

## INTRODUCTION

### Tools and personal protective equipment

The following tools will be needed to install our WeatherFAST Fatra coated steel:

#### For Welding

- 110v Hot air welding gun (Leister Triac or similar)
- 20mm welding nozzle
- 20mm 60° nozzle (for detailing)
- Wire brush for cleaning
- 28mm Teflon-coated roller (for main welding)
- Brass 'Penny' roller (for internal angles)
- Seam probe (for testing welds)

#### For Fixing

- Impact drive • Phillips head (PH2)

#### For Detailing

- Scissors (not knives) for trimming membrane
- Metal snips
- Tape measure
- Fatra internal/external corners

#### For Finishing

- Soft broom or squeegee
- Lint-free cleaning cloths
- FF860 membrane cleaner

The following PPE is suggested to be the minimum required:

- Foot Protection
- Hand Protection
- Head Protection
- Eye Protection
- High visibility waistcoat

**\*\*Other PPE may be required as indicated by a Risk Assessment.**





## Welding

### Basic Requirements

**OVER LAP** – The membranes must overlap by 75 mm minimum.

**WELD WIDTH** – A minimum of 30mm.

**WELDING TEMPERATURES** – Welding of Fatra PVC is carried out at a nozzle temperature of 450 to 550°C.



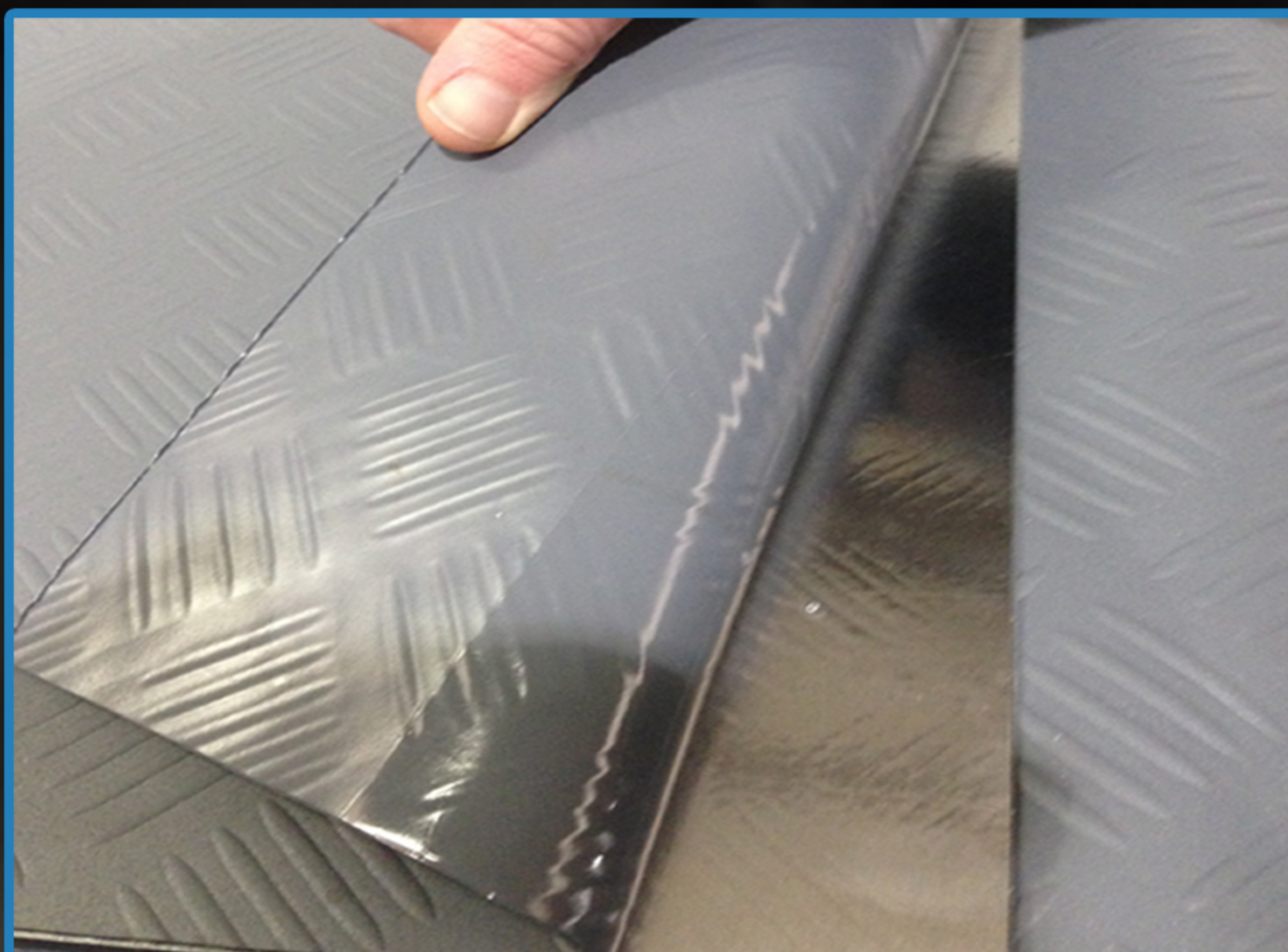
### Pre-weld

Pre-weld to the rear of the overlap using the heat gun and immediately closing the seam with the silicon roller, crossing over the lap in a diagonal motion. This closes the lap to produce the air seal. Use a heat gun and a 20mm flat nozzle. Seam areas must be clean and dry.



