

- B. Use a swivel coupling between the reamer or compactor and product pipe.

2.2.2 Pipes

- A. Use butt or saddle welded polyethylene for the intended use and comply with the specifications in Section 1.3. The grade of pipe to be determined by calculation provided for in Sections 1.9.E and 1.4.3. Weld pipe into one continuous length such that the pulling operation is continuous.

2.2.3 Pipe Welding

A. General

1. Use butt fusion or electro fusion welding of pipes. All pipes in a continuous string shall have the same physical and chemical characteristics. Obtain the Engineer's approval before joining pipes from different manufacturers.
2. Make site butt fusion joints in accordance with WIS 4-32-08.
3. Use welding equipment and techniques approved by the manufacturer of the pipe.
4. Employ only welders with approved qualifications for the type of weld being used.

B. Butt-welding machinery and fusion process

1. Provide butt-welding machine in accordance with industry standards and current practices.
2. Provide a dust-free habitat with positive air pressure to prevent:
 - a) Dust from being attracted to heater, plate, to prepared PE surface prior to welding.
 - b) Wind chilling of the heater plates and butt welding surfaces
 - c) Operations during sand storms
3. Provide operating parameters, checklists, work orders and job elements in controlling the following:
 - a) Proper and secure siting of the machine
 - b) Provision for lifting equipment for handling pipes and welding machine.
 - c) Provision for friction free feed of pipes to welding machine (e.g.