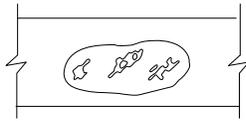
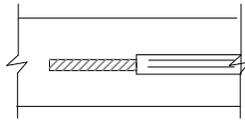


STEP 1



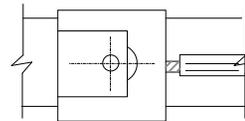
FILE SURFACE TO BRIGHT METAL AND CLEAN.

STEP 2



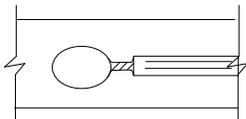
STRIP INSULATION FROM WIRE.

STEP 3



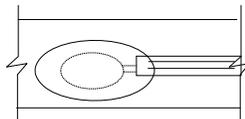
HOLD WELDER FIRMLY WITH OPENING AWAY FROM OPERATOR AND IGNITE STARTING POWDER.

STEP 4

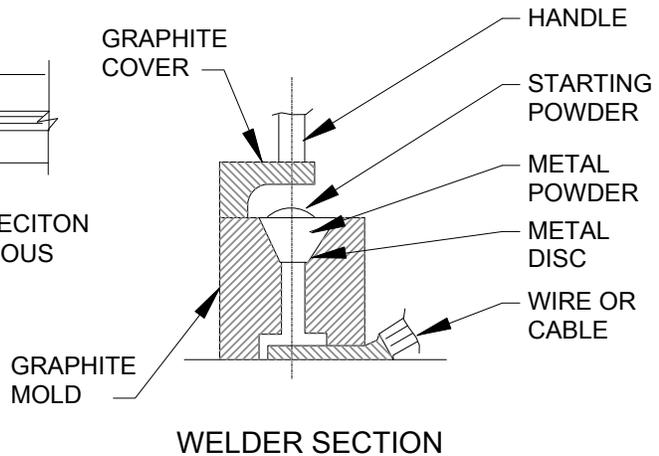


REMOVE SLAG FROM CONNECTION.

STEP 5



COVER CONNECITON WITH BITUMINOUS COMPOUND.



NOTES:

1. WELDER SHOWN IS FOR HORIZONTAL SURFACES, FOR VERTICAL SURFACES, SIDE WELDER IS REQUIRED.
2. ALL WIRE WELDS SHALL BE 6 INCHES APART MINIMUM.
3. ALL EXPLOSED METAL (STRUCTURE, WIRE AND WELD) SHALL BE COATED WITH BITUMINOUS COMPOUND PRIOR TO COATING REPAIR AND BACKFILLING.
4. STANDARD WELD CARTRIDGES SHALL BE USED FOR STEEL SURFACES.



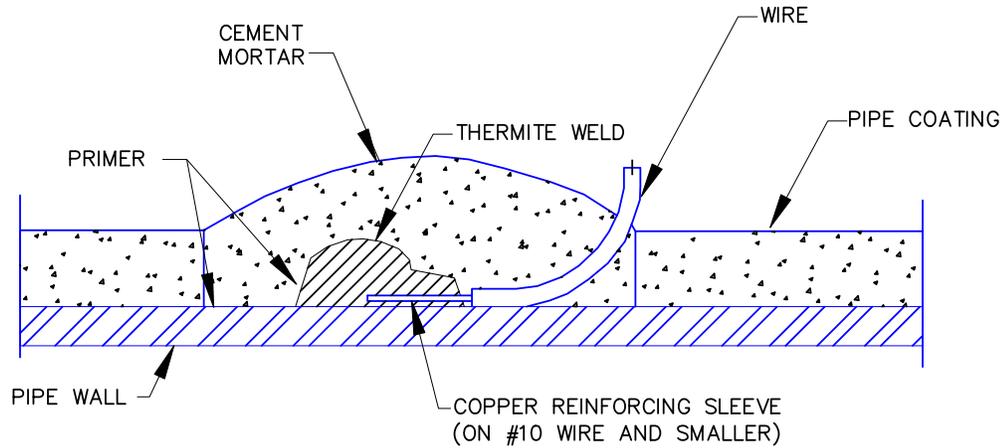
APPROVED DATE: January 1, 2011

DIRECTOR OF ENGINEERING

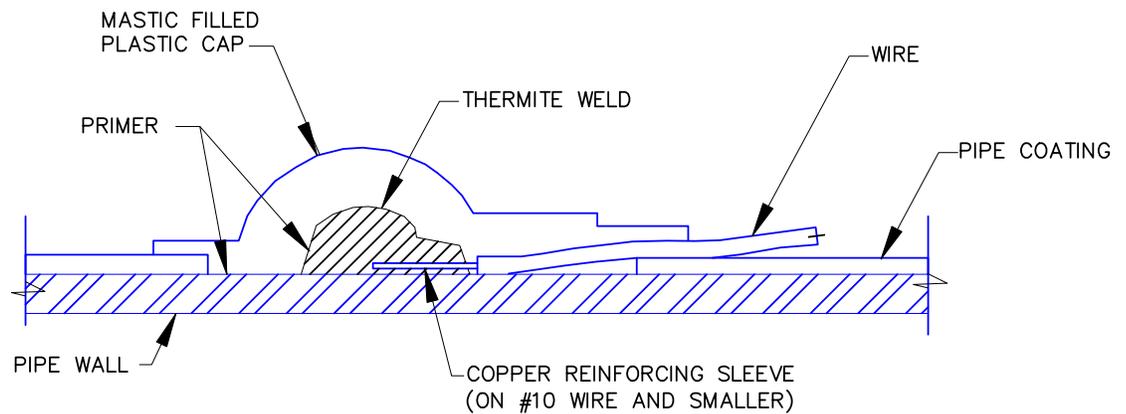
STANDARD DRAWING
ALUMINO - THERMIC WELD DETAIL

STD. DWG. NO.

W-0840p1



C.M.L. & C. PIPE



DIELECTRIC COATED PIPE

NOTES:

1. THERMITE WELD ALLOY SHALL BE SUITABLE FOR TYPE OF PIPE METAL (ie. STEEL OR IRON).
2. CLEAN PIPE TO BRIGHT METAL WITH FILE OR GRINDER.
3. WELD WIRE TO PIPE FOLLOWING WELD MANUFACTURER'S DIRECTIONS.
4. STRIKE SIDE OF WELD SOLIDLY WITH A 16 OZ. OR LARGER HAMMER TO TEST WELD.
5. REMOVE FLUX AND COAT WITH PRIMER.
6. RECOAT WITH MORTAR FOR CML&C PIPE AT JOINT ENCASE IN FIELD APPLIED MORTAR.
7. INSTALL MASTIC-FILLED PLASTIC CAP FOR DIELECTRIC COATED PIPE.



APPROVED DATE: January 1, 2011

Joseph P. Resuly

DIRECTOR OF ENGINEERING

STANDARD DRAWING
THERMIC WELD DETAIL

STD. DWG.
NO.

W-0840p2