exothermic welding CC1

Straight in-line joint of two bare copper conductors

Complies with IEEE 837 and UL 467

Conductor-to-conductor exothermic welding



Code	CC1
Connection type	Straight in-line joint of two bare copper conductors
Group	Conductor to conductor
Conductor cross-section	10 to 400 mm²
Weld powder	KWD 032 to 2 × KWD 150
Matching handle clamp	HC 01
Standard	As per IEEE 837 and UL 467
Mould body material	High-grade graphite
Mould lid material	Stainless steel
Mould life	50 to 60 welds with correct use

exothermic welding CC1 Used for straight in-line joints of two bare copper conductors in earthing, bonding and lightning protection networks. After welding, the joint becomes one with the conductors and has no bolts or nuts to work loose over time.

Mould and powder selection table

Main conductor (mm²)	Weld powder	Mould code
10	KWD 032	CC1-010
16	KWD 032	CC1-016
25	KWD 032	CC1-025
35	KWD 045	CC1-035
50	KWD 045	CC1-050
70	KWD 065	CC1-070
95	KWD 090	CC1-095
120	KWD 115	CC1-120
150	KWD 115	CC1-150
185	KWD 150	CC1-185
240	KWD 200	CC1-240
300	KWD 250	CC1-300
400	2 × KWD 150	CC1-400

> The mould code and powder size are also marked on the lid of each mould. Do not substitute powder from another mould or another size. For other sizes, contact our specialists.

Preparation and welding

Cut the conductor end straight with wire cutters so the strands do not open and splay, brush up to about 5 cm of the end to a shine with a wire brush, and hold any conductor under tension or bent steady with a clamp.

1. Check the mould and powder against the table.
2. Preheat a cold mould before the first weld.
3. Clean the conductors to bright metal and dry them fully.
4. Close the handle clamp, place the conductors in the centre of the chamber and lock the mould.
5. Place the steel disc concave side up and pour in the powder.
6. Add the starting powder, close the lid and ignite it with a flint igniter.
7. Wait at least one minute, then open the mould.
8. Clean the mould with a soft brush and a scraper; never use a wire brush.

Welds KALWELD Complies with IEEE 837 and UL 467 , welds KALWELD have passed freeze testing (10 cycles), thermal cycling (25 cycles) and a 20 kA short-circuit test at the Power and Water University of Technology (Shahid Abbaspour) (reports 95/4221 and 95/4220, 1395/12/24).

Result
Approved by

Full illustrated guide, safety notes and troubleshooting: exothermic welding instructions KALWELD at www.kalot.ir

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