

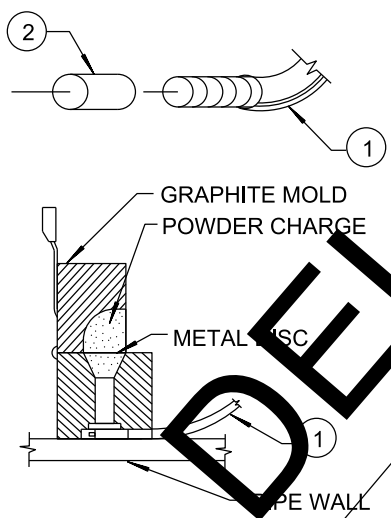
DETAIL 1
TYPICAL CONNECTIONS OF NO.6 AWG CABLE AND SMALLER CABLES

DETAIL 2
TYPICAL CONNECTIONS OF NO.4 AWG CABLE

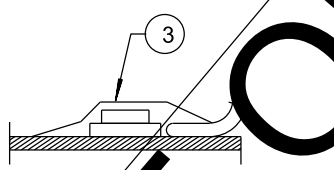
DETAIL 3
TYPICAL CONNECTIONS OF NO.2 AWG CABLE AND LARGER CABLES

NOTES:

1. CLEAN AREA OF STEEL SURFACE APPROXIMATELY 2"x 2" FOR EACH THERMOWELD CONNECTION. WIRE BRUSH FILE AND SCRAPE TO OBTAIN SSPC-SP-5 WHITE METAL SURFACE FINISH.
2. SELECT PRIMER MOLD BASED ON STRUCTURE GEOMETRY, ORIENTATION AND MATERIAL TYPE.
3. STRIP CABLE END AND TWIST TO FIT THERMOWELD MOLD. CABLE SIZES LARGER THAN 6 AWG SHALL BE THERMOWELDED BY TWISTING CONDUCTORS INTO GROUPS APPROXIMATELY NUMBER 6 AWG CABLE SIZE. MINIMUM SPACING BETWEEN WELDS WILL BE DETERMINED BY MOLD GEOMETRY, NOMINALLY 3".
4. HOLD MOLD FIRMLY AGAINST PIPE WITH OPENING AWAY FROM THE OPERATOR. IGNITE WITH FLINT GUN.
5. REMOVE ALL WELD SLAG, SPLATTER, SHARP EDGES AND BURRS WITH CHIP HAMMER AND METAL FILE.
6. TEST STRENGTH OF CONNECTION BY LIGHTLY TAPPING WITH 1 LB HAMMER, AND PULL WITH 5 LB FORCE ON CABLE.
7. WIPE PIPE SURFACE WITH CLEAN, OIL FREE RAGS TO REMOVE ANY LOOSE DUST.
8. PRIME CLEANED SURFACE WITH APPROVED PRIMER.
9. COAT THERMOWELD AND 6" OF CABLE TAIL WITH COMPATIBLE COATING, SUCH THAT ALL CORNERS ARE FILLED. THE COATING SHALL EXTEND FOR AT LEAST 2" AROUND THE THERMOWELD AREA.
10. THERMOWELD CARTRIDGE SIZE SHALL BE COMPATIBLE TO STEEL MATERIALS. MULTIPLE POWDER CARTRIDGE CHARGERS SHALL NOT BE USED. IF A THERMOWELD MUST BE REPEATED, A NEW PIPE SURFACE MUST BE PREPARED AT LEAST 3" FROM THE ORIGINAL WELD ATTEMPT. MORE THAN ONE WELD ATTEMPT ON THE SAME SPOT SHALL NOT BE PERMITTED.
11. IN NON-CONCRETE LINED PIPES, ALL EXOTHERMIC WELDS SHALL BE MADE IN A STEEL PAD.



EXOTHERMIC CONNECTION DETAIL



EXOTHERMIC CONNECTION SECTION

CABLE STRAND DETAILS			
CABLE SIZE	NO. OF STRANDS	NO. OF EXOTHERMIC GROUPS PER CABLE CONNECTION	CABLE STRANDS PER GROUP
8	19	1	19
6	7	1	7
	19		19
4	7	2	3-4
	19		10-9
2	7	3	3-2-2
	19		7-6-6

ITEMS CALL OUT:

- ① CABLE: AWG SIZE, ASTM B3/B8
ASTM D-1248, TYP1 1, CLASS C, GR.5 INSULATION
- ② SLEEVE: ADAPTER
- ③ APPROVED PRIMER & WELD CAP OR MORTAR OVER WELD LOCATION

REVISION	BY	APPROVED	DATE
ORIGINAL		A. OSKLOI	12/03
UPDATED	KA	J. NAGELVOORT	01/12
REDRAFTED	CD	J. NAGELVOORT	09/18
DELETED	EF	J. NAGELVOORT	10/19

CITY OF SAN DIEGO - STANDARD DRAWING

**EXOTHERMIC WELDING OF CABLES
AND COATING OF WELDING**

RECOMMENDED BY THE CITY
OF SAN DIEGO STANDARDS COMMITTEE

Chungpa 10/10/19
COORDINATOR R.C.E. 56523 DATE

DRAWING
NUMBER **SDW-125**