exothermic welding CC2

T joint of bare copper conductor

Complies with IEEE 837 and UL 467

Conductor-to-conductor exothermic welding



Code	CC2
Connection type	T joint of bare copper conductor
Group	Conductor to conductor
Conductor cross-section	16 to 300 mm²
Branch conductor	16 to 240 mm²
Weld powder	KWD 045 to 2 × KWD 200
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 CC2 Used for T joints of bare copper conductor in earthing networks, bonding and lightning protection. Once welded, the joint becomes one with the conductors and has no bolts to work loose over time.

Mould and powder selection table

Main conductor (mm²)	Branch conductor (mm²)	Weld powder	Mould code
16	16	KWD 045	CC2-016-016
25	16	KWD 045	CC2-025-016
25	25	KWD 045	CC2-025-025
35	25	KWD 045	CC2-035-025
35	35	KWD 045	CC2-035-035
50	25	KWD 065	CC2-050-025
50	35	KWD 065	CC2-050-035
50	50	KWD 090	CC2-050-050
70	25	KWD 065	CC2-070-025
70	35	KWD 065	CC2-070-035
70	50	KWD 090	CC2-070-050

Main conductor (mm²)	Branch conductor (mm²)	Weld powder	Mould code
120	120	KWD 150	CC2-120-120
150	50	KWD 115	CC2-150-050
150	70	KWD 115	CC2-150-070
150	95	KWD 150	CC2-150-095
150	120	KWD 150	CC2-150-120
150	150	KWD 200	CC2-150-150
185	70	KWD 150	CC2-185-070
185	95	KWD 150	CC2-185-095
185	120	KWD 200	CC2-185-120
185	150	KWD 200	CC2-185-150
185	185	KWD 200	CC2-185-185

Main conductor (mm²)	Branch conductor (mm²)	Weld powder	Mould code
70	70	KWD 090	CC2-070-070
95	35	KWD 090	CC2-095-035
95	50	KWD 090	CC2-095-050
95	70	KWD 090	CC2-095-070
95	95	KWD 115	CC2-095-095
120	35	KWD 090	CC2-120-035
120	50	KWD 090	CC2-120-050
120	70	KWD 090	CC2-120-070
120	95	KWD 115	CC2-120-095
240	95	KWD 150	CC2-240-095
240	120	KWD 200	CC2-240-120
240	150	KWD 200	CC2-240-150
240	185	KWD 250	CC2-240-185
240	240	2 × KWD 150	CC2-240-240
300	120	KWD 250	CC2-300-120
300	150	KWD 250	CC2-300-150
300	185	2 × KWD 150	CC2-300-185
300	240	2 × KWD 200	CC2-300-240

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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