

LPG Mixers

Applicability

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|-------------------|--|----------------------|--|-----------------|---|----------|--|
| ARTC Network Wide | | Western Jurisdiction | | New South Wales | ✓ | Victoria | |
|-------------------|--|----------------------|--|-----------------|---|----------|--|

| Audience | Main Points | Change History |
|---|--|--------------------------------------|
| Corridor/Delivery Manager Team Managers Work Group Leaders Project/Delivery Engineers Engineering Compliance Managers Rail Welders | Only use approved mixers Some non-approved equipment will give poor welding results | Previously RailCorp CTN 06/17 Jun 06 |

Only Oxy and LPG Gas equipment may be used in ARTC.

There have been reported occurrences where incorrect mixers have been used, resulting in incorrect preheating of rails.

It is essential for preheating of welds that the correct preheating equipment is used.

The approved mixer for use in the Thermit process is Cigweld mixer type 570, Part number 304003.

Some welders have been using a mixer from WELDMASTER. It is almost identical in outward appearance to the approved mixer (see Figure 1) but the hole diameter on each end of the spindle is far greater (see Figure 2).



Figure 1 – CIG and Weldmaster mixers

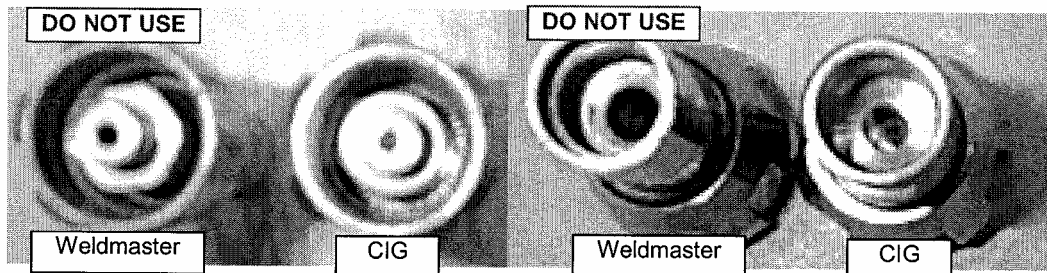


Figure 2 – CIG and Weldmaster mixers

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| Issued by | Date |
| John Cowie, Manager Standards | 08 May 2007 |