



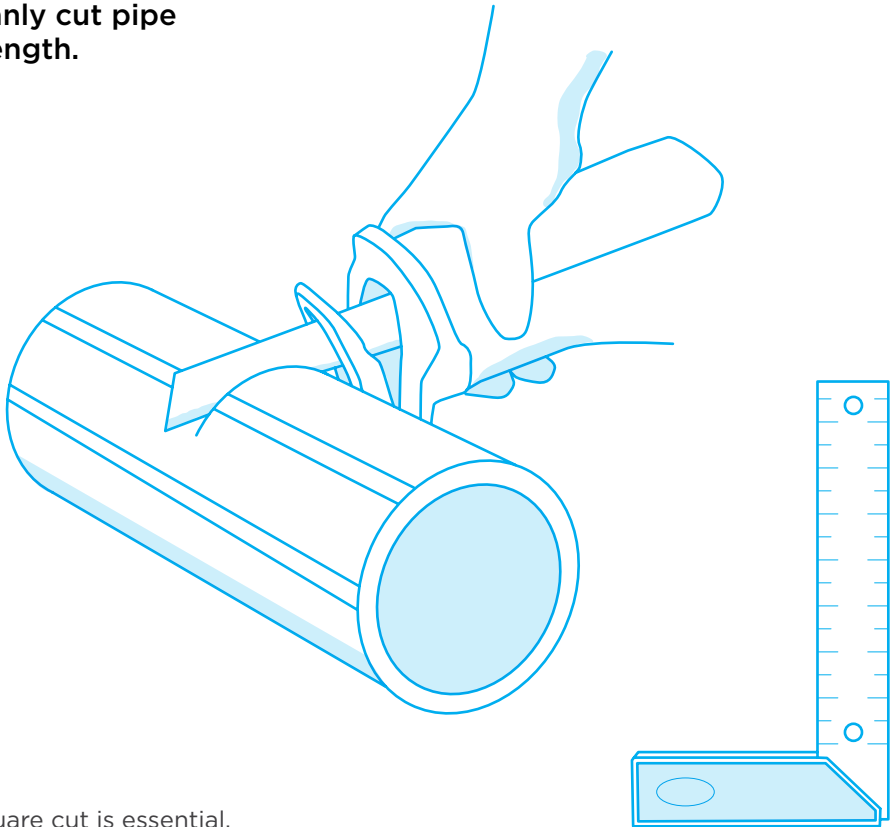
# GOOD WELD GUIDE

FOR FAST & SAFE INSTALL



# 01

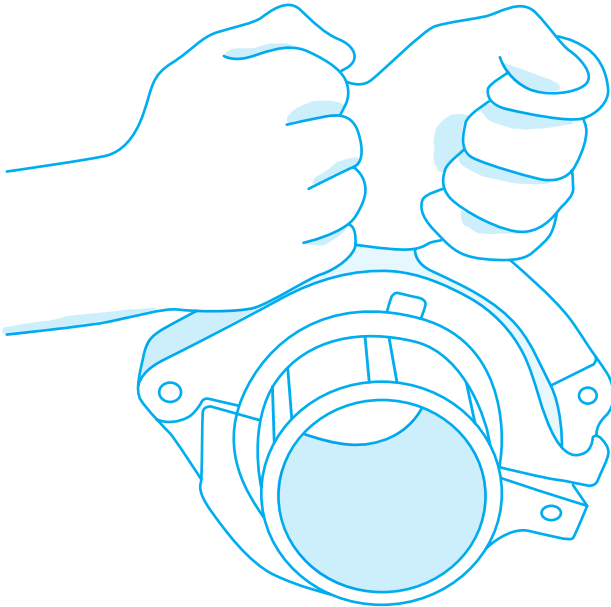
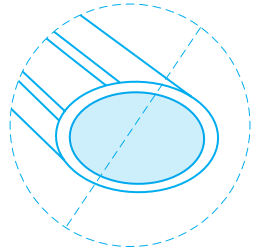
Cleanly cut pipe  
to length.



A square cut is essential.

# 02

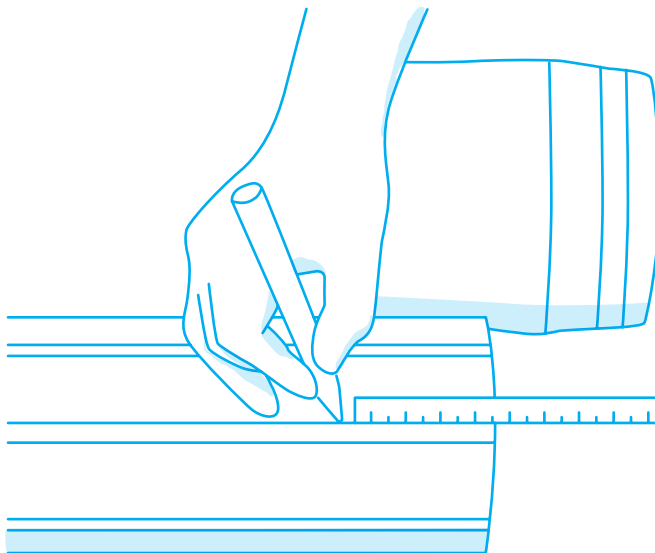
**Inspect pipe cross-section  
for imperfections and ovality.**



A rounding clamp can help fix this.

