

The product

A KingsWeld weld metal consists of copper oxide, aluminium and flux in a granular (powder) form.

Each weld metal is packed into a plastic container. Different connections require differing weld metal sizes and so each container is marked with the weld metal size (grams).

These sizes are detailed in the table (right), which also provides our standard packaging information.

DESCRIPTION	INNER PACK QTY.	PACK WEIGHT (kg)	PART NO.
Weld metal 15	20	0.60	#015
Weld metal 25	20	0.80	#025
Weld metal 32	20	0.90	#032
Weld metal 45	20	1.21	#045
Weld metal 65	10	0.88	#065
Weld metal 90	10	1.22	#090
Weld metal 115	10	1.58	#115
Weld metal 150	10	1.86	#150
Weld metal 200	10	2.06	#200
Weld metal 250	10	3.04	#250

Weld metals

The weld metals are packed into plastic inner cartons, each of which contains metal discs, a moisture absorbing sachet and a box label, clearly identifying size, quantity and batch information.

The weld metal container has two compartments. The main weld metal is under the green cap and the starter powder is under the red cap.



KingsWeld moulds

The KingsWeld exothermic mould is manufactured from high quality graphite. This lends itself to easy machining, as well as being able to withstand the high thermal and mechanical shocks produced during the exothermic welding process. Heat obtained in such reactions is in excess of 2000°C.

Our moulds are designed to have an average lifetime of 50 to 60 connections. But, if treated with care, it is possible to obtain a significantly longer life.

Graphite is both brittle and soft, therefore it is important that the operator takes care whilst handling the product.

Worn-out or damaged moulds should not be used.

Each mould has a nameplate, detailing the connection type, part code and the correct weld metal size to be used.



The KingsWeld range of moulds can be seen on pages WELD:8 - 9. If you do not see the connection, configuration or size of conductor that you require, please contact our sales office who will be pleased to assist you.

How to use this catalogue







The KingsWeld catalogue lists the most commonly used exothermic connections. However, if you cannot find the one that you are looking for, please contact our sales office who will be pleased to assist.

Select the mould connection configuration required using charts on pages WELD:8 - 9. Go to the pages highlighted under that connection type and refer to the connection table. Select the conductor sizes to be joined.

By following the line across you will find:

- Mould price key
- Weld metal size
- Handle clamp size
- Accessories
- Part number

Now, all you need to add is a tool kit and you are set to go.

A B						
Conductor size	Price key	Weld metal	Clamp	Mould	Sleeve	Hammer die

Product table icons, above, are explained in detail on page WELD:41 - Legend.

Mould care guide

KingsWeld moulds are manufactured from high quality graphite which, by nature, is soft and needs to be handled with care in order to get the maximum lifetime.

- Always clean the mould after every weld
- Only use KingsWeld cleaning equipment (soft brush) to clean the mould
- Keep the mould dry and away from moisture
- Do not hit or drop the mould
- When not in use, keep the mould in its packaging for protection
- Try not to hit the edges of the mould with the conductors to be connected
- Never use a wire brush to clean the mould
- Always use the correct weld metal size, tools and handle clamps

Mould inspection

- Handle the mould with care.
- Mould must be dry with fixed lid.
- Identification plate must be attached.
- Mould faces must be smooth, so they seal properly.
- Mould steel disc seat must not show signs of wear, chips or gouges (steel disc must seal the hole properly to prevent weld metal entering the weld cavity prior to welding).
- Tap hole must be well defined.
- Weld cavity must not show signs of wear, chips or gouges (conductors must have a 3mm gap between them prior to welding, fit snugly and not be loose in the mould).

Regular checks help keep moulds in good condition.

