



TOOLS AND EQUIPMENT



- Pipe cutter
- Chamfering tools
- Felt pen
- Personal Protection Equipment
- Soft, lint-free cloths
- Socket depth gauge
- Gloves

CHOOSE YOUR WELDING POLYMER



Cleaner+	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
HTA FUSION	<input checked="" type="checkbox"/>			
CSTB certified adhesive*			<input checked="" type="checkbox"/>	
HPFIX	<input checked="" type="checkbox"/>			
GAFIX		<input checked="" type="checkbox"/>		

* Cold water

SERVICES

Telephone hotline, training sessions, production of drawings and bills of materials, a BIM library, induction training on site: an entire team is there to help.



Telephone hotline

To answer your questions:

+33 (2)41.63.73.25



On-site technical assistance

A team at your side to support you in getting your job started.



Training centre

Helping contractors and specifiers to understand GIRPI system installation techniques.



Custom-made fabricated items

A workshop at your disposal to produce special parts.



safety for your pipeworks
an *OAliaxis* company

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INSTALLATION ACCESSORIES

A STEP BY STEP GUIDE TO GOOD COLD WELDING



safety for your pipeworks

PREPARING THE JOB

CHECKLIST:

HAVE ALL THE ITEMS YOU NEED IN YOUR POSSESSION:

- Pipes and fittings
- Welding polymers, cleaner
- Tools
- PPE Personal Protection Equipment

CHECK YOUR EQUIPMENT BEFORE STARTING:

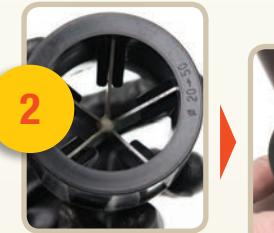
- Do I have the right welding polymer?
- Is it still in good condition?
- Do I have cleaner and clean rags?
- Check the use-by dates

CHECK AMBIENT WORKING CONDITIONS:

- Installation temperature between:
 - -5°C and +40°C for the HTA® Fusion welding polymer
 - +5°C and +35°C for other welding polymer
- Avoid strong sunlight, rain, wind
- Work in a clean, well-ventilated location

Step 1

PREPARE



TIPS
Chamfering facilitates joining and allows for an even distribution of the welding polymer between the pipe and fitting to be joined.

CHAMFER SIZE	
PIPE Ø	CHAMFER LENGTH
Ø 16	1 - 2 mm
Ø 20 - Ø 50	2 - 3 mm
Ø 63 - Ø 225	3 - 6 mm

3 **Deburr / trim** the inside of the pipe.

**4**

Check: the pipes and fittings must be clean and dry, with no scratches or impact marks.

**5**

Measure and mark the socket depth of the fitting using the gauge.

**TIPS**

Remember to mark the orientation of the fittings.



PROHIBITED

The following actions may jeopardise the quality of the welds.

- Do not store the pipes in unprotected or exposed areas, e.g. directly on the ground, exposed to rain, sunlight, etc.
- Do not apply the welding polymer with an unsuitable tool (piece of wood, rag, finger, glove, etc.).
- Do not dilute the welding polymers with water or solvents.
- Do not apply sustained forces (twisting, pulling) during the first minutes following assembly. Do not adjust a fitting's orientation after assembly.
- Do not allow the welding polymer to dry between application and joining.

Step 2

JOIN



6 **Clean the parts to be welded**, first female then male, using CLEANER+. Use a clean, lint-free piece of cloth. Leave to dry or wipe dry using a soft, lint-free piece of cloth.

7

Shake the pot for 5 seconds to mix the polymer when doing the first welds of the day. The more the polymer is shaken, the more fluid it will be. If you find that it is too fluid, leave it to settle for a few minutes.

**8**

Apply the welding polymer in a thin, uniform coat. To obtain better adherence, carry out 4 to 8 rotations (depending on the diameter) on the Female parts first, and then the Male parts.

**TIPS**

To avoid droplets, remove any surplus polymer by scraping the applicator on the neck of the pot.

250 ML POT > For Ø16 to Ø50

1 L POT > For Ø40 to Ø160

Applicators optimised for the size of the pipes are provided with the pots. Larger sized applicators are also available for diameters above 110 mm, on ref PAB1L

TIPS

- Work in a team of 2 for Ø ≥ 90.

**TIPS**

Leaving the welding polymer bead as it is helps check that the weld is done.

**10**

Clean off drips using a clean, lint-free piece of cloth.

Remember to close the pot after each use.

After joining, make sure that the recommended drying times are respected before loading the network with pressurised water, whether for new installations or for renovations. For further information, refer to the label on the pot of welding polymer.

