

SAFE WORK PROCEDURES
Wedge Welder – Field Welding

Facility: Field	Written By: Kevin Donnelly	Approved By: Kevin Donnelly	Date Created: May 15, 2009	Date of Last Revision: May 15, 2009
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Hazards Present:	Personal Protective Equipment (PPE) or Devices Required:	Additional Training Requirements:
<ul style="list-style-type: none"> • Back Injury-MSI • Electrical Shock • Burns • Pinch Points 	<ul style="list-style-type: none"> • Wire Brush • Safety Hook Blade • Hard Hat • Safety Footwear 	<ul style="list-style-type: none"> • Titan Wedge Welder Training

Safe Work Procedures:

1. After qualifying the Wedge Welder, and the test strips pass the Tensiometer test to ensure proper fusion, field welding can begin.
2. Load one strip under the hot wedge from the left side of the unit.
3. Load one strip over the hot wedge from the left side of the unit.
4. Engage the hot wedge.
5. Engage the drive wheels.
6. The operator of the of the welder shall position themselves 2' – 4' ahead of the unit, constantly wiping dirt, debris and moisture from the sheet.
7. The operator shall frequently check the wedge temperature and drive speed of the unit to ensure the settings haven't changed.
8. The operator shall constantly be checking for obstruction under the sheet that can obstruct the forward travel of the unit.
9. Although the unit is self-propelled, the operator shall constantly check and adjust the unit left or right to ensure the weld remains fully in 4" to 6" overlap of the material to be welded.
10. The operator is to frequently check that the material behind the unit is properly fusing.
11. Just before the end of the sheet, disengage the drive wheels.
12. Disengage the wedge.
13. Power off the drive wheels.
14. Clean the wedge and drive wheels if necessary.
15. The unit can now be indexed over to the next seam and the processed repeated.

Guidance Documents/Standards/Applicable Legislation/Other:	
Guidance Documents: <ul style="list-style-type: none"> • Operators Manual Manitoba Workplace Safety and Health Regulation, M.R. 217/2006: <ul style="list-style-type: none"> • 2.1 Safe Work Procedures • 6.1 Personal Protective Equipment • 8 Musculoskeletal Injuries MSI • 16.4 Machine and Tool Safety 	<p>This Safe Work Procedure will be reviewed any time the task, equipment, or materials change and at a minimum every three years.</p>

Temperature Display and Adjustment.

Speed Display

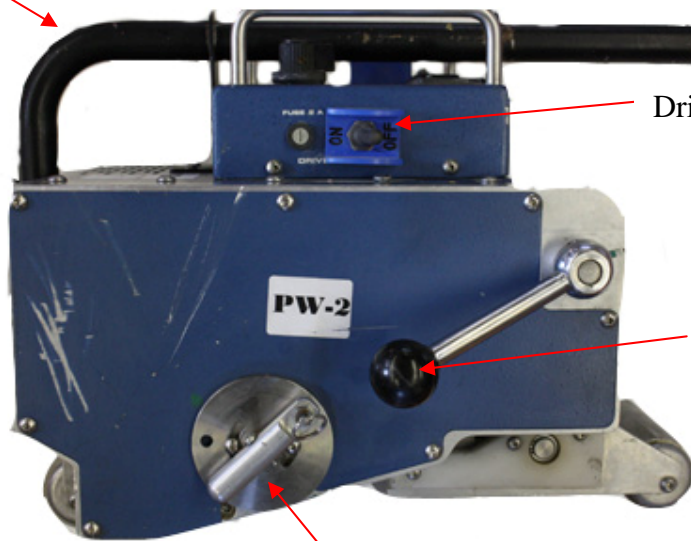
Drive Wheel Power Switch

Main Power Switch



Carrying Handle

Speed Control



Drive Wheel Power Switch

Drive Wheel Engagement

Hot Wedge Engagement

