# exothermic welding TT2

90-degree elbow (L) joint of two copper tapes

**Complies with IEEE 837 and UL 467**

Tape-to-tape exothermic welding



| | |
|---|---|
| Code | TT2 |
| Connection type | 90-degree elbow (L) joint of two copper tapes |
| Group | Tape to tape |
| Tape dimensions | 20×3 to 60×5 mm |
| Weld powder | KWD 115 to 2 × KWD 250 |
| 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 TT2 Used for a 90-degree elbow (L) joint of two copper tapes in earthing grids, bonding and lightning protection. 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 tape (mm) | Branch tape (mm) | Weld powder | Mould code |
|---|---|---|---|
| 20×3 | 20×3 | KWD 115 | TT2-203 |
| 20×5 | 20×5 | KWD 150 | TT2-205 |
| 25×3 | 25×3 | KWD 150 | TT2-253 |
| 25×5 | 25×5 | KWD 200 | TT2-255 |
| 30×3 | 30×3 | KWD 200 | TT2-303 |
| 30×5 | 30×5 | KWD 250 | TT2-305 |
| 40×3 | 40×3 | KWD 250 | TT2-403 |
| 40×5 | 40×5 | 2 × KWD 150 | TT2-405 |
| 50×5 | 50×5 | 2 × KWD 200 | TT2-505 |
| 60×5 | 60×5 | 2 × KWD 250 | TT2-605 |

In this table the main tape and the branch tape are the same size; for two tapes of different sizes, send both sizes to our specialists.

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 tape ends square, flatten them and brighten them with a wire brush so the edges sit side by side in the mould with no gap.

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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