RACC MOD4 USA VER12 EF

WELDING INSTRUCTIONS FOR ELECTROFUSION SOCKET FITTINGS

1. Make sure that the pipe or spigot ends to be welded are lined up and cut straight.

2. Scrape the surface of the pipe or the spigot ends to remove the oxidized layer. Scrape the length equal to the depth of the electrofusion fitting +0.4" (1 cm). Mechanical scrapers are recommended. Hand scrapers can be used (refer to your Company procedures). The scrape depth must be a minimum of .007; avoid gouging or removing excessive material from the pipe surface.

3. Clean the external surface of the pipe or spigot ends and the internal surface of the fitting with isopropanol and a soft wiping cotton cloth without any printing.
Wait until the clean parts are completely dry.

4. Measure the depth of insertion of the electrofusion sockets and mark it on each pipe or spigot ends. Insert the pipe or spigot ends into the electrofusion sockets until they reach the stop and the marked lines.

IT IS ALSO POSSIBLE TO REMOVE THE STOPS INSIDE THE FITTING AND INSERT THE FIRST PIPE COMPLETELY, THEN ALIGN THE TWO PIPE SECTIONS LEAVING ONLY A SMALL GAP BETWEEN THE PIPE ENDS AND SLIDE THE FITTING UNTIL IT IS CENTERED BETWEEN THE TWO LINES MARKED ON THE PIPE.

5. ALWAYS USE THE ALIGNERS WHEN POSSIBLE.
Avoid any stress in the welding area during the welding operation and the cooling time.

6. Connect the welding cables to the fitting connectors, scan the barcode with the barcode scanner or enter the welding parameters manually.
ALWAYS CHECK THE WELDING PARAMETERS ON THE DISPLAY

7. At the end of the welding cycle, disconnect the cables, verify that no material has leaked out of the joint between the pipe and the fitting then wait for the cooling time indicated on the barcode (TABLE 1).

8. At the end of the cooling time it's possible to start the pressure test with the Pressure Sensor. In TABLE 2 you find the recommended waiting time in MINUTES before starting the test.

For gas pipelines:
The Max Operating Pressure for this fitting is 145 PSI.
The Max Test Pressure for this fitting is 217psi for 1 hour.
DO NOT EXCEED MAX OPERATING OR MAX TEST PRESSURES.

ATTENTION:

- **YOU CAN WELD WITH POLYVALENT WELDING UNIT IN AUTOMATIC MODE (WITH BARCODE SCANNER) OR IN MANUAL MODE.**
- **IN CASE OF AUTOMATIC WELDING, ALWAYS CHECK TIME AND VOLTAGE PARAMETERS ON THE DISPLAY AFTER BARCODE SCAN.**
- **IN CASE OF MANUAL WELDING, USE TIME AND VOLTAGE PARAMETERS INDICATED ON THE BARCODE (Fig.1).**
- **IF THE WELDING UNIT DOES NOT PERFORM WELDING TIME COMPENSATION ACCORDING TO AMBIENT TEMPERATURE, USE THE PARAMETERS ON THE LABEL AFFIXED ON THE BAG (Fig.2).**
- **KEEP AT A SAFE DISTANCE DURING WELDING.**

TABLE 1

COOLING TIME	
INCH	MINUTES
½" to 1 ½"	10
2" to 2 ½"	15
3" to 6"	20

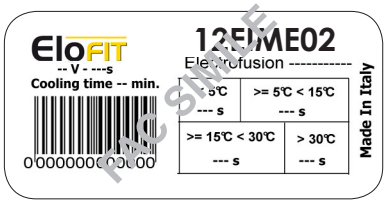
TABLE 2

RECOMMENDED WAITING TIMES BEFORE PRESSURE TEST START			
FOR GAS APPLICATIONS			
Dn pipe	P ≤ 100 PSI	P ≤ 150 psi	P ≤ 217 psi
½" to 1 ½"	Cooling + 20'	Cooling + 60'	Cooling + 60'
2" to 2 ½"	Cooling + 30'	Cooling + 90'	Cooling + 90'
3" to 6"	Cooling + 40'	Cooling + 120'	Cooling + 120'
FOR LIQUID APPLICATIONS			
Dn pipe	P ≤ 150 PSI	P ≤ 240 psi	P ≤ 348 psi
½" to 1 ½"	Cooling + 20'	Cooling + 60'	Cooling + 60'
2" to 2 ½"	Cooling + 30'	Cooling + 90'	Cooling + 90'
3" to 6"	Cooling + 40'	Cooling + 120'	Cooling + 120'

FIG.1 WELDING PARAMETERS

XXX00: FITTING CODE
00v: VOLTAGE
00s: WELDING TIME
c.t. 00 m: COOLING TIME

FIG.2 MANUAL WELDING PARAMETERS



RECCOMENDATIONS FOR THEIR DISPOSAL:
POLYETHYLENE USED FOR THIS ACCESSORY IS RECYCLABLE: DISPOSE THROUGH AUTHORISED CENTRES. DO NOT DISPERSE WRAPPING AND PACKAGING OF THE PRODUCT, RECYCLE THROUGH COLLECTION.

NUPI Americas, Inc.
1511 Superior Way, Houston, TX 77039
Tel: 281 590 4471 - Fax: 832 201 8537
Web site: www.nupinet.com