

cycle of the joint. A suitable shelter shall be used in cold, windy, dusty or wet weather conditions.

- F. Prior to commencing the welding process the Contractor shall measure and ensure that the ovality of the pipe or spigot end is within the limits given in Table 03 of ISO 4427, Part 3.
- G. All pipe work shall be cleaned with disposable alcohol impregnated wipes prior to undertaking the pipe scraping, in order to remove any contamination. Prior to scraping the Contractor shall measure and mark the area of the pipe or spigot end to be scraped in order to remove the oxidized surface to a depth between 0.2 and 0.4 mm. The length of the pipe or spigot end to be scraped shall be equivalent to the insertion depth of the electro-fusion joint plus a distance of between 10 and 20 mm.
- H. Only rotating mechanical scrapers or peelers, which are capable of cutting a continuous strip or ribbon over the insertion length of the coupler or fitting, shall be used.
- I. The fitting shall be removed from its packaging and immediately inserted over the pipe end only after preparation and scraping of the pipe.
- J. Each pipe or spigot end shall penetrate completely its relevant part of the electro-fusion socket.
- K. Alignment clamps shall not be removed before the appropriate cooling time has elapsed. Abnormal displacement of the electric wire coils shall not occur. This shall be checked prior to commencement of the fusion process.
- L. All completed electro-fusion joints shall be inspected in accordance with the requirements of EN 12007 Part 2. Should the joint contain any of the faults described in the standard then the electro-fusion fitting shall be cut out and replaced.
- M. After completion of the fusion process, all fusion indicators shall be checked to ensure that they are in the position indicated in the Manufacturer's instructions. If any fusion indicators are not in the required position the electro-fusion fitting shall be cut out and replaced.
- N. The Contractor shall, on a regular basis allow the Engineer to download the historical data relating to the welds made by the unit through the data retrieval facility.