

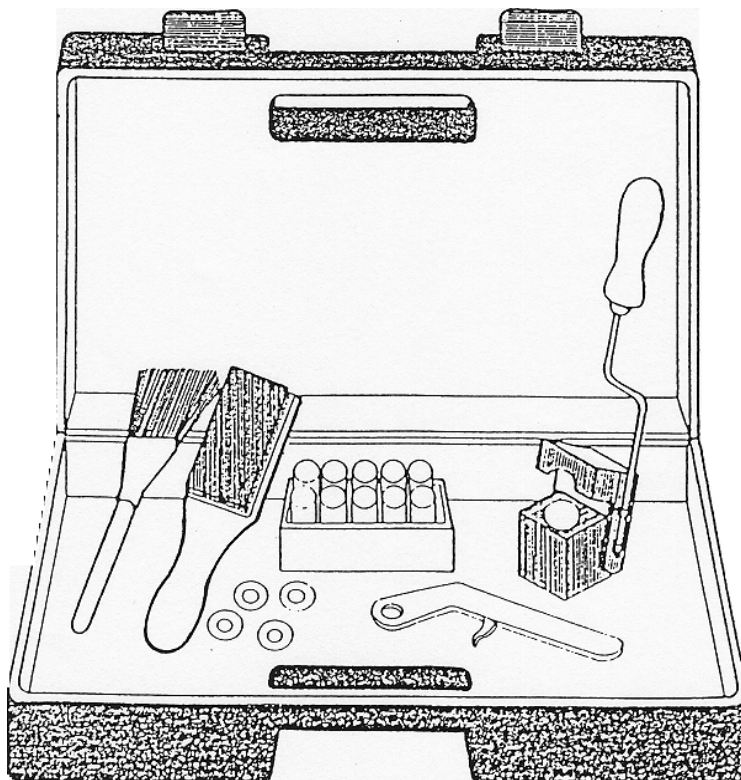
ALUMINOTHERMIC WELDING EQUIPMENT

The aluminothermic weld copper process is a method of making electrical connections of copper to copper, copper to steel or steel to steel in which no outside source of heat or power is required

Powdered copper oxide and aluminum weld metal is emptied from a plastic container into the crucible and temporarily held in place by a metal disc until ignited by a flint gun.

The subsequent exothermic reaction of the copper oxide with aluminium produces molten copper and aluminium oxide slag.

The molten copper melts the metal disc and flows over the copper conductor and weld surface welding them together.



Pipeline Maintenance Limited

Cathodic Protection Engineering and Materials Supply

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Equipment details

Stranded Copper Cable - mm2	Mould Type	Handle Type	Cartridge Size	Copper Sleeve
2.5	HAM-83-CA	M-125	15	H-105
4.0	HAM-83-CA	M-125	15	H-10S
6.0	HAM-83-CA	M-125	15	
10.0	HAA-Y1-CA	M-129	25	H-102
16.0	HAM-B3-CA	M-125	15	
or	HAA-Y2-CA	M-129	32	H-103

For Steel pipe use F-33 grade weld metal.

For Iron pipe use XF-19 grade weld metal.

When making these connections to pipes, the moulds must be adjusted to the round surface. This is done by adding a letter-code suffix to the mould type when ordering.

Pipe O.D. (mm)	Suffix Code	Pipe O.D. (mm)	Suffix Code	Pipe O.D. (mm)	Suffix Code
60-70	A	135-145	D	300-350	M
70-90	B	145-165	E	350-450	N
90-105	G	165-190	J	450-550	O
105-115	C	190-220	F	550-700	P
115-125	R	220-250	K	700-1000	Q
125-135	H	250-300	L	1000+	

A full range of complementary cathodic protection equipment is available including:

- Cable bonds
- Coating material
- Test posts -both UK and Middle Eastern Standards
- Anodes
- Transformer rectifier
- Instrumentation

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