

GEOTECHNICS ACCESSORIES

TDS 263-13

Technical Data Sheet



Waterstop Welding Blade 220V

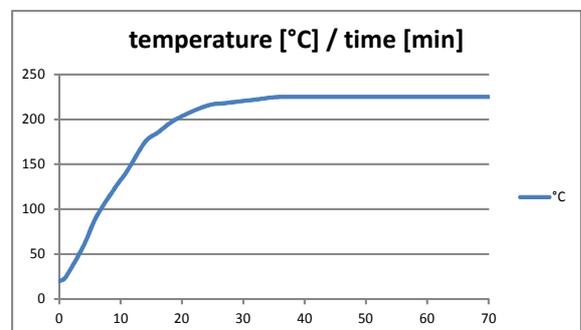
COD: WAT-LAMA
TDS 263-13

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Revision date: 02/2015

Hot Blade to weld together Flexvinil® waterstop profiles.

DIMENSIONS	DIMENSIONS	DIMENSIONI
<ul style="list-style-type: none"> - Weight: 2750 g - Overall length: 850 mm - Hot Blade length: 550 mm - Hot Blade width: 60 mm 	<ul style="list-style-type: none"> - Poids: 2750 g - Longueur totale: 850 mm - Longueur lame chauffante: 550 mm - Largeur lame chauffante: 60 mm 	<ul style="list-style-type: none"> - Peso: 2750 g - Lunghezza complessiva: 850 mm - Lunghezza lama scaldante: 550 mm - Larghezza lama scaldante: 60 mm
TECHNICAL DATA	DONNEES TECHNIQUES	DATI TECNICI
<ul style="list-style-type: none"> - Voltage: 220 V / 450 W - Warm up time: 20 min - Working temperature: 200-220 °C - Cooling time: 40 min 	<ul style="list-style-type: none"> - Voltage : 220 V / 450 W - Temps de chauffage: 20 minutes - Température d'exercice : 200-220 °C - Temps de refroidissement : 40 minutes 	<ul style="list-style-type: none"> - Voltaggio: 220 V / 450 W - Tempo riscaldamento: 20 min - Temperatura di esercizio: 200-220 °C - Tempo raffreddamento: 40 min

WARNING: HOT SURFACE – PLEASE READ MSDS ABOUT FLEXVINIL WATERSTOP



Sireg Welding Blade Safety Manual

Do not use the **Sireg Welding Blade** unless you read and understand the instructions and warnings in this manual. If any doubt or question arises about the correct or safe method of performing anything found in this manual contact **Sireg SPA**.

Personal Protection

Always wear protective gear before start welding process.

Temperature resistant gloves / Safety goggles / Protective shoes/boots / Respirator, if operating in indoor confined spaces.

Electrical Safety & Standards

Ensure all electrical connections are in good working order prior to plugging in Sireg Welding Blade.

Ensure appropriate electrical connections are in good working order.

Do not alter the tool in any way. Doing so could be a hazard and void the warranty.

Keep iron away from water and never operate with wet hands.

Do not use the **Sireg Welding Blade** with a damaged cord.

Never use the **Sireg Welding Blade** with non-regulated voltages.

Understand the Safety Manual and User Guide before plugging in Sireg Welding Blade. In case of doubt don't hesitate to contact **Sireg SPA**.

Worksite Safety

Do not leave unattended the **Sireg Welding Blade** in the work area.

Never use **Sireg Welding Blade** on slippery, wet, or muddy surfaces. The location should be flat, dry, and free from any tall grass, brush, or ignitable objects.

Welding should be done in a well ventilated area. In confined areas, a respirator should be worn as melting plastic waterstop fumes may be harmful to your health.

Never use your **Sireg Welding Blade** in the dark.

Operating Safety

Allow only one person to work on **Sireg Welding Blade** at a time.

Only qualified personnel should operate **Sireg Welding Blade**.

Keep children, bystanders, and animals, at least twenty 5 meters away from the work area.

Always unplug the iron when not in Use.

Never operate under the influence of medications, drugs or alcohol.

Iron operates at very high temperature and can burn flesh or cause ignition, even after being unplugged (until cool).

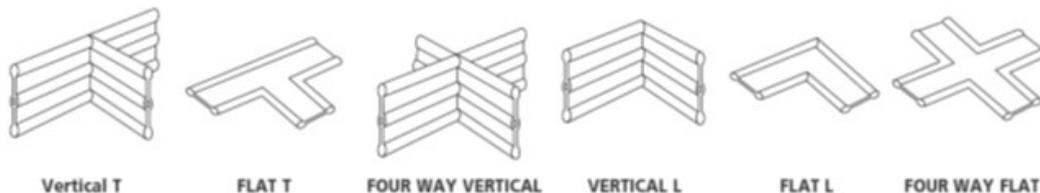
Never, under any circumstances, alter your **Sireg Welding Blade**. Altering the equipment, or using the equipment in such a way as to change its design capabilities and capacities, could result in serious or fatal injury and WILL VOID THE WARRANTY.

Waterstop Sireg Welding Blade Job Site Installation User Guide

Follow all of the instructions contained in this sheet to ensure a safe procedure and structurally waterstop welds.

Welding Technique:

Following is the proper procedure, as recommended by **SIREG SPA** for field welding PVC waterstops. Provide factory fabricated corners, intersections and transitions, leaving only straight butt joint splices for the field.



Standard factory fabricated junction pieces

An initial warm up time of approximately 20 minutes is required to heat up **Sireg Welding Blade** to the required temperature (180° - 190° C / 350 - 380°F).



1. Always cut square ends before welding waterstops. Never weld to extruded ends. Use flat work table to create field splices. Work area should be solid and have access to power supply and have jigs and fixtures to aid splicing. Cut ends square, using a razor knife or circular saw equipped with a carbide tipped blade to ensure matching edges.



2. Wait that the **Sireg Welding Blade** preheat to the desired temperature ranges. Place the blade between butt ends. Keep waterstops in place until approximately 5mm bead forms on each side of waterstops.



3. Quickly remove **Sireg Welding Blade** and gently press waterstops ends together until they bond (approximately 3 to 5 minutes or cool to touch). Cold water may be sprayed on waterstops to expedite the bond.

Sireg Aluminium waterstop welding jig is designed to perfectly align the straight legs of **SIREG SPA** Waterstop securing the two lengths, and making for significantly easier field welding.

NOTE: When welding , if you do not join ends quickly, the melted material will skin over, resulting in an inadequate bond.

Unacceptable splicing defects include:

- Tensile strength less than 80 percent of the parent section.
- Misalignment of centerbulb, ribs, and end bulbs greater than 1,5mm.
- Bond failure at joint deeper than 1,5mm or 15 percent of material thickness, whichever is less.
- Misalignment which reduces waterstop cross section more than 15 percent.
- Visible porosity in the weld.
- Bubbles or inadequate bonding.
- Visible splice separation when a cooled splice is bent by hand at a sharp angle.
- Charred or burnt material.

Warranty

SIREG SPA. warrants this **Sireg Welding Blade** to the original user against defective material or workmanship for a period of 2 years days from the purchase date.

As of all other technical indications and information provided by us, the only purpose of this data sheet is to describe the nature of this product, as well as its possible applications and fields of use. However, it does not guarantee certain properties of this product or its suitability for a determined purpose of application; furthermore, the directions for use given in this data sheet are not complete. Since this data sheet is subject to modification, it is the duty of our clients to ensure that they refer to the latest version. The updated data sheets can be obtained at all times from all our locations. In addition, the current general terms of business are applicable.