

# SINGLE SHOT WELDING INSTRUCTIONS

## GENERAL SAFETY INSTRUCTIONS

1. Weld only items mold is designed for.
2. Do not use worn or broken molds which could cause leakage of molten weld metal.
3. Do not alter molds or accessories without factory authorization.
4. Avoid breathing concentrations of smoke, as it may be hazardous to your health.
5. Avoid contact with hot materials.
6. Remove or protect fire hazards in the welding area.
7. Avoid moisture and contaminants in the mold and materials being welded. Contact of molten weld metal with moisture or contaminants may cause porous welds or weld metal to spew out of mold.
8. Failure to abide by the above may result in improper welds, damage to the material being welded or be hazardous to the individual.

## WELD PROCEDURES

1. Cable must be bright, clean and dry.
2. Ends that are threaded, mushroomed from driving, or drilled and tapped, must be cut off. Contact factory about ground rod driving sleeves.
3. End of ground rods must be clean. Use a coarse file to remove rust and oxide.
4. When removing mold from box, remove lid, disk and weld metal cartridge and save. (see figure 1)
5. Roll mold on ground rod. Do not twist. (see figure 2)
6. Place cable into mold so that the end of the cable is at the center of the mold. (step 1)
7. Press mold down on ground rod till the cable is against the ground rod. (step 2)
8. Support wire to prevent pullout during welding.
9. Place disk in mold being sure concave side is up. (step 3)
10. Pour weld metal from cartridge into mold crucible. (step 4)
11. Place lid on mold and then pour starting powder thru hole in the top of the lid. (step 5)
12. Ignite starting powder with flint gun.
13. After 30 seconds, mold may be removed by breaking or left on.

## NOTES:

- Refer to the above instructions and the (Material Safety Data Sheet) for full information and instructions on use.

## WARNING NOTES:

- Avoid breathing smoke, dust or fumes. May cause irritation or damage to respiratory system.
- Avoid contact with hot molten metals. Contact will cause burns.
- Avoid contact of hot molten metal with water, oil, grease, etc. (Contact could cause excessive spatter and burns)
- Do not use in areas where dust or flammable vapors are present. A fire or explosion could result.

## CAUTION NOTES:

- Avoid risk of fire. Store in dry, well ventilated controlled access area.
- Avoid looking directly at the flash of the reaction. May irritate eyes.

