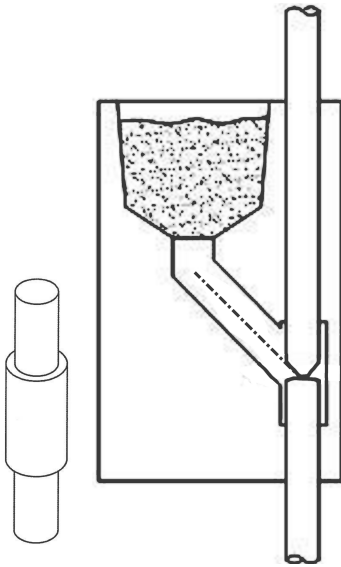


ULTRAWELD®

INSTRUCTIONS FOR ULTRAWELD® GROUNDING CONNECTIONS - ROD TO ROD OR CABLE TO AIR TERMINAL

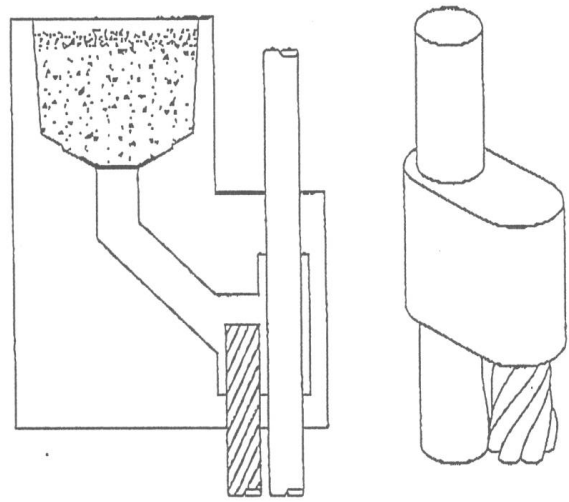
GG

Insert lower rod up to centerline of tap hole. For all rods butt ends together.



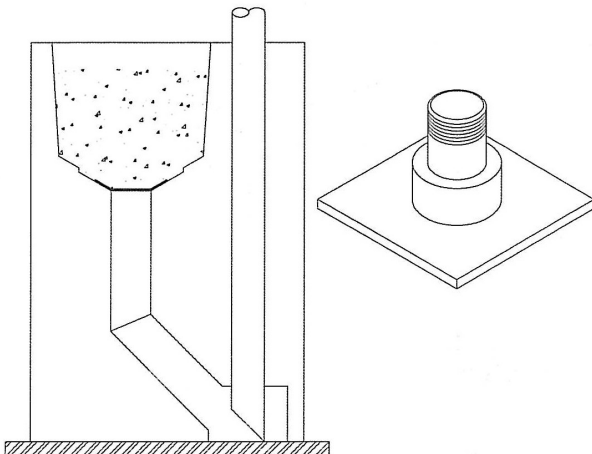
AD

Place end of cable up to center of tap hole. Support mold to keep it from sliding down the air terminal when welding with locking pliers or clamp below mold.



HSVB

Place stud in mold so end to be welded is 1/8" from steel surface. If this is not possible due to using short stud, cut end of stud to a 25° angle. All 3/4" and 1" studs must be cut at the 25° angle, and position as shown.



ULTRAWELD Installation Instructions

Ground Rods

GENERAL SAFETY INSTRUCTIONS:

1. Always wear proper clothing, safety glasses and gloves when exothermic welding.
2. Only weld items that the mold is designed for.
3. Do not use worn or broken molds which could cause leakage of molten weld metal.
4. Make sure that the conductors being welded fits in the mold properly and that the mold will close tightly around them.
5. Do not alter molds or accessories without factory authorization.
6. Avoid breathing concentrations of smoke, as it may be hazardous to your health.
7. Avoid contact with hot materials.
8. Remove or protect fire hazards in the welding area.
9. Avoid moisture and contaminants in the mold and conductors being welded. Contact of molten weld metal with moisture or contaminants may cause weld metal to spew out of mold.
10. Failure to abide by the above and follow welding procedures may result in improper welds, damage to the material being welded or create hazardous situations for the individual.

MOLD CARE:

- Do not use a wire brush to clean mold
- Do not use a screwdriver to clean the mold
- Clean mold with soft bristle mold cleaning brush to remove slag and residue
- Do not push conductor into a closed mold
- Store molds in a dry environment

PREPARATION OF CABLE:

1. Cable must be bright, clean and dry.
2. Cable that is saturated with oil or grease must be cleaned. Cable may be cleaned by burning it off with a propane or oxy-acetylene torch. After burning off oil or grease, a wire brush should be used to remove residue. Wet cable must be dried out. Use a hand propane torch.
3. Corroded cable must be cleaned. Use the CCBRS2 cable cleaning brush or CCBRS1 card cloth brush. It is important that the ends of the individual strands are clean. This can best be accomplished by making a fresh cut on the end of the cable.
4. Cable should be straightened before clamping mold in place. Bent or out of round cable will hold mold open and cause leaks.
5. Remove insulation from insulated cable before cutting with hack saw. Otherwise ends of strands will become coated with insulating material which may cause defective welds.
6. FLEXIBLE CABLE: A sleeve must be used when welding flexible cable. WRPSLV wrap sleeves are recommended for 300 MCM and smaller cable.

PREPARATION OF GROUND RODS:

1. Ends that are threaded, mushroomed from driving, or drilled and tapped, must be cut off before welding to the end. Contact factory about ground rod driving sleeves.
2. The site of the weld on the ground rod must be clean. Use a coarse file to remove rust and oxide before welding.
3. Slightly under sized rod may be built up with WRPSLV wrap sleeves. This will not work for large differences in size.