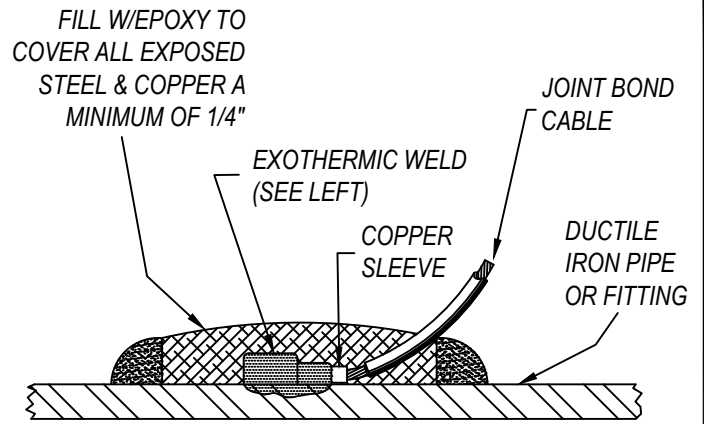


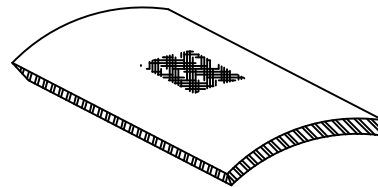
EXOTHERMIC WELD



CABLE-TO-PIPE CONNECTION

EXOTHERMIC WELD PROCEDURE

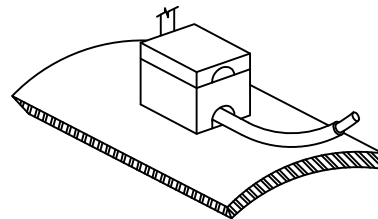
STEP 1. FILE STRUCTURE CONNECTION AREA TO BARE SHINY METAL AND CLEAN.



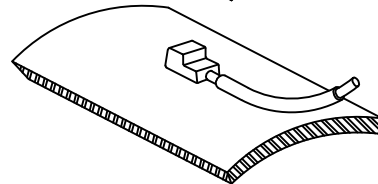
STEP 2. STRIP INSULATION FROM WIRE. ATTACH SLEEVE REQUIRED ON #6 AWG WIRE OR SMALLER.



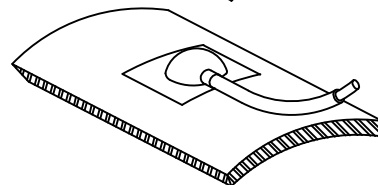
STEP 3. HOLD MOLD FIRMLY WITH OPENING AWAY FROM OPERATOR AND IGNITE WITH FLINT GUN.



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

PUBLIC WORKS DEPARTMENT

TITLE

EXOTHERMIC WELD

DRAWN BY: DCF

CHECKED BY: MJH

DATE: 07/2017

APPROVED BY: MJH

SCALE: NTS

DRAWING NO.

FIELD NOTES:

W-23B