

METHOD STATEMENT

SIKA[®] WATERBAR WELDING

SIKA LIMITED (VIETNAM)

BUILDING TRUST



1 SCOPE

- Procedure for the 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.

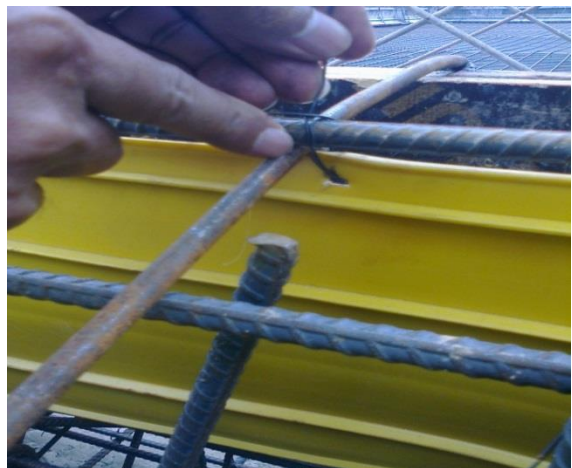
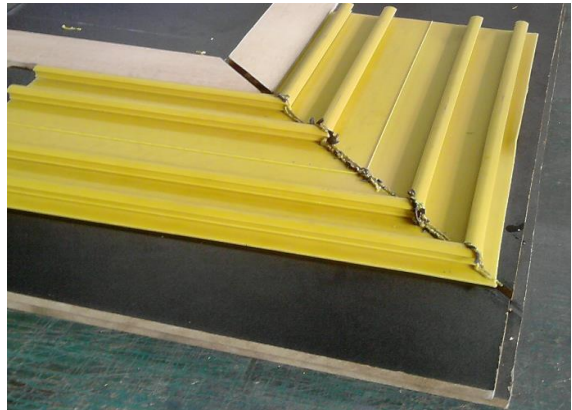


Step 3:

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

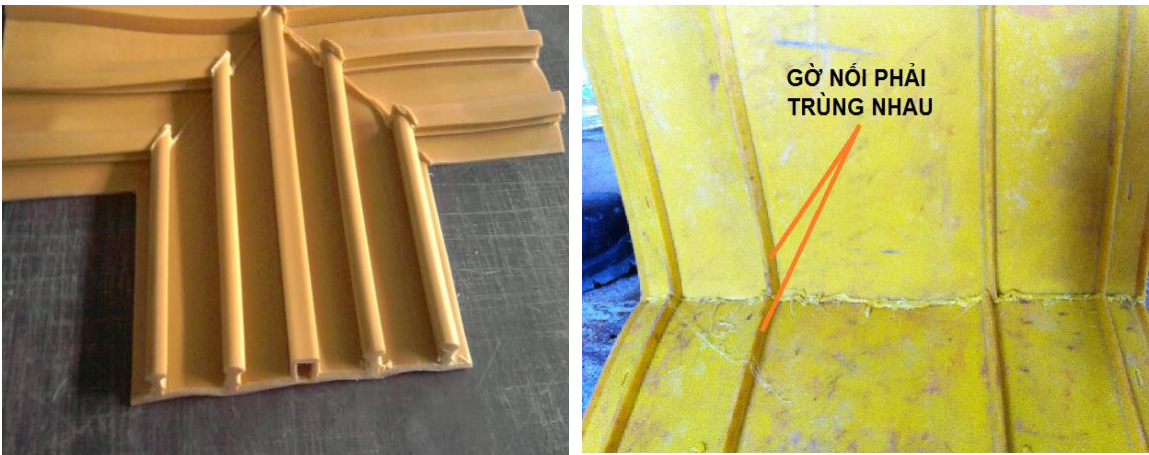


Step 3:

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

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the products suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

Sika Limited (Vietnam)
Nhon Trach 1 Industrial Zone
Nhon Trach, Dong Nai
Vietnam
vnm.sika.com

Phone: (84-251) 3560 700
Fax: (84-251) 3560 699
Mail: sikavietnam@vn.sika.com

Method Statement
SIKA® WATERBAR WELDING
Edition: 09/2018