

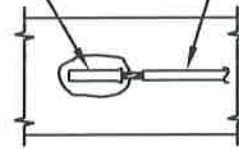
DUCTILE IRON OR
STEEL PIPE OR
FITTING



CLEAN SURFACE TO
BRIGHT METAL AT WELD
LOCATION BY
MECHANICAL GRINDER.

STEP 1

ADAPTER SLEEVE (AS RECOMMENDED BY
THERMITE WELD MOLD MANUFACTURER
FOR SMALL WIRE DIAMETERS).

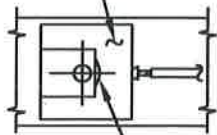


STRANDED COPPER
WIRE (WITH THWN
OR HMWPE
INSULATION).

STRIP INSULATION FROM WIRE AND
INSTALL COPPER ADAPTER SLEEVE AS
REQUIRED FOR WIRE SIZE, SEE NOTE 2.

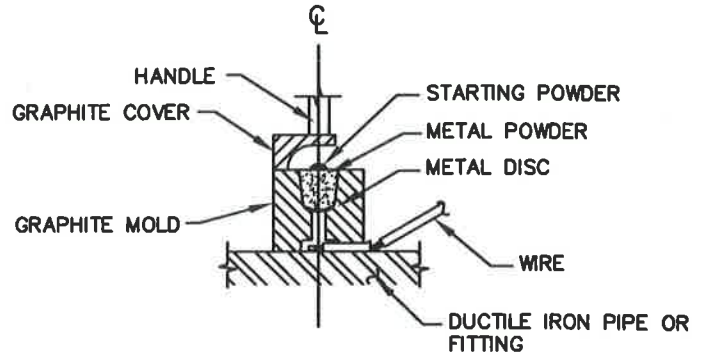
STEP 2

GRAPHITE MOLD



OPENING

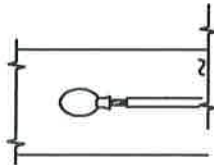
TOP



SIDE

HOLD GRAPHITE MOLD FIRMLY OVER ADAPTER SLEEVE WITH OPENING AWAY FROM OPERATOR
- IGNITE STARTING POWDER.

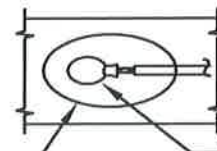
STEP 3



REMOVE SLAG FROM CONNECTION. THOROUGHLY
CLEAN WELD AREA.

STEP 4

COAT ALL EXPOSED
METAL AT WELD AREA.



THERMITE WELD

WIRE

DUCTILE IRON PIPE
OR FITTING

STEP 5

NOTE:

1. THERMITE WELDS SHALL BE COATED WITH A PREFABRICATED ONE PIECE PLASTIC CAP PER SPECIFICATIONS.
2. A COPPER SLEEVE IS REQUIRED FOR THERMITE WELD WIRE CONNECTIONS USING #10 AWG WIRE OR SMALLER.

WASHINGTON
SUBURBAN
SANITARY
COMMISSION

APPROVED:

8/12/16

Chief Engineer

STANDARD DETAIL
THERMITE WELD
DETAIL

C
2.1