

TERRAIN

Technical Bulletin No.7 (2013)

Polypipe Terrain FUZE Electrofusion Welding

Polypipe Terrain's FUZE system is a high performance drainage range that has many advantages over cast iron and other traditional systems.

Manufactured from high density polyethylene (HDPE), Terrain FUZE delivers a comprehensive, modern solution to above ground non-pressure drainage requirements, providing specifiers and installers maximum flexibility in the design process.

Utilising the intrinsic properties of HDPE, Terrain FUZE offers greater benefits above and beyond more traditional materials and performs significantly better when tested for impact and abrasion resistance as well as chemical corrosion. Any drainage system is only as good as the joints made. Terrain FUZE can be joined in a number of different ways including butt fusion welding, ring seal sockets and electrofusion welding. In this bulletin we are going to explain the procedure for making an electrofusion welded joint.

Procedure for making an electrofusion welded joint.

Step 1. Cut the pipe or fitting using the appropriate pipe cutter or saw. Make sure the end of the pipe or fitting is square and clean.



Step 2. Scrape the oxidation layer from the spigot of the pipe or fitting to at least the insertion depth of the coupling using the appropriate pipe scraper. Ensure that the spigot ends and the couplers are kept clean and free from dirt, water and grease.



Step 3. Insert into the centre stop of the coupling. Mark the spigots using a wax pencil.



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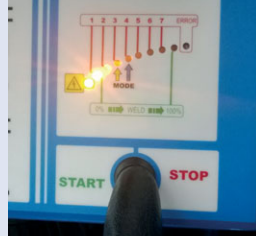
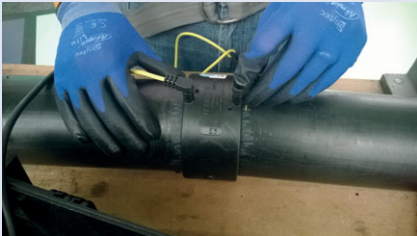
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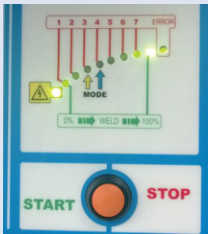
Step 4. Unpack your Polypipe Terrain FUZE electrofusion welding machine and ensure you have the correct leads attached.



Step 5. Ensuring that the pipe work is supported correctly, attach the leads to the coupling and push the start/stop button. This will begin the electrofusion welding process.



Step 6. There will be two visual indications showing that the weld has been completed successfully. The first will be on the screen showing that the welding is 100% complete. The second will be a visual indication on the coupling, as shown below.



The before and after



Before weld



After weld