

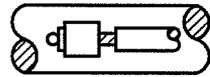
STEP 1.

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



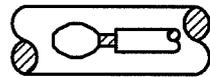
STEP 2.

STRIP INSULATION FROM WIRE. ATTACH SLEEVE (REQUIRED ON NO.4 AWG WIRE AND SMALLER).



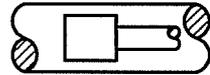
STEP 3.

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



STEP 4.

REMOVE SLAG FROM CONNECTION AND PEEN WELD FOR SOUNDNESS.

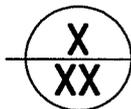


STEP 5.

COVER CONNECTION AND EXPOSED STRUCTURE SURFACE WITH AN EPOXY COATING.

NOTES:

1. ALL CABLES WELDS SHALL BE MINIMUM 3 INCHES APART.
2. STANDARD WELD CARTRIDGES SHALL BE USED FOR STEEL SURFACES. FOR DIP USE XF-19 WELD CARTRIDGES.
3. A FIRE PERMIT FROM LBNL FIRE DEPARTMENT IS REQUIRED.



EXOTHERMIC WELD DETAIL

SCALE: NONE

LBNL STANDARD EXOTHERMIC WELD DETAIL	DRAWN BY	DATE
	CHECKED BY	
	APPROVED BY	
	CAD FILE PATH	
	SCALE	NTS
UNIVERSITY OF CALIFORNIA LAWRENCE BERKELEY NATIONAL LABORATORY FACILITIES DIVISION	DRAWING NO.	SHEET
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	PROJECT NO.	