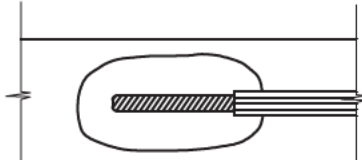


STEP 1



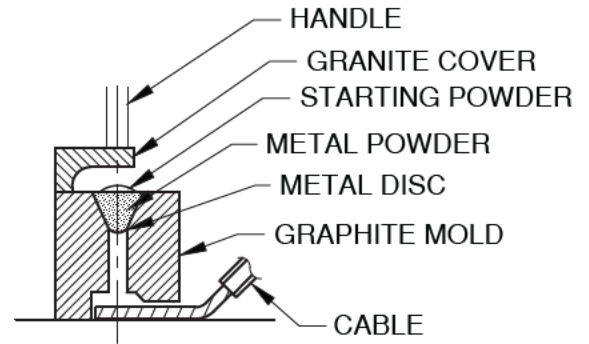
CHIP OUT MORTAR (CML&C) AND/OR FILE SURFACE TO BRIGHT METAL AND CLEAN

STEP 2



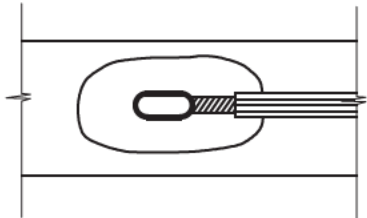
STRIP INSULATION FROM WIRE

STEP 3



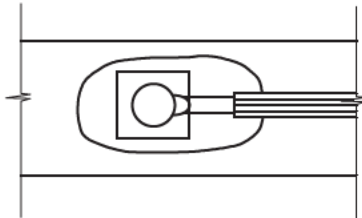
HOLD WELDER FIRMLY WITH OPENING AWAY FROM OPERATOR AND IGNITE STARTING POWDER

STEP 4



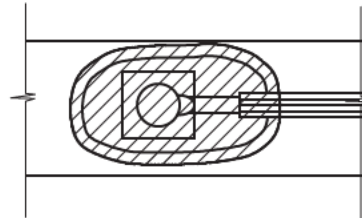
REMOVE SLAG FROM CONNECTION

STEP 5



APPLY 2 COATS OF PRIMER AND COVER CONNECTION WITH A PREFORMED WELD CAP

STEP 6



COAT AREA WITH BITUMEN. PATCH MORTAR. SEE NOTE 5.

NOTES:

1. WELDER SHOWN IS FOR HORIZONTAL SURFACES. FOR VERTICAL SURFACES SIDE WELDER IS REQUIRED.
2. ALL WIRE WELDS SHALL BE 3 INCHES APART, MINIMUM.
3. STANDARD WELD CARTRIDGES SHALL BE USED FOR DUCTILE IRON AND STEEL SURFACE. FOR CAST IRON, USE XF-19 ALLOY OR EQUIVALENT.
4. TEST ALL WELDS BY STRIKING WITH 2 LB. HAMMER.
5. ALL EXPOSED METAL (STRUCTURE, WIRE & WELD) SHALL BE COVERED WITH 2 COATS OF PRIMER AND AN ELASTOMETRIC WELD CAP.
6. APPLY GENEROUS COAT OF BITUMEN OVER WELD CAP AND EXPOSED METAL AREA UP TO EDGE OF MORTAR (CML&C) OR 3" BEYOND WELD CAP (DIP).
7. PATCH MORTAR COATING WITH QUICK SETTING MORTAR (CML&C).

APPROVED:

Wally P. ... 5/16/19

District Engineer Date

5/16/2019

Latest Revision Date



VALLEY CENTER MUNICIPAL WATER DISTRICT
STANDARD DRAWING

ALUMINO - THERMIC WELD

NOT TO SCALE

DWG. NUMBER

W-53