



## User manual ELPA

### Procedimiento ELPA-Carril

**1.Track cleaning.** Remove any grease residue from the rail with a spatula. Heat (up to approx. 50°C) the rail, to dry it, using a welding lamp or blowtorch. Grind the rail slide to remove ALL oxide residue (to white metal), using a hard grinding wheel and the bottom plane of the slide to avoid contamination of the insert when mounting the mould.

**2. Apply the flux evenly.** Break off the flux dose by turning the cap and apply it evenly over the entire ground surface.

**3.Positioning the mould.** Insert the mould into the skid until it is centred on its upper plane.

**4.Insert the cable.** Insert the tip of the cable/terminal into the mould until it stops.

**5.Welding powder.** Open the coloured cap of the cartridge and empty it into the mould. Open the black cap and spread the ignition powder over the welding powder and the front edge of the mould. Place the cap with its opening towards the ballast.

**6. Ignition.** Ignite the powder with the ignition gun.

**7. Demoulding.** Wait at least 5 minutes before destroying the mould with a hammer. Then clean the weld with a wire brush and a brush.

**8.Final appearance of the weld.** Mark the weld in accordance with the established identification specifications.

**IMPORTANT NOTE:** If traffic passes within one minute after ignition, the welding must be removed and repeated. It can be done in the same place, without risk to the rail, after the rail cleaning operations have been carried out again.

