO ANOTHER PREPARED SURFACE NOT LESS THAN 3" AWAY OR COMPLETELY GRIND OFF UNSUCCESSFUL WELD.

ISSUED:		STANDARD DETAIL		DETAIL NO.
6/97		EXOTHERMIC WELDING		SD-703
REVISED:				
10/08				