**REMEMBER**  
to use starting material  
in bottom of tube.

STARTING  
MATERIAL



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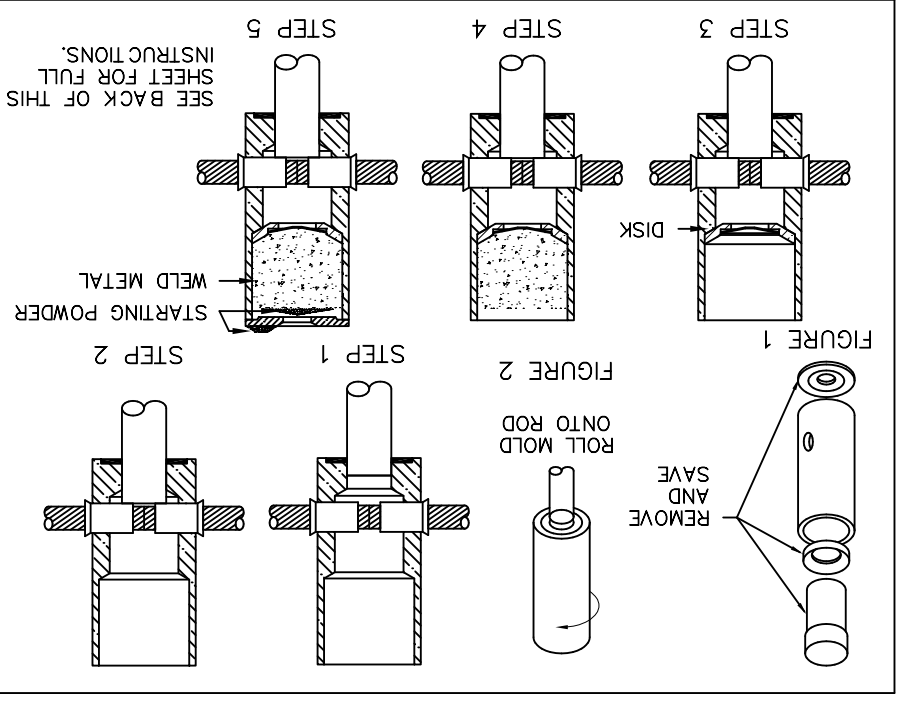
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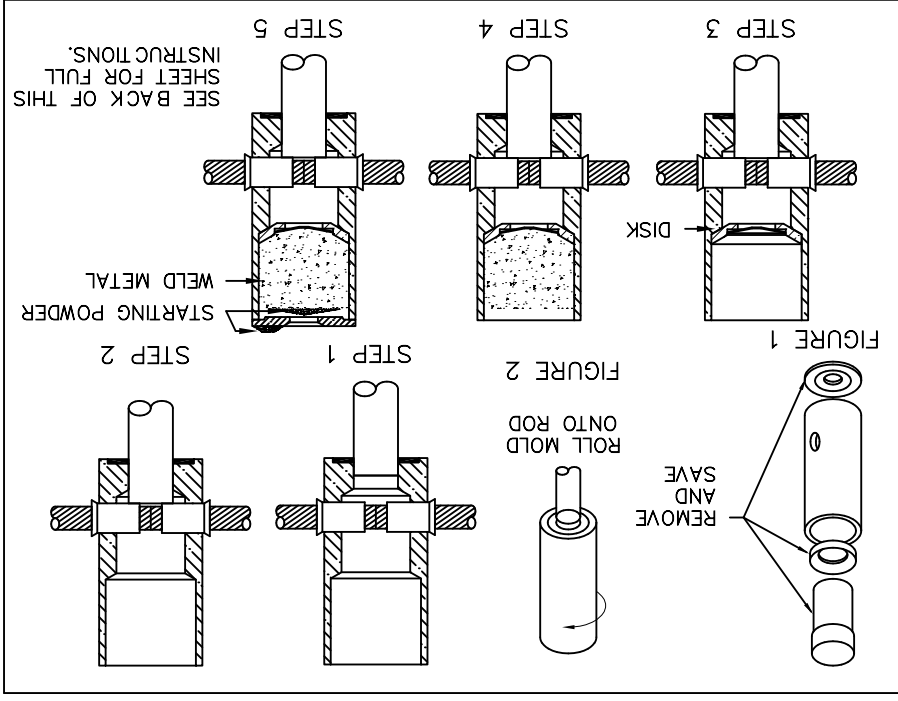
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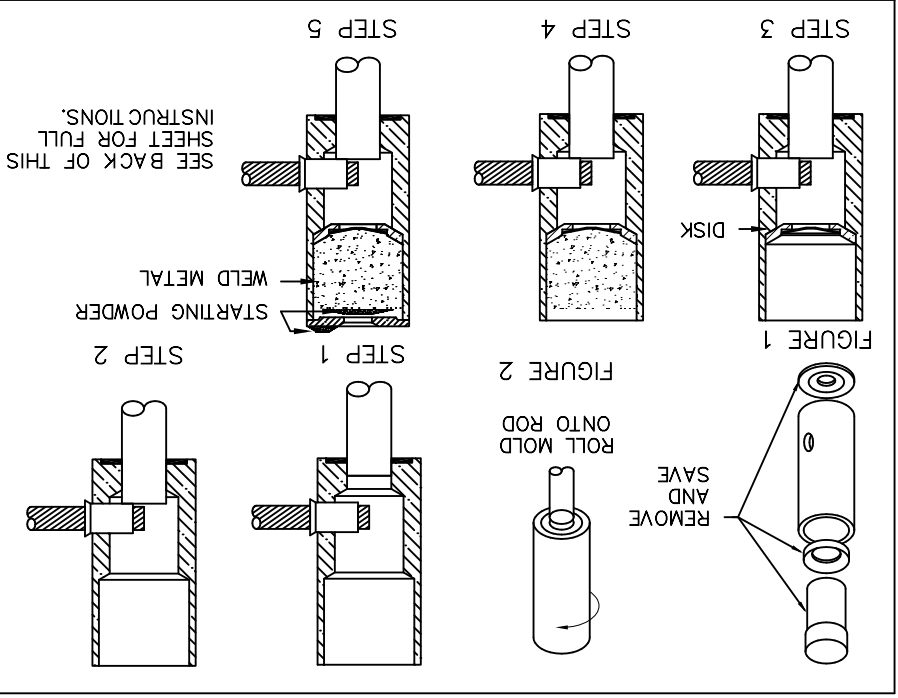




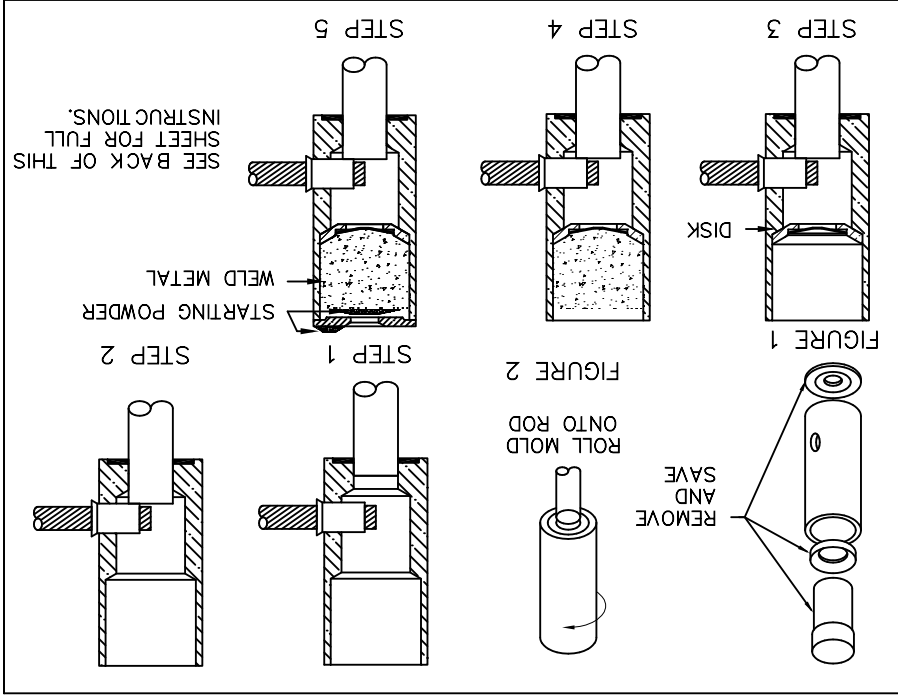
CR-2, CR-24 & CR-25 WELD TYPES



CR-2, CR-24 & CR-25 WELD TYPES



CR-1 WELD TYPE



CR-1 WELD TYPE