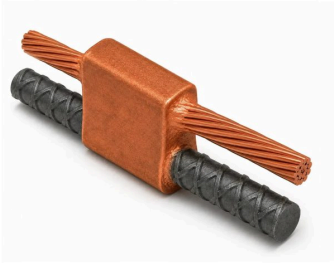
# exothermic welding CR17

Copper conductor parallel to a reinforcing bar

**Complies with IEEE 837 and UL 467**

Conductor-to-reinforcing bar exothermic welding



| | |
|---|---|
| Code | CR17 |
| Connection type | Copper conductor parallel to a reinforcing bar |
| Group | Conductor to reinforcing bar |
| Conductor cross-section | 16 to 300 mm² |
| Reinforcing bar | 10 - 40 mm |
| Weld powder | KWD 115 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 CR17 Used for joining a copper conductor parallel to a reinforcing bar in earthing, bonding and lightning protection networks. After welding, the joint fuses with the conductors and has no nuts or bolts to work loose over time.

## Mould and powder selection table

| Reinforcing bar (mm) | Conductor (mm²) | Weld powder | Mould code |
|---|---|---|---|
| 10 - 40 | 16 | KWD 115 | CR17-016 |
| 10 - 40 | 25 | KWD 115 | CR17-025 |
| 10 - 40 | 35 | KWD 115 | CR17-035 |
| 10 - 40 | 50 | KWD 150 | CR17-050 |
| 10 - 40 | 70 | KWD 150 | CR17-070 |
| 10 - 40 | 95 | KWD 200 | CR17-095 |
| 10 - 40 | 120 | KWD 200 | CR17-120 |
| 10 - 40 | 150 | KWD 250 | CR17-150 |
| 10 - 40 | 185 | 2 × KWD 150 | CR17-185 |
| 10 - 40 | 240 | 2 × KWD 150 | CR17-240 |
| 10 - 40 | 300 | 2 × KWD 150 | CR17-300 |

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

Use a grinder or brush to clean rust, mill scale and any coating from the weld area on the reinforcing bar until it shines. Wrap ribbed reinforcing bar with the heat insulation from the box so molten metal cannot run out between the ribs.

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 https://kalot.ir



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