

Welded joint instructions for Altro Whiterock™ wall designs

Full installation details are available in the Altro Whiterock installation guide at www.altro.com

The technique used to weld Altro Whiterock wall designs is different to the one used to weld standard Altro Whiterock. Installers must read these instructions fully before commencing to weld Altro Whiterock wall designs sheets and it is strongly advised to carry out a test weld before welding the final installation.

Specialist Tool

A Leister 5 mm round speed weld nozzle with small air slide (105.433) **MUST** be used for welding all Altro Whiterock wall designs installations.



Preparation

Ensure all sheet edges (where joints are to be formed) are clean, smooth, true and level.

Always inspect new sheets and ensure the edges are undamaged. Damaged edges will need re-trimming.

Do not bevel, profile or chamfer the edges of the wall designs sheets at seam locations. Chamfering the edges will expose the base colour of the sheet. When hot welding this could leave the exposed sheet being visible on the finished detail and make a welded joint more challenging to achieve an aesthetically pleasing seam.

Check there is no debris left on the edges of the sheet. Any debris could burn when hot welding the joint and will leave a blemish which cannot be removed.

When fitting the sheets, leave a maximum 2 mm and a minimum 1.5 mm gap between sheets to ensure an even joint detail once hot welded, and leave a 2mm gap at all rigid abutments (ceiling, windows, doors, services etc.) to allow for expansion.

Clean both the seam area and the weldrod prior to welding.

Heat Welding

Ensure the welding equipment is clean especially the nozzle which may contain debris and carbon build up. The use of a wire brush and pipe cleaners will maintain the nozzle.

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The speed required to weld Altro Whiterock wall designs may be different compared to a standard Altro Whiterock sheet due to the foil used which gives the design. As a result it is essential that the correct welding speed is achieved on practice sections using off-cuts of the sheet prior to attempting an initial live weld. This will allow the installer to gauge the correct speed and heat of the welding gun to ensure acceptable weldrod adhesion and help eliminate any potential burning of the sheet. Each site will require new settings for the weld gun which depend on site electrical supply. Check for proper fusion of the weld by trying to roll the bead left to right with your finger after it has been welded. Pulling on the end of the weldrod will be a good indicator that you have successfully fused to the sheets. The temperature of the weld gun can be regulated, and the settings depend on the speed at which the gun is pulled along the sheet. This is something each individual must practice to ascertain what speed best suits their method of working.

Care must be taken not to scorch the sheets, as this will be extremely difficult to repair.

Trimming off excess weldrod

When trimming the weldrod two passes are key to the process to ensure a flat weld. Choice of tools to trim the weld are installer lead, but care must be taken all chosen tools are free from rust and are smooth. Failure to follow these guidelines could result in surface defects alongside the joint. The first pass should be done while the weldrod is warm. Spray a soapy water solution or Altro anti-static solution to the sheet along the weld to help lubricate the trimming knife, blade and sledge, if using the Mozart trimming tool leave a final cut thickness of 0.5 - 0.7 mm. Once the rod has cooled down, final trimming can commence with a trimming knife and soapy water.

Take extra care not to scratch or damage the Altro Whiterock wall designs surface while undertaking this final part of the procedure.

When heat welding, a small mock up must be done and inspected for the client's approval before proceeding with the entire installation.

Weldrod	Colour	Code
	Soft Woodgrain	WSR9901
	Rich Woodgrain	WSR9902
	Warm Woodgrain	WSR9904
	White Mineral	WSR9905
	Cool Mineral	WSR9906
	Urban Mineral	WSR9907
	Winter Weave	WSR9909
	Autumn Weave	WSR9010
	Cool Woodgrain	WSR9914
	White Woodgrain	WSR9915
	Warm Concrete	WSR9916
	Warm Elegance	WSR9917
	Soft Elegance	WSR9918
	White Elegance	WSR9919

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