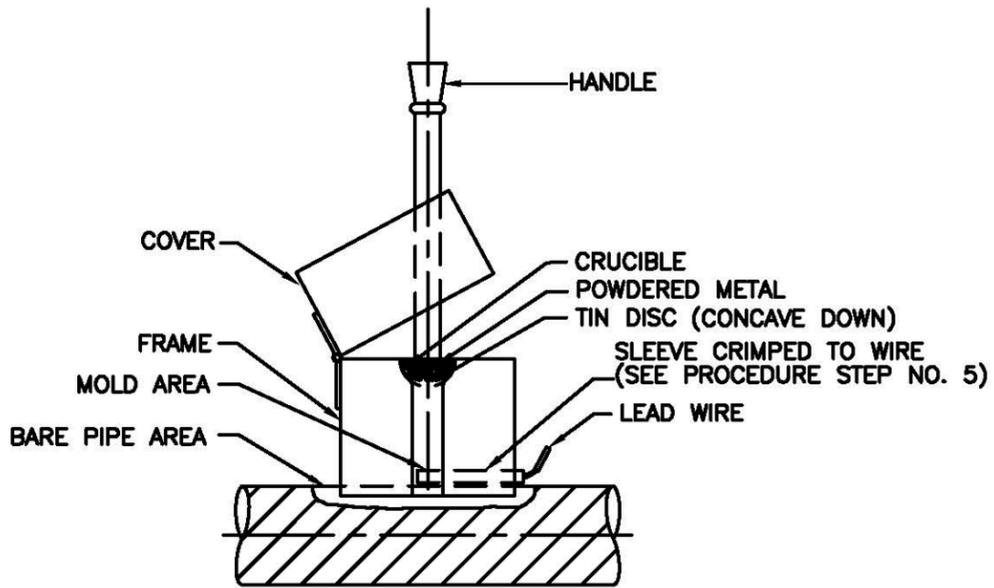


EO-14134-C

REVISIONS

P. CARNEVALE 3/23/01	6
REDRAWN TO AUTOCAD UPDATED DWG. AND ADDED REF. SPEC# G-8209 3/23/01	
P. CARNEVALE 3/16/06	7
ADDED "ENVIRONMENTAL & SAFETY IMPACT" RAJ. 3/16/06	
M. SIMONE 12/3/10	8
CORRECTED SPELLING ERROR D. JACOBS 10/19/10	



PROCEDURE

- 1- REMOVE SUFFICIENT PROTECTIVE COATING FROM PIPE TO EXPOSE AREA LARGE ENOUGH FOR MOLD. PCBs, ASBESTOS OR LEAD MAY BE PRESENT IN COATING. PRIOR TO COATING REMOVAL, REFER TO "ENVIRONMENTAL AND SAFETY IMPACT" BELOW.
- 2- CLEAN EXPOSED AREA OF PIPE DOWN TO BRIGHT METAL USING A FILE, ETC.
- 3- INSERT A TIN DISC IN THE CRUCIBLE, POUR THE CONTENTS OF THE CARTRIDGE INTO THE CRUCIBLE, BEING CAREFUL NOT TO UPSET THE TIN DISC. CRIMP THE BOTTOM END OF THE CARTRIDGE TO MAKE SURE ALL OF THE FINE FUSE POWDER IS REMOVED. CLEAN AWAY ANY POWDER WHICH MAY HAVE SPILLED OR IS NOT IN THE CRUCIBLE. PLACE A SMALL AMOUNT OF STARTING POWDER ON TOP EDGE OF MOLD UNDER COVER OPENING FOR EASY IGNITION, THEN CLOSE COVER.
- 4- REMOVE INSULATION FOR APPROXIMATELY 1" FROM THE END OF THE WIRE TO BE THERMIT WELDED.
- 5- INSTALL ADAPTER SLEEVE ON #10 SOLID WIRE: ON # 10 STRANDED WIRE, SLEEVE IS NOT NEEDED.
- 6- PLACE THE BARE END OF THE WIRE ON CLEANED SURFACE OF PIPE.
- 7- PUT THE MOLD IN PLACE OVER THE WIRE AND IGNITE POWDER.
- 8- REMOVE THE MOLD AND CLEAN OUT ANY SLAG IN THE MOLD.
- 9- STRIKE THE WELD SHARPLY WITH A HAMMER TO TEST ADHESION, THEN RECOAT PIPE AS PER G-8209.

PRECAUTION AND NOTES:

PRIOR TO USING THE THERMIT WELD PROCESS, CHECK THE EXCAVATION USING AN APPROVED GAS DETECTOR FOR THE POSSIBLE PRESENCE OF COMBUSTIBLE GAS. THE PROCESS SHALL BEGIN ONLY WHEN SAFE CONDITIONS ARE INDICATED, AND THERE IS NO INDICATION OF COMBUSTIBLE GAS.

USE #10 AWG. WIRE WITH POLYETHYLENE TW OR THW INSULATION.

DO NOT STAND WITH YOUR FEET DIRECTLY UNDER THE MOLD UPON IGNITION. ALWAYS WEAR LEATHER OR HEAVY CANVAS WORK GLOVES.

DO NOT USE THE #25 CARTRIDGE (CAST IRON) ON STEEL PIPE, USE THE # 15 CARTRIDGE ON STEEL PIPE.

USE THIS PROCESS ON CLEAN DRY SURFACES ONLY.

IF THE MOLD DOES NOT MAKE GOOD CONTACT ALONG THE PIPE SURFACE WRAP DUCT SEAL ALL AROUND MOLD CONTACT AREA.

REFERENCE STANDARD:

G-8209- "FIELD COATING OF STEEL PIPE AND FITTING INSTALLED UNDERGROUND AND IN SUBSURFACE STRUCTURES."

ENVIRONMENTAL AND SAFETY IMPACT

ALL OPERATIONS THAT ARE PERFORMED (i.e. COAL TAR REMOVAL, DISPOSAL, INSTALLATION, ETC.) MUST BE IN COMPLIANCE WITH ALL APPLICABLE SPECIFICATIONS, CORPORATE SAFETY PROCEDURES (CSPs), GENERAL SAFETY INSTRUCTIONS (GSIs), CORPORATE ENVIRONMENTAL PROCEDURES (CEPs) AND GENERAL ENVIRONMENTAL INSTRUCTIONS (GEIs).

**THERMIT WELD PROCESS FOR
ATTACHING WIRE TO PIPE OR FITTING**

CONSOLIDATED EDISON COMPANY OF N.Y., INC.
GAS OPERATIONS DEPARTMENT

DATE 5/18/71 | DWG. NO. **EO-14134-C** REV. **8**
LAST REV. 12/3/10