METHOD STATEMENT
SIKA® WATERBAR WELDING

SIKA LIMITED (VIETNAM)

BUILDING TRUST

1 SCOPE

- Procedure for he thermal welding of Sika® Waterbar connections.

2 APPLICATION

2.1 Preparing

Welding sword

Cleaning tool

2.2 Butt welding using copper sword

Step 1:

- Cut straight the Sika® Waterbar sections to be welded. This is extremely important since the Sika® Waterbar ends are butt welded.
- Check heating of welding sword by place heating sword onto the sample Sika® Waterbar to check degree.

Step 2:

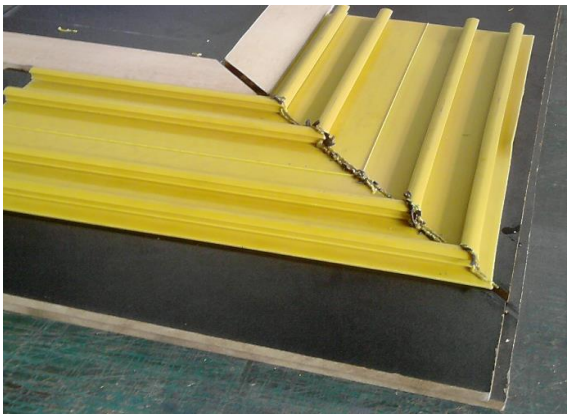
- Place heated copper sword between the Sika® Waterbar ends to be welded and lightly press together the welding Sika® Waterbar until the Sika® Waterbar ends are touching the sword.
- Move the copper sword backward and forward slowly for approx. 10 seconds.
- Pull copper sword slowly out, and immediately and forcefully press the Sika® Waterbar ends together with the clamping device.


Step 3:

- Press the clamping device forcefully together for approx. 10 seconds.
- The welding seam may only be stressed after having completed cooled down!

Step 4:

- Across the whole welding seam, a welding bead must be visible.
- If there is no continuous welding bead, the welding must be improved spot-wise.
- The copper sword is heated again and the faulty areas worked over.

Step 5:

- Finally, the copper sword is cleaned with a wire brush.

2.3 T-Welding

Step 1:

- Cut straight the Sika® Waterbar sections to be welded. This is extremely important since the Sika® Waterbar ends are butt welded.
- Check heating of welding sword by place heating sword onto the sample Sika® Waterbar to check degree.

Step 2:

- Place heated copper sword between the Sika® Waterbar ends to be welded and lightly press together the welding Sika® Waterbar until the Sika® Waterbar ends are touching the sword.
- Move the copper sword backward and forward slowly for approx. 10 seconds.
- Pull copper sword slowly out, and immediately and forcefully press the Sika® Waterbar ends together with the clamping device.


Step 3:

- Press the clamping device forcefully together for approx. 10 seconds.
- The welding seam may only be stressed after having completed cooled down!

Step 4:

- Across the whole welding seam, a welding bead must be visible.
- If there is no continuous welding bead, the welding must be improved spot-wise.
- The copper sword is heated again and the faulty areas worked over.


Step 5:

- Finally, the copper sword is cleaned with a wire brush.

3 HEALTH AND SAFETY INFORMATION

Care should be taken to avoid breathing fumes and smoke during the PVC welding process. Hence, welding should be performed in open, well ventilation area.

Legal Note

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