

INSTRUCTION

MOULD

1



Pre-heating with a butane torch to ensure the mould is totally dry before every first joint regardless of new or used mould. Otherwise, the mould may crack or break or a bad joint produced or cuts down the lifespan of the mould.

2



Always clean the surfaces of the conductors with a card cloth brush before performing exothermic welding. Do not grind or use sandpaper.

3



Pre-heating with a butane torch to ensure the surfaces to be joint is free from oil, dirt and moist.

4



When jointing to a steel surface, use a grinder to skim the surfaces of steel surface e.g. rail, angle bar, U-beam, steel plate, etc to remove rust, carbon, paint and dirt. Then, heat the surface with a butane torch.

5



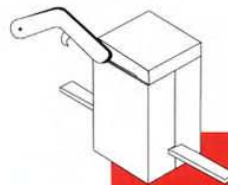
To avoid cracking or breaking the mould, ensure that all conductors fit snugly into the mould. In the mould, allow a space of about 2 to 3 mm. Between the ends of the conductors to allow a better flow of weldmetal. Then, lock the handle clamp. Always make sure the mould is in a level position. Place the correct size of retaining disc and make sure the disc sits well at the base of the weldmetal cavity.

6



Pour a factory's recommended size of weldmetal into the mould crucible. Check for leaks, make sure the weldmetal does not enter into the weld cavity. If it does leak, repeat the whole of step 5. At the inner bottom of the tube, you will find the starting powder, then loosen the starting powder from the tube and pour 2/3 of it on top of the weldmetal and the balance at the mouth of mould lid marked "X".

7



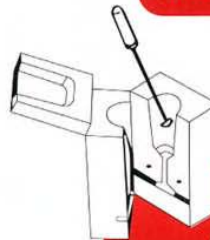
Ignite the starting powder at the lid opening. Warning: Only fire from the side of the mould, do not place your hand or any other flammable items around the mould. Use only a recommended flint gun.

8



Open the mould after 20 seconds to allow the solidification of the joint, then remove the solidified joint carefully from the mould and leave it to cool to ambient temperature.

9



Gently scrap off the unwanted slag (aluminium oxide) from the crucible with a mould scraper.

10



Finally, clean the crucible and weld cavity with a mould cleaning brush. Only a mould cleaning brush would help endure the mould.