# 03

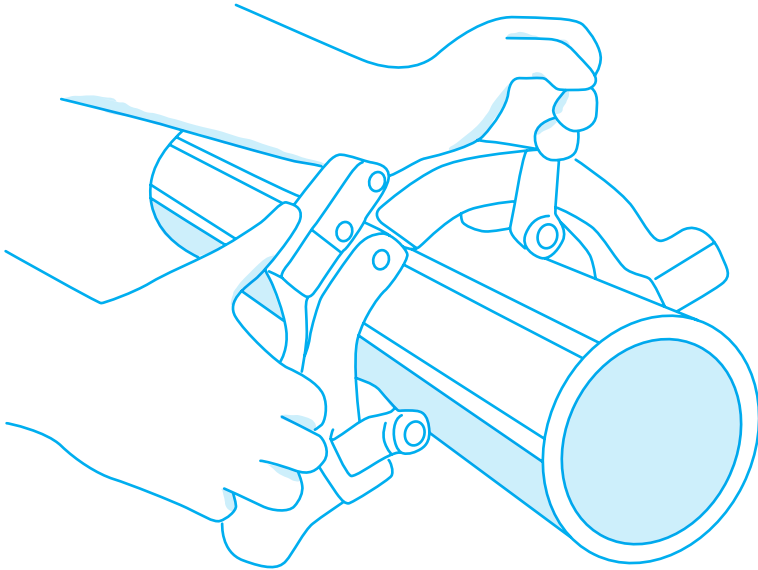
**Measure and mark the insertion depth.**



Use the fitting to find the required depth.

# 04

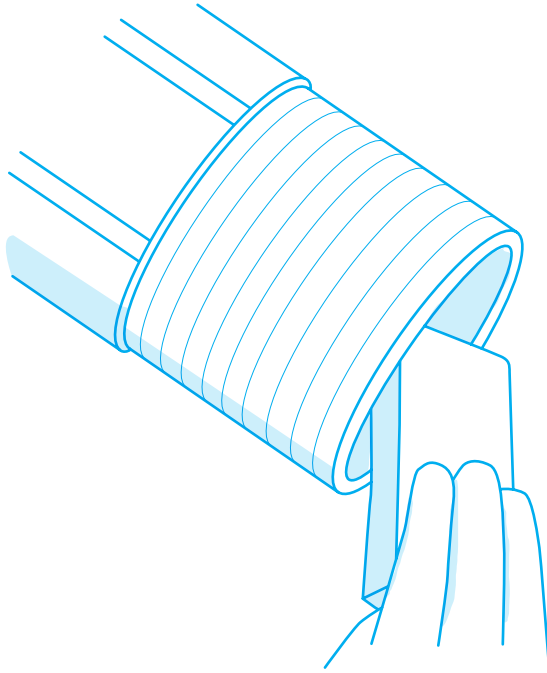
**Remove the top oxide layer up to the marking.**



A rotational scraper will give the best results.

# 05

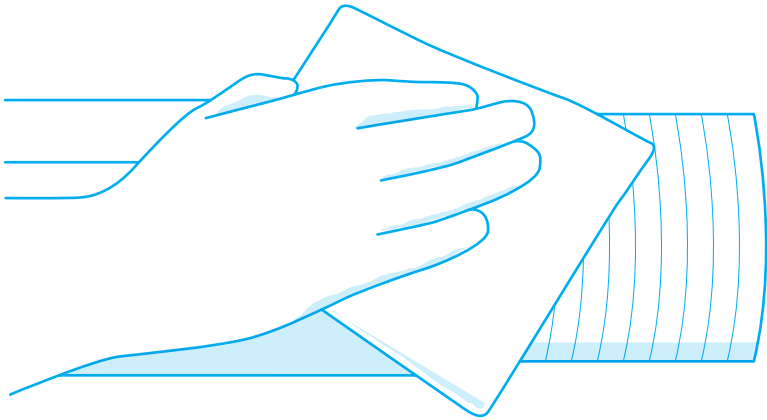
**Slightly chamfer the pipe's inside and outside then clean with a wipe.**



Removes any burrs and chips.

