



## QUANTUM ALUMINIUM SITE WELDING



### Aluminium Site Welding (T.I.G.) Specification

Aluminium Site Welding (T.I.G.) will be fully in accordance with the Roofing sheet Manufacturers standard details.

Site Welding must be carried out fully in compliance with specification Ref: ASW/T.I.G./001 Rev B 1997.

Weld procedure qualification WPMR01 and WPMR02 complying with BSEN 288 - 2 and - 3 1992.

Welders shall be suitably qualified to the requirements of BSEN 287 -1 1992. Site welding may be tested generally in conjunction with BSEN 30042 1994. Site welding operations carried out fully in accordance with ISO 9001: 2008.

Site welding to be carried out by: M.R Site Services Ltd,

Unit 6, Worcester Trading Estate, Blackpole Road Worcester WR3 8HR

Tel; 01905 755055, Fax; 01905 755053 or similar approved.

All welding shall be carried out by operatives fully trained and conversant with the system manufacturers method of fixing and specifications.

Works should be carried out only by the system manufacturers agreed welding contractors.

## Product Information

M.R. (Site Services) Ltd provide permanent Leak free solutions on sheeting details and modifications throughout Europe, Iceland, The Middle East, Far East, Africa, Asia, Canada & South Atlantic

### **Benefits**

One-fix TIG welded solution  
Guaranteed watertight.  
Insurance-backed guarantees

### **Certification/Qualification**

All welders are CSCS card holders and fully trained to:  
EN 287-2/BS EN ISO 9606-2: 2004  
Welding Procedure Qualification 012  
complies with EN 288-4

### **Durability**

Totally watertight  
Strong and lightweight.  
Corrosion-free.

### **Welding consumables**

Tungsten Ceriated Tungsten 1.6, 2.4 or 3.2 mm dia Filler Wire Grade 5556A Aluminium filler wire to BS EN ISO 18273:2004 2.4 or 3.2 mm dia. Shielding Gas; Argon; 99.99% Pure Argon. Ceramic Nozzles; Type and size to suit welding operation and condition.

### **General welding parameters**

Three-phase AC straight polarity supplied from shop welding sets or from diesel powered generators on-site (carried in MR mobile workshops) As a general guide the amperages for the various material thicknesses are as follows:

0.7-0.9 mm aluminium alloy 30 -40 amps  
1.0 mm aluminium alloy 35 -50 amps  
1.2 mm aluminium alloy 45 -60 amps  
1.6 mm aluminium alloy 55 -75 amps  
2.0 mm aluminium alloy 65 -85 amps  
3.0 mm aluminium alloy 115 -145 amps



Contact a member of our team for more comprehensive information on this product