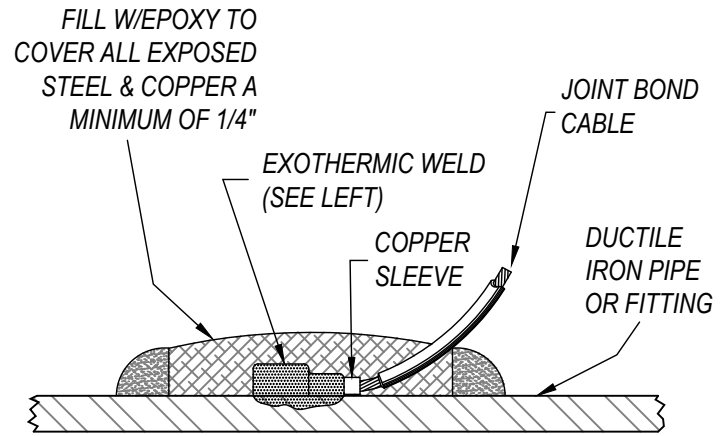


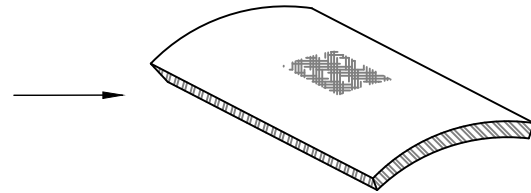
**EXOTHERMIC WELD**



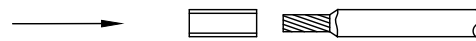
**CABLE-TO-PIPE CONNECTION**

**EXOTHERMIC WELD PROCEDURE**

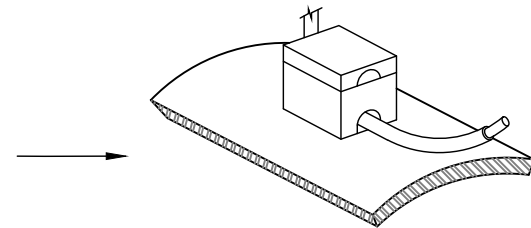
**STEP 1.** FILE STRUCTURE CONNECTION AREA TO BARE SHINY METAL AND CLEAN.



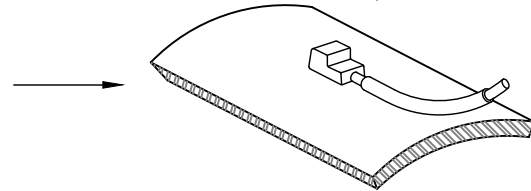
**STEP 2.** STRIP INSULATION FROM WIRE. ATTACH SLEEVE REQUIRED ON #6 AWG WIRE OR SMALLER.



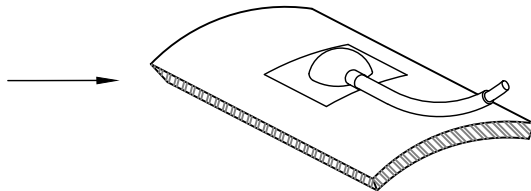
**STEP 3.** HOLD MOLD FIRMLY WITH OPENING AWAY FROM OPERATOR AND IGNITE WITH FLINT GUN.



**STEP 4.** REMOVE SLAG FROM CONNECTION AND PEEN WELD FOR SOUNDNESS.



**STEP 5.** COMPLETELY COVER CONNECTION AND EXPOSED STRUCTURE SURFACE WITH EPOXY COATING COMPOUND.



**NOTES**

- EXOTHERMIC WELD PROCEDURE SHOWN ABOVE IS TO BE USED AS A GENERAL GUIDE ONLY. CONSULT MANUFACTURER'S LITERATURE FOR SPECIFIC SIZE AND INSTALLATION INSTRUCTIONS.
- PUTTY USED FOR THE CABLE TO PIPE CONNECTION SEAL DAM (THERMITE CONNECTIONS) SHALL BE "A+B" EPOXY AS MANUFACTURED BY BIGGS COMPANY, OR EQUAL. ALL BONDS SHALL BE INSPECTED BY WATER DIVISION PRIOR TO BACKFILLING TRENCH.

CITY OF NAPA

UTILITIES DEPARTMENT

TITLE

EXOTHERMIC WELD

DRAWN BY: DF

CHECKED BY: SL

APPROVAL DATE: 09/2021

APPROVED BY: DD

SCALE: NTS

DRAWING NO.

REVISED DATE: 09/2021

W-23B