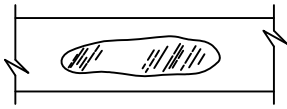
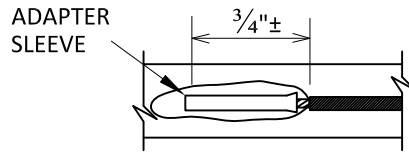


**STEP 1**



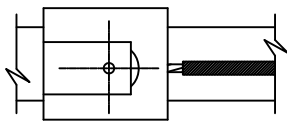
CLEAN PIPE SURFACE AT WELD LOCATION TO BRIGHT METAL USING MECHANICAL GRINDER

**STEP 2**

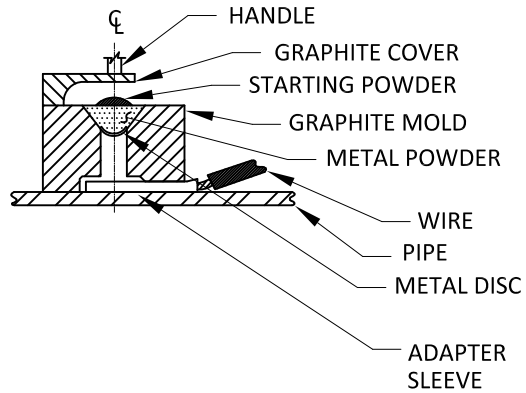


STRIP INSULATION FROM WIRE. INSERT WIRE IN COPPER ADAPTER SLEEVE IF WIRE IS #12 AWG OR SMALLER -SEE NOTE 3

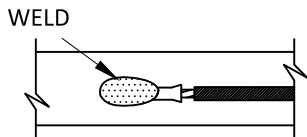
**STEP 3**



HOLD MOLD FIRMLY WITH OPENING AWAY FROM OPERATOR - IGNITE STARTING POWDER.

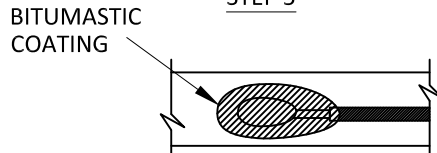


**STEP 4**



TEST WELD INTEGRITY (SEE NOTE #4) REMOVE SLAG FROM CONNECTION AND THOROUGHLY CLEAN WELD AREA

**STEP 5**



COAT ALL EXPOSED METAL AT WELD AREA WITH ONE COAT OF BRUSH APPLIED BITUMASTIC PROTECTIVE COATING

**NOTES:**

1. FOLLOW MANUFACTURER'S PROCEDURES AND RECOMMENDATIONS WHEN THERMITE WELDING.
2. USE APPROPRIATE WELD MOLDS AND WELD METALS FOR SPECIFIC SIZE AND MATERIAL OF PIPE THAT WIRE IS BEING ATTACHED TO.
3. WHEN THERMITE WELDING #12 AWG WIRES OR SMALLER, INSERT END OF WIRE INTO AN APPROVED COPPER SLEEVE PRIOR TO THERMITE WELDING AND CRIMP SLEEVE ON WIRE.
4. TEST WELD INTEGRITY BY STRIKING WELD WITH A HAMMER AFTER WELD HAS COOLED. AVOID STRIKING WIRE.

CITY OF ROCHESTER	
<b>THERMITE WELD DETAILS</b>	
ISSUED	10-17-08
NON-STANDARD	
REVISED	12-28-10
DWG.NO.	S966-2