### Probing

After the welded seams have cooled they must be visually checked for a thin dark line of extrusion from under the membrane and mechanically tested by running a steel hand probe along the joint by applying pressure to the seam at all times. If any weak welds are found, then peel the membrane back to fully open and re-weld with the heat gun.

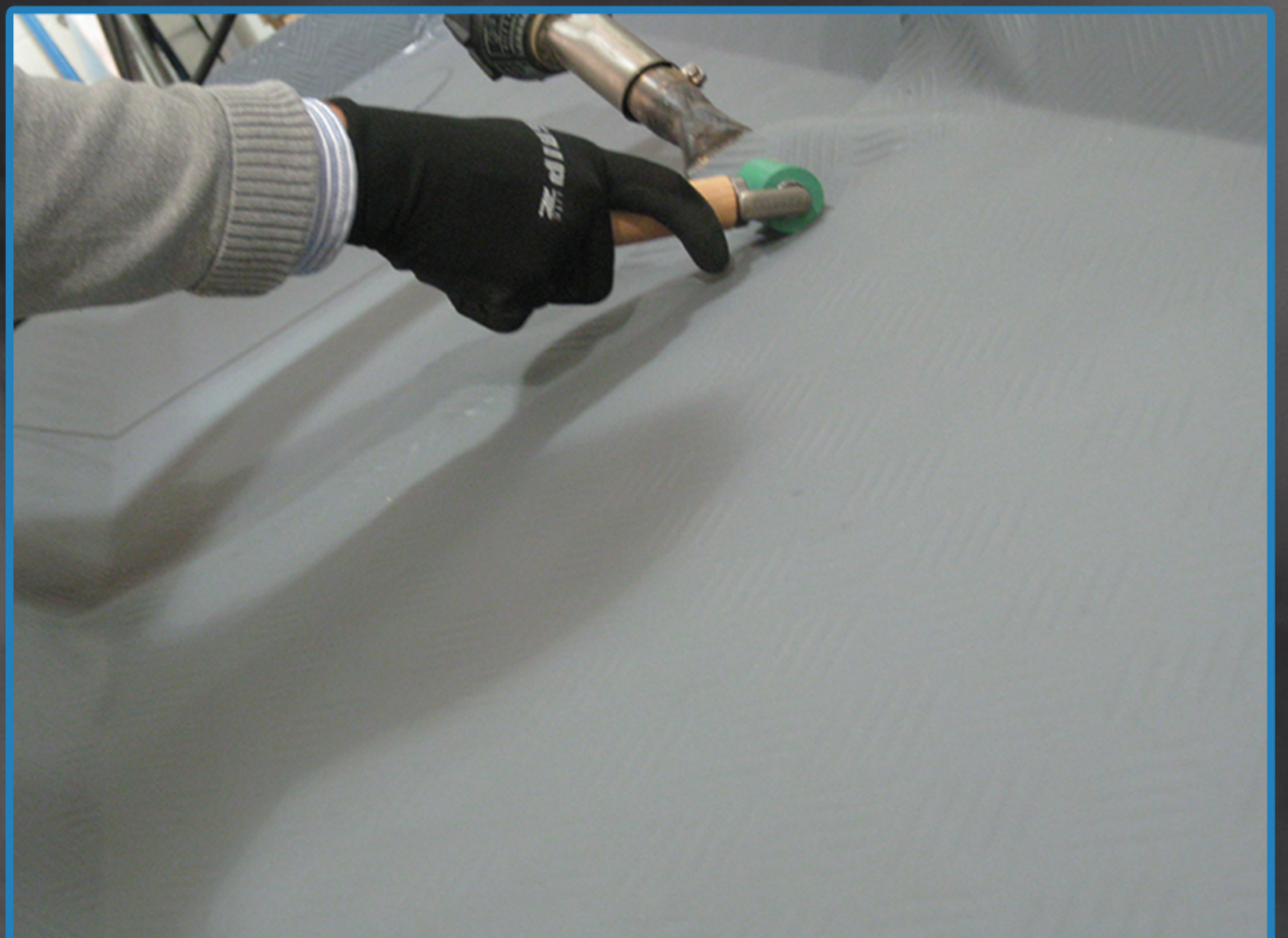


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### Tacking

On occasions there may be a need to lightly tack the membrane. This is to the rear of the 75 mm overlap within the line of the pre-weld at. A tack is not a weld, it can be removed.



### Final weld

After the pre-weld place the tool under the overlap leaving 5mm projecting out from the edge. Continually roll back and forth diagonally across the edge of the lap and down the full length of the seam producing the final homogeneous weld and the weatherproof seal.



### Tear tests

Before carrying out any welding on the roof check that the tool is at the correct temperature by welding several membrane strips together. When cooled, cut 25mm wide strips to carry out a tear test. Take the sample strips and tear them apart across the weld width. If the membrane has achieved a full homogeneous seal it will rupture outside the weld.