

Basic welding procedure

Raintite

Trading Ltd



The following are basic guidelines and recommendations as to the procedure for hot air welding of a *fatra* Coated Metal product within a guttering application.

- All procedures should be carried out within the HSE guidelines for working at height and Risk assessments conducted prior to commencement of any procedures.
- Great care should be taken to ensure the joint area of the product is not damaged and is free from any dirt or contamination.
- During the installation process, the use of sacrificial walkway products to protect the material surface from manual traffic damage is recommended.
- All contractors should ensure the footwear of their operators is clean and suitable and will not damage the membrane surface. I.e. the use of “Hobnail” type footwear is not recommended.
- The welding process should only be carried out by approved and trained operatives.
- In an Ideal situation the gutter joints should be welded immediately after installation of the gutter section. Splitting the installation team into 2 groups will assist in this process. Group 1 will install and fix the gutter section, immediately followed by Group 2 who will clean and weld the gutter joint. This method of installation will reduce the cleaning process involved and ultimately reduce the installation time.
- The overlap surface of the gutter should be cleaned and any detritus removed, the use of Solvent Cleaner Fatrafol FF860 is recommended for this.
- No sharp implements should be used during the cleaning process i.e. metal spades or shovels, metal scrapers wire brushes or abrasive wools or pads. Soft lint free cloth type materials are ideal for this process.
- Hot air welding should only be attempted in a well ventilated area, should extraction used should it be deemed necessary.
- The Hot air gun should initially be set to between 350 and 400deg C, a trial weld should be attempted and the temperature adjusted to compensate for weather conditions and prevailing wind direction.
- The overlap weld should be a minimum of 75mm and created in 3 complete passes.
 - 1, first 25mm Tack weld the overlap into position.
 - 2, Continuously weld the next 25mm.
 - 3, Continuously weld the last 25mm to ensure a watertight seal.
- The Joint should then be inspected with a probe and any potential weak points addressed.
- The joint should then be dressed with a bead of Fatrafol 854 Liquid PVC, this product has been specifically designed to penetrate any potential gaps and will set over the next 12 hours.
- Where a stop end or intersection is being fitted the installer is required to use of Fartafol internal corners at all tines. These corners have been specifically designed to suit this type of application and will ensure a watertight seal.
- Finally all visible areas of the gutter joint should be closely inspected with particular attention paid to joints stop ends and outlets.

Failure to comply with any of the procedures contained within this document or the any subsequent documentation issued by either *fatra* or Raintite trading Ltd will invalidate any for of Guarantee / warrantee implied or inferred.

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