



MR (Site Services) Limited

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Preparation prior to Welding of thin
gauge standing seam roofing



ABOUT M.R.SITE SERVICES

The welding of thin gauge aluminium roof materials was pioneered by Melvyn Rowberry in the early 1980s - and this early work has resulted in one of the major success stories of modern British Construction

SHARING OUR KNOWLEDGE

When welding was first introduced back in the early 1980's there was one standing seam system and 3 installers of that system. Early contracts were mostly government or military projects with reasonably straight forward flat roofs with most of the difficult details coming along in the last few years.

Enlightening contractors to the needs of this specialist process was in hind sight relatively easy. We trained the industry using road shows and presentations on the very difficult subject of preparing the aluminium for welding .

PREPARING FOR WELDING

The weld zone or area (300mm min) must be clean, no rubbish, nor sand or concrete etc, All cutting by saw not grinder, all burrs removed. The 300mm weld zone must be fully supported by non flammable rigid, dense insulation e.g. Duorock is normally used.

All flammable material must be removed or covered prior to the welding works commencing. The weld will follow the prepared line so if you want a straight weld, produce a straight cut.

Work area Preparation - All sheet cutting must be completed using saws, not grinders. All weld zones are required to be fully supported by Duorock, and any flammable materials covered or removed.

Stucco embossed sheets

The preparation of the weld zone is crucial for a safe and successful watertight roofing detail, the weld torch is not a magic wand, maximum gap no more than 5mm

Painted surfaces Prior to installation all painted/coated surfaces must be removed locally (25mm either side of weld line and from the bottom sheet under the weld) by wire wheel/brush. Any abrasive discs or the like will reduce the thickness of the sheet and deposit inclusions into the sheet.



Paint removed from sheets prior to welding

The above is just a very brief introduction to this process, For full information please contact the team On 01905 755055 or welding@mrsiteservices.co.uk