MecFlow CLICKWELD

Technical Bulletin

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Electrofusion Welding

A key feature of the MecFlow system is its CLICKWELD fittings. Electrofusion welding provides a simple, rapid method of creating a consistent weld between the spigots inserted into the electrofusion fitting, and the electrofusion fitting itself.

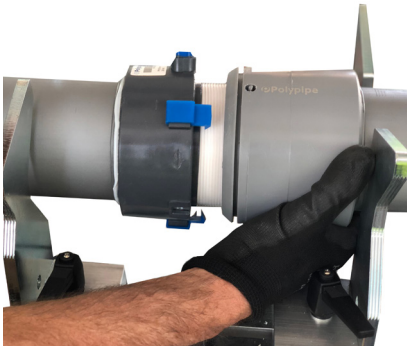
Each coupling features a barcode label that can be scanned by the electrofusion machine for the purpose of Automatic Weld parameter set-up and weld parameters data storage, as shown in the picture.

The label also contains the welding parameters that need to be set, should the electrofusion machine require a manual set-up. Please refer to table 1.

Pre-Welding Process

1. Remove the cap from the CLICKWELD coupling, and slide towards the intended CLICKWELD fitting.

2. Check that the spigot/socket is free of any mechanical damage or defects, and insert the spigot into the socket, clicking the clips of the CLICKWELD coupling into the grooves of the fitting.



3. Check that the joint has no angular deflection – adjust the containment accordingly.

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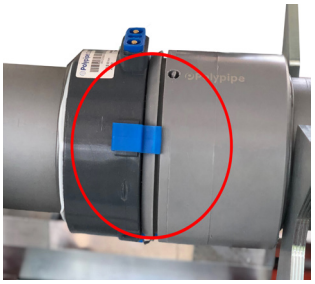
Welding Process



1. Check that all clips are fully engaged and that there is a consistent gap around the circumference of the CLICKWELD joint.

2. Connect the terminals of the welder to the electrofusion coupling.

3. Provided the machine is not showing an error, cycle the machine through the welding sequence.
If available, use a bar coding reader to scan the coupling or refer to table 1.

4. Once the weld sequence has successfully completed, leave the welded coupling to cool down for the time indicated on the label. Do not disturb the coupling during the cooling period. Cooling time should be extended in ambient temperatures above 25°C, or when welding in strong direct sunlight.

Diameter	Voltage	Weld Time (seconds)	Cooling (minutes)
75	22	110	5
90	26	120	5
110	32	110	5
125	40	130	5

Table 1

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