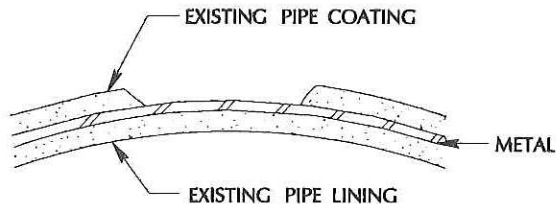
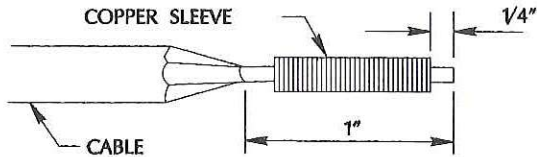


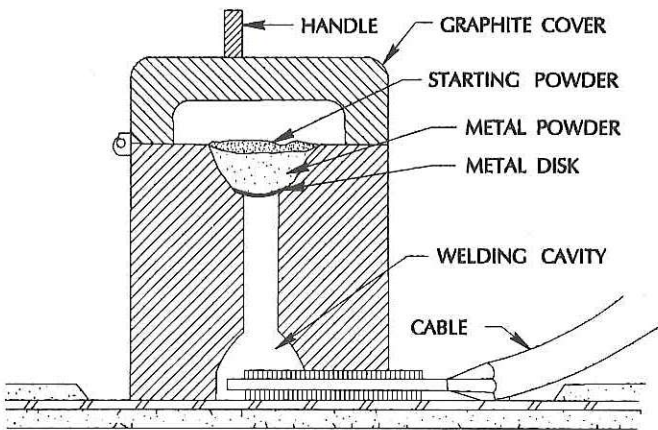
WELDING INSTRUCTIONS



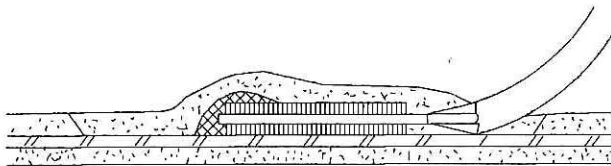
STEP 1



STEP 2



STEP 3



STEP 4

STEP 1

REMOVE EXISTING COATING AND CLEAN PIPE TO WHITE METAL WITH FILE GRINDER OR METAL RASP.

STEP 2

REMOVE INSULATION, SLIP ON COPPER SLEEVE AND CRIMP.

STEP 3

INSTALL CABLE AS SHOWN. PLACE POWDER IN MOLD AND CLOSE COVER. IGNITE WITH FLINT GUN AND HOLD WELD MOLD IN POSITION FOR 10 SECONDS.

STEP 4

REMOVE SLAG AND TEST WELD WITH SHARP HAMMER BLOW. REPLACE COATING ON MAIN & COAT WELD AND BARE COPPER WITH 1/4" MIN. COATING OF SAME MATERIAL OR WITH 10 MIL PVC TAPE, HALF- LAPPED.

WELDING SPECIFICATIONS-

CADWELD

CONDUCTOR- #10 OR #12 SOLID	STEEL OR DUCTILE IRON	CAST IRON
WELDER	CAM-108	CAHBA-1G
SLEEVE	CA-26180	CA-26180
CARTRIDGE	CA15-F33	CA25-XF19

CONDUCTOR- #8 STRANDED	STEEL OR DUCTILE IRON	CAST IRON
WELDER	CAM-109S	CAHBA-1L
SLEEVE	CAS-421	CAS-421
CARTRIDGE	CA15-F33	CA45-X519

APPROVED BY

Wah

DATE

4-2-90

**CABLE TO PIPE
EXOTHERMIC WELD**

DEPARTMENT OF PUBLIC WORKS



DRAWING
NO.

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