

3.2.3 SOCKET FUSION WELDING: WELDING SADDLES

Threaded and unthreaded welding saddles allow reduced branches to be made on larger diameter pipes already installed and also pipe headers (e.g. for water meters).

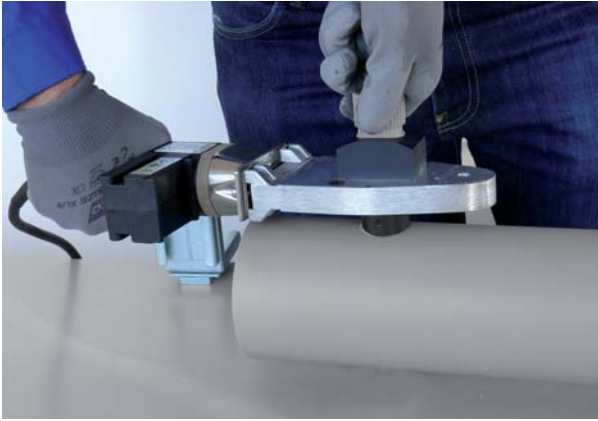
Drill a hole in the pipe with the suitable cutter (item code 00FGS) at the point where you want to make a new branch reduction.

Make sure that the parts to be welded (especially the pipe) are clean and dry.

Check that the welder and die pairs have reached the correct operating temperature of 500°F (260°C).

Insert the male die pair into the pipe hole until the concave part touches the outer surface of the pipe.





Insert the fitting into the female die pair simultaneously. The contact times between die pairs, fitting and pipe shall be those listed in the relevant table.

Once the heating time is over, immediately insert the welding saddle into the heated hole without turning. The fitting must be perfectly fixed and pressed against the pipe surface for about 30 seconds.

After a cooling time of 10 minutes, the new joint can be pressure tested or placed into operation.

When making double pipe arrays for water meters we suggest to:

- Mark in advance the two opposing drilling axes.
- Make all the holes at the same time with the suitable cutter.
- Make the joints in a staggered manner.