

HEXATECH	Electrical Method Statement for Exothermic Welding for Lightning & Earthing System	Issue No: 1	Effective Date: 01/03/17
		Rev No: 0	Document Ref: MS-E010

## 1.0 **OBJECTIVE**

This procedure provides exothermic welding details on work sequence, materials, equipment and safety with reference to drawings, specification, field quality control and Safety Plan pertaining to this project.

## 2.0 **SCOPE**

Method of installation is accordance to latest IEC, IEE, MS, JKR & TNB requirements and local authority standards.

## 3.0 **TOOLS & EQUIPMENT**

1. Exothermic Mould
2. Handle Clamp
3. Weld Metal (Powder)
4. Flint Gun

## 4.0 **SAFETY & ENVIRONMENTAL PROGRAM**

- All welding works will be carried-out in accordance with Project Safety Plan, Owner Safety Procedures and statutory regulations.
- All necessary personal protective equipment will be provided and worn.
- All the tools and equipment used at site must be compliance to safety requirement.
- The site of all work activities will be kept in clean and tidy manner.
- 1 no. fire extinguisher will be standby in case any fire occurred

## 5.0 **REFERENCES**

MS ISO 9001: 2015 Element 7.1.6.

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## 6.0 TESTING METHOD STATEMENT

### Instruction Exothermic Welding



step **1** Assembly mould with handle clamp.



step **2** Pre-heating with a butane torch to ensure the mould is totally dry before every first joint regardless new or used mould.



step **3** Clean the surface of conductors and Rod with a card cloth brush. And preheating with butane torch to ensure the conductors is totally dry.



step **4** Conductors and Ground Rod fits snugly into the mould and lock the handle clamp. Always make sure the mould a level position.



step **5** Place retaining disc and make sure the disc sits well at the base of the weld metal cavity.

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## Instruction Exothermic Welding



step **6**

Pour a factory's recommended size of weld metal into the mould crucible. Check for leaks, make sure the weld metal do not enter into the weld cavity. If it does leak, repeat the whole of step 4.



"X"  
step **7**

You will find the starting powder, then loosen the starting powder from the tube and pour 2/3 of it on top of the weld metal and the balance at the mouth of mould lid-marked "x"



step **8**

Ignite the starting powder at the lid opening. Warning only fire form the side of the mould. Do not place your hand or any other flammable a recommended flint gun.



step **9**

Gently off the un-wanted slag from the crucible with a mould scraper. Finally, Clean the crucible and weld cavity with a mould cleaning brush. Only a mould cleaning brush would help to endure the mould.



step **10**

Complete Connection.

