



# Welding Tips

## For Altro Suprema™

Altro Suprema is manufactured using a different composition to that of standard Altro flooring. Due to its makeup, the welding is slightly different to that of standard Altro flooring.

We normally recommend welding at 2 to 3 metres per minute with standard Altro flooring, with the gun temperature set at 300-360°C. **See Image 1 for necessary tools.**

## Guide to Welding

When welding Altro Suprema, we recommend the points below be followed:

- **Cutting in joint;** do not butt or gap the joints. All joints must be cut in before grooving – **Image 2**
- **Grooving;** it is important to ensure that all joints are grooved correctly to a depth of at least 75-90% of the thickness of the product to fully expose the PVC edges of the sheet – **Image 3**
- **Internal mitres;** all internal mitres should be grooved as above.
- **External mitres;** for external mitres care should be taken not to open the vertical joint too wide.
- **Test sample;** as individual welding guns can vary in their heat output and external factors on site can vary, it is recommended that, test welds are carried out on samples of flooring to determine the correct settings and speed – **Image 4**
- **Speed / temperature;** If the test piece shows scorching, turn down the heat and progress more slowly. Alternatively use an anti-glaze nozzle.
- **Trimming;** unlike standard Altro safety flooring, the weld should be trimmed off whilst it is still slightly warm. We would also recommend that a sledge is used, holding the spatula at a low angle, to trim off approximately 1mm of the rod, before finally trimming and finishing the remaining rod flush to the floor surface with the spatula – **Images 5, 6 and 7**
- **Do not use solvents;** solvents should not be used to repair any defective welds as these could attack and damage the surface of the floor covering.

**For further information or technical advice**

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Image 1



Image 2



Image 3



Image 4

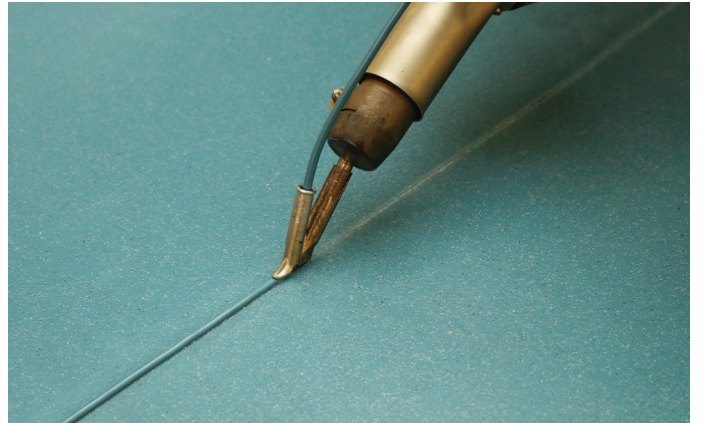


Image 5

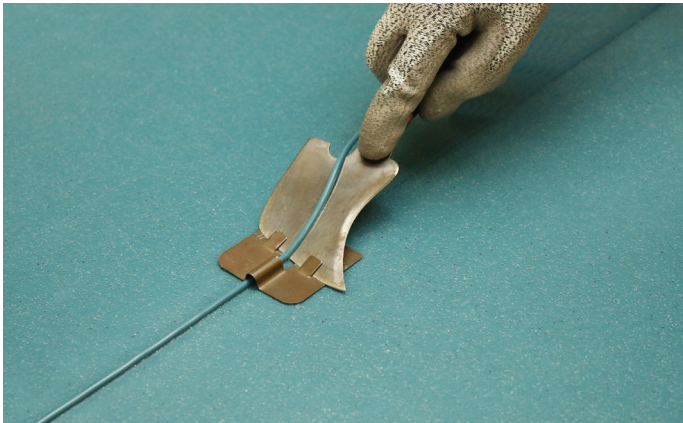


Image 6



Image 7

