

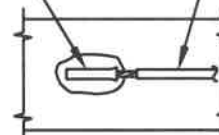
DUCTILE IRON OR  
STEEL PIPE OR  
FITTING



CLEAN SURFACE TO  
BRIGHT METAL AT WELD  
LOCATION BY  
MECHANICAL GRINDER.

### STEP 1

ADAPTER SLEEVE (AS RECOMMENDED BY  
THERMITE WELD MOLD MANUFACTURER  
FOR SMALL WIRE DIAMETERS).

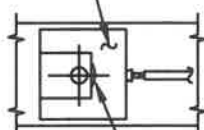


STRANDED COPPER  
WIRE (WITH THWN  
OR HMWPE  
INSULATION).

STRIP INSULATION FROM WIRE AND  
INSTALL COPPER ADAPTER SLEEVE AS  
REQUIRED FOR WIRE SIZE, SEE NOTE 2.

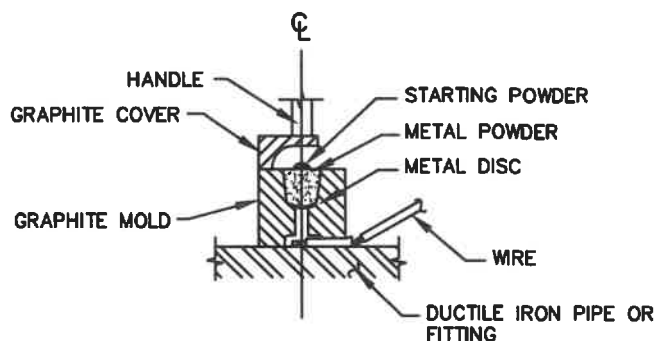
### STEP 2

GRAPHITE MOLD



OPENING

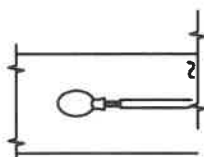
### TOP



### SIDE

HOLD GRAPHITE MOLD FIRMLY OVER ADAPTER SLEEVE WITH OPENING AWAY FROM OPERATOR  
- IGNITE STARTING POWDER.

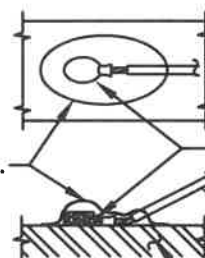
### STEP 3



REMOVE SLAG FROM CONNECTION. THOROUGHLY  
CLEAN WELD AREA.

### STEP 4

COAT ALL EXPOSED  
METAL AT WELD AREA.



### STEP 5

### NOTE:

1. THERMITE WELDS SHALL BE COATED WITH A PREFABRICATED ONE PIECE PLASTIC CAP PER SPECIFICATIONS.
2. A COPPER SLEEVE IS REQUIRED FOR THERMITE WELD WIRE CONNECTIONS USING #10 AWG WIRE OR SMALLER.

WASHINGTON  
SUBURBAN  
SANITARY  
COMMISSION

APPROVED: 7-26-21

*Mike Harmon*

Chief Engineer

STANDARD DETAIL  
THERMITE WELD  
DETAIL

C  
2.1