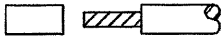


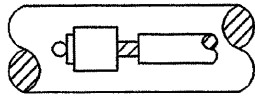
STEP 1.

FILE STRUCTURE CONNECTION AREA (3 IN. x 3 IN.) TO BARE SHINY METAL AND CLEAN.



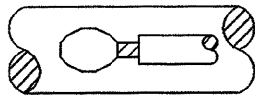
STEP 2.

STRIP INSULATION FROM WIRE. ATTACH SLEEVE (REQUIRED ON NO. 8 AWG WIRE OR SMALLER).



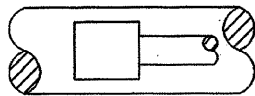
STEP 3.

HOLD MOLD FIRMLY WITH OPENING AWAY FROM OPERATOR AND IGNITE WITH FLINT GUN.



STEP 4.

REMOVE SLAG FROM CONNECTION AND PEEN WELD FOR SOUNDNESS.

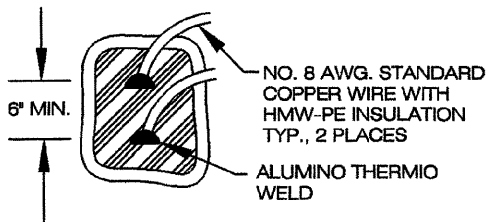


STEP 5.

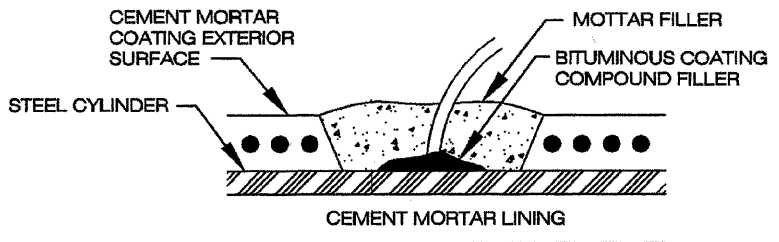
COVER CONNECTION AND EXPOSED STRUCTURE SURFACE WITH A BITUMINOUS COATING COMPOUND. PLACE PLASTIC SHIELD CAP FIRMLY OVER CONNECTION.

NOTES:

1. ALL WIRE WELDS SHALL BE MINIMUM 6 INCHES APART.
2. STANDARD WELD CARTRIDGES SHALL BE USED FOR STEEL SURFACES, FOR DUCTILE IRON AND CAST IRON, USE XF-19 ALLOY OR EQUIVALENT.
3. WELDER SHOWN IS FOR HORIZONTAL SURFACES, FOR VERTICAL SURFACES, SIDE WELDER IS REQUIRED.
4. ALL EXPOSED METAL STRUCTURE, WIRE, WELD, SHALL BE COATED WITH BITUMINOUS COMPOUND.



NOTE: WELD TEST STATION WIRES AT PIPE JOINTS WHENEVER POSSIBLE



WIRE CONNECTION DETAIL FOR MORTAR COATED STEEL PIPE

REVISIONS	APPROVED	DATE	VISTA IRRIGATION DISTRICT	PATH: (TOM) H:\STDDWGS\8-15.DWG
			ALUMINO-THERMIC WELD	<i>John A. Amodeo</i> JOHN AMODEO R. C. E. 31161
				DATE
ACAD		6/86		STANDARD DRAWING 8-15