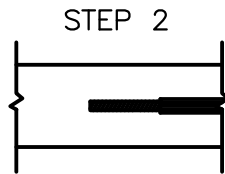
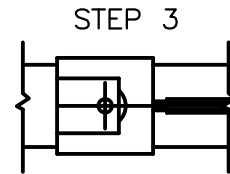


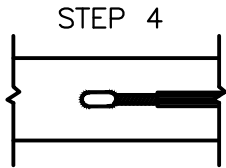
FILE SURFACE TO BRIGHT METAL AND CLEAN



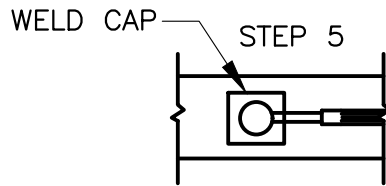
STRIP INSULATION FROM WIRE



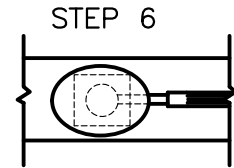
HOLD WELDER FIRMLY WITH OPENING AWAY FROM OPERATOR AND IGNITE STARTING POWDER



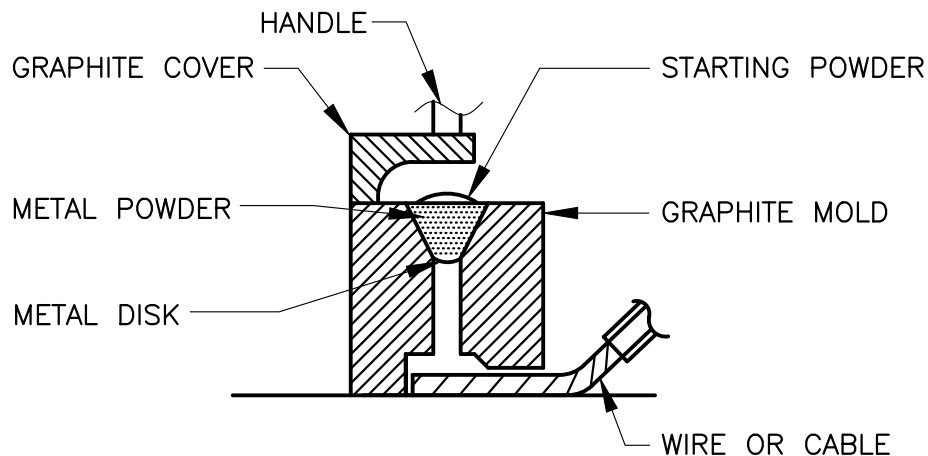
REMOVE SLAG FROM CONNECTION (SEE NOTE 4)



APPLY 2 COATS PRIMER AND COVER CONNECTION WITH PRE-FORMED WELD CAP



COVER COMPOUND WITH BITUMINOUS COMPOUND



WELDER SECTION A-A

NOTES:

1. WELDER SHOWN IS FOR HORIZONTAL SURFACES. FOR VERTICAL SURFACES, SIDEWELDER IS REQUIRED.
2. ATTACH ONE (1) WIRE PER WELD. ALL WIRE WELDS SHALL BE 3" APART MINIMUM.
3. ALL EXPOSED METAL (STRUCTURE, WIRE AND WELD) SHALL BE COVERED WITH TWO (2) COATS OF PRIMER AND AN ELASTOMERIC WELD CAP, THEN OVER-COATED WITH BITUMINOUS COMPOUND OVERLAPPING PIPE COATING BY 2" MINIMUM.
4. ALL WELDS SHALL BE TESTED BY STRIKING THE WELD WITH A TWO (2) POUND HAMMER WHILE PULLING FIRMLY ON THE WIRE. ANY WELDS BROKEN OR LOOSENED SHALL BE RE-WELDED AND RE-TESTED. THE SURFACE MUST BE RE-GROUND AND CLEAN BEFORE RE-WELDING. ALL WELD SLAG SHALL BE REMOVED FROM THE WELD.

REVISION	BY	APPR	DATE

PARAG KALARIA R.C.E. 83927 DATE

EXOTHERMIC WELD

STD. DWG. NO.
CP-6