



Procedimiento ELPA-Tubo

1. Remove the polyethylene coating and grind the area of the pipe where the welding is to be carried out, at a surface of 95x60 mm. Then pour the flux into the frosted area.

2. Bring the mould towards the ground area by centring it on the uncoated area and apply force F on the sides of the lower part of the clamping system to bring it closer to the surface of the pipe. Make sure that all magnets are in contact with the steel of the pipe, and not with the polyethylene coating.

3. Remove the sheathing from the cable at the end to be welded and for a length of 50 mm. Select the appropriate tapered ferrule, making sure that it can be inserted completely through the unshielded end of the wire, and that as little slack as possible appears in the ferrule, and insert the ferrule selected in the previous step into the mould opening, pressing lightly to secure it in position. Finally, insert the end of the bare wire into the mould opening. **IMPORTANT: these operations are not necessary for the larger cross-section cable that can be soldered with the kit, only the last step would be necessary.**

4. Open the coloured lid of the cartridge and empty the welding powder into the mould hopper. Open the black cartridge cover and sprinkle the ignition powder on the welding powder, reserving a small amount of ignition powder.

5. Place the lid on the mould, pressing lightly to secure it in place. Pour the reserved quantity of ignition powder through the funnel-shaped opening. Press the button on the remote ignition device. Keep it pressed until the aluminothermic reaction takes place.

6. Do not touch anything for at least five minutes. Once the time has elapsed, use a hammer or similar to break the sand mould. Use the opening of the movable part to separate a corner from the rest of the mould. Use the opening of the moving part to move the rest of the mould and free the weld.

