

Welding Dyna-Flow® and Lightwall Pipe

Welding on Dyna-Flow® Pipe

The physical characteristics of Dyna-Flow sprinkler pipe are ideal for welding. Although the thinner wall requires less welding heat, it is compatible with standard manual and automatic welding practices. No alloys or additives are utilized that would cause any change in the weld fumes. The mill coating on the exterior surface of the pipe is a safe non-carcinogenic material which is non-toxic when welded. When done properly, Dyna-Flow has been proven to weld better and warp less than Sch-10 sprinkler pipe.

RECOMMENDED-WELDING-PRACTICES:

1. Lower the weld heat.
2. Use a 75% Argon: 25% CO2 gas mixture, or 100% Argon.
3. Change the angle of the welding tip so that it points more toward the outlet and less on the pipe. This is easily done in manual welding. For automatic welders, see the following page notes.
4. For wire-feed welders, use an .035 gauge wire maximum. For stick welders, change to a smaller stick; 6013 – 3/32" is ideal.

If there are holes in the weld at the nipple, it is because the weld was made with excessive heat, or at the wrong angle. The coating on Dyna-Flow does not interfere with welding. A test weld should be made to be sure of the correct heat setting before continuing on with entire job. Take standard precautions when doing any welding to avoid inhalation of fumes or eye injury.

Automatic Welding of Lightwall Pipe

The physical characteristics of Dyna-Flow® sprinkler pipe are ideal for welding. Although the thinner wall does require less welding heat, it is compatible with standard and automatic welding practices. No alloys or additives are utilized that would adversely affect these practices. The mill coating on the exterior surface of the pipe is a safe, non-carcinogenic material which is non-toxic when welded. When done properly, Dyna-Flow has been proven to weld better and warp less than standard Sch-10 pipe.

Using the new N.A.P. Universal Welder® does not alter any of the above. North Alabama Pipe has done extensive testing in conjunction with this product to ensure that this new automatic welding machine is practical for use with all types of sprinkler pipe.

RECOMMENDED WELDING PRACTICES FOR DYNA-FLOW:

1. Wire Feed Speed: 750 – 800 Inches per Min.
2. Welder Voltage: 25.5 – 27 Volts
3. Mixture: 65 – 70% Argon
4. Wire: ER70-S2 (For larger diameter pipe with small outlets, use ER70-S6 or ER70-S7)

It is always advisable to make a test weld to be sure of settings prior to continuing with entire job. Always refer to the owners manual for further instructions.

JUNE 23rd 1998

ALLIED TUBE & CONDUIT
16100 SOUTH LATHROP AVENUE
HARVEY, IL 60426

ATTENTION - ROBERT D. BUSSIERE

DEAR BOB:

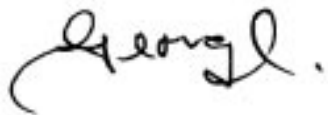
AS PER OUR CONVERSATION THE FOLLOWING ARE THE RECOMMENDATIONS FOR WELDING SUPER FLO/DYNA-FLOW PIPE WITH OUR NOGEO COMPUTERIZED BURN & WELD SYSTEM:

1. WIRE SIZE RECOMMENDED .030
2. VOLTS 20 - 22
3. WIRE FEED SPEED 425 - 450
4. GAS MIX 75% ARGON 25% CO-2

OUR WELDER BEING COMPUTERIZED CONTROLLED WE ARE HAVING NO DIFFICULTY WELDING THE LIGHT WALL PIPE.

IF ANY OF YOUR CUSTOMERS ARE EXPERIENCING PROBLEMS WITH WELDING, I WOULD BE MORE THAN HAPPY TO TRY AND HELP THEM, THEY CAN REACH ME AT 519-763-0788 OR FAX 519-767-2065.

SINCERELY



GEORGE MCVICKER
PRESIDENT