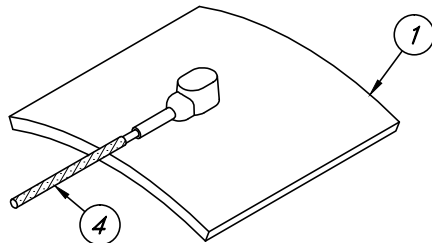
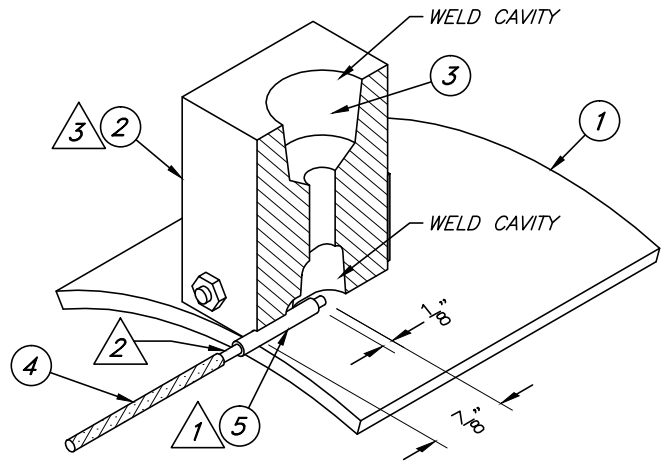


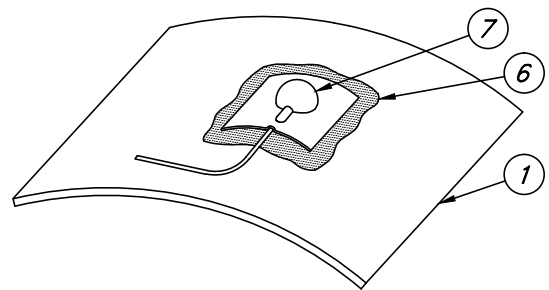
PLACEMENT ON PIPE



FINISHED WELD



CUTAWAY VIEW OF MOLD



FINISHED CP HANDY-CAP

MATERIAL LIST

QTY	DESCRIPTION	STOCK NO.
1	STEEL PIPE	
2 1	THERMITE WELDING UNIT (CADWELDER): FOR PIPE SIZES 3/4" TO 3-1/2" FOR PIPE SIZES 4" AND LARGER	212560 212533
3 1	CADWELD CARTRIDGE/CONDUCTOR TAB	212506
4 1	STRANDED COPPER WIRE: #8 THHN-THWN - BLACK #8 THHN-THWN - WHITE #10 HDPE YELLOW LOCATOR WIRE #12 (FROM ANODE OR TEST STATION)	211556 211559 211571
5 1	ADAPTER SLEEVE (REQUIRED ON #10 & #12 WIRE)	202785
6 1	SPRAY PRIMER	209753
7 1	CP HANDY-CAP (CORROSION PROTECTION CAP FOR EXOTHERMIC GROUNDING CONNECTION)	209730

PROCEDURE

- 1) REMOVE THE COATING AND CLEAN THE STEEL SURFACE (APPROX. 2"x2" MIN.) WITH A WIRE BRUSH OR BY LIGHTLY FILING.
- 2) STRIP COATING FROM WIRE AS SHOWN AND INSTALL COPPER SLEEVE TO #10 & #12 AWG WIRES. WIRE SHOULD EXTEND 1/8" BEYOND THE SLEEVE END.
- 3) PLACE CADWELD CARTRIDGE IN THE WELDER AND CONNECT THE CONTROL BOX LEAD TO THE CARTRIDGE CONDUCTOR TAB.
- 4) PLACE THE WIRE AND WELDER ON PIPE AS SHOWN ABOVE AND ACTIVATE/TRIGGER THE CONTROL BOX WHILE FIRMLY HOLDING THE WELDER IN PLACE.
- 5) ALLOW WELD TO COOL THEN TUG ON THE WIRE TO CONFIRM A PROPER WELD.
- 6) APPLY PRIMER TO SURFACE (4"x4" MINIMUM). REMOVE THE PROTECTIVE FILM FROM BACK OF THE HANDY-CAP PATCH AND FIRMLY APPLY TO THE PIPE'S EXPOSED SURFACE.

NOTE: THE HANDY-CAP MAY BE OMITTED IF OTHER COATING METHODS ARE BEING APPLIED BECAUSE THE WELD WAS MADE IN LARGE EXPOSED AREAS (REF. GS-450).

GENERAL NOTES

- 1 #10 AWG OR SMALLER CONDUCTORS MUST BE BUILT UP TO FIT THE OPENING OF THE WELDER BY USING A COPPER ADAPTER SLEEVE.
- 2 KEEP EXPOSED COPPER WIRE TO A MINIMUM.
- 3 CLEAN MOLD AFTER USE.

CONSTRUCTION STANDARD
CITY UTILITIES OF
SPRINGFIELD, MISSOURI

THERMITE WELDING
PROCEDURE