

**For FKS pipe electrofusion socket welding following equipments are required.**

- Special FKS electro fusion welding equipment
- Pressing rings for pipe sizes > 800 mm
- Tightening straps
- HDPE cleaner
- Pressure test equipment
- Continuous 15 KVA power supply

1. Welding area is to protect of impureness and humidity.  
Welding to be performed in ambient temperatures above +5°C only. For ambient temperatures below +5°C use heated welding tent or others.

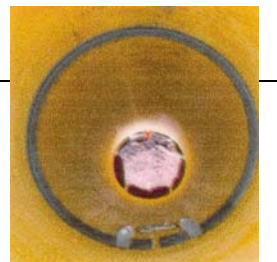
2. Removal of protection foil just before socket installation only.



3. Check socket parts for transport damages.  
Check electro fusion socket contacts to be in 12.00 o'clock position.  
Clean spigot and socket ends using special HDPE cleaner.  
Mark spigot installation depth (min 120 mm) on spigot. Push spigot into the socket and optimize in horizontal and vertical directions.

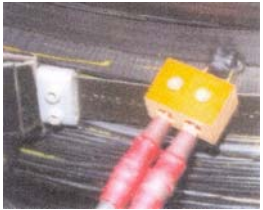




4. Install pressing ring inside the pipe in the welding area for FKS pipes > 800 mm.  
Install tightening straps outside the pipe in the welding area for FKS pipes 300-600 mm



5. Welding to be executed directly after preparations.  
Tightening straps need to be fixed at socket end.  
Tightening tool to be set in a distance of min 25 mm to the socket connections. Tighten the straps unless the spigot is in good position to the socket.



<p>6. Connect the welding cable to the electro fusion wire contacts by using the adapter.</p>	
<p>7. Start welding operation by reading the barcode using the bar code reader and follow the equipment manual. Re-tighten the straps after 60% of welding time. Do not move the pipe connection during the whole welding operation including the indicated cooling time (approx 40 minutes).</p>	
<p>8. Remove the welding cables, tightening straps and pressing ring and mark the socket with the welding parameters.</p>	
<p>9. Perform pressure test.</p>	