# 06

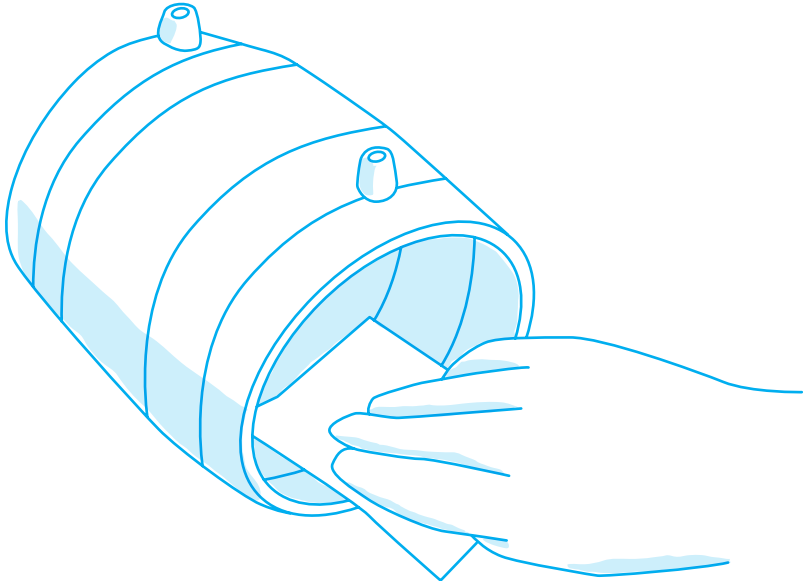
Clean the weld zone with an isopropyl wipe.



Removes debris and any particulates.

# 07

**Remove fitting from packaging and clean with an isopropyl wipe.**

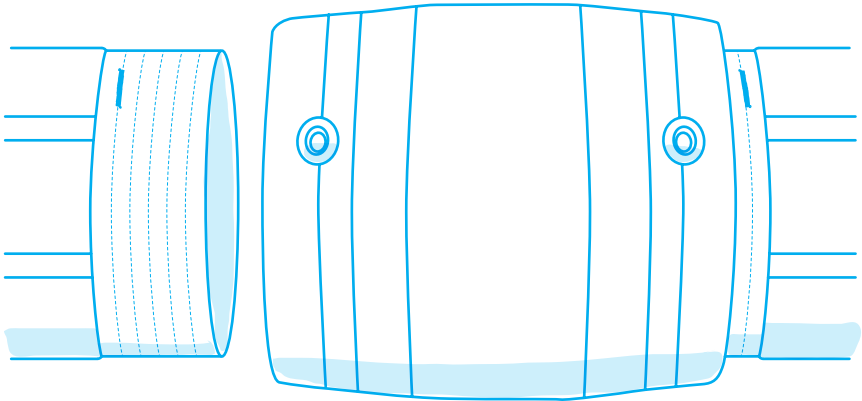


Fittings must be kept sealed until ready to install.



# 08

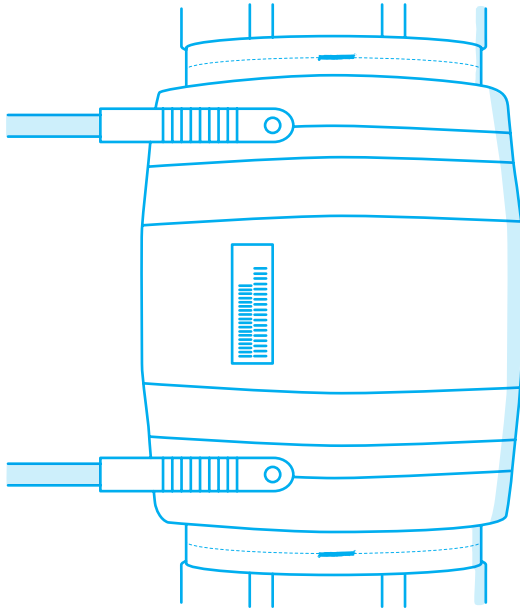
**Mark insertion depth again  
and insert pipe into fitting.**



If you feel resistance, ensure fitting is clear of debris.

# 09

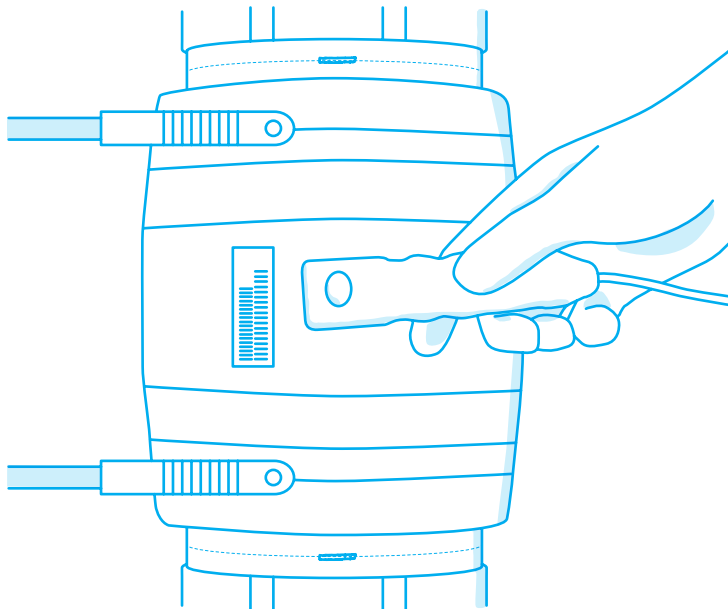
**Connect welder leads to fitting,  
use adapters if necessary.**



If using a generator, start it BEFORE connecting to welder.

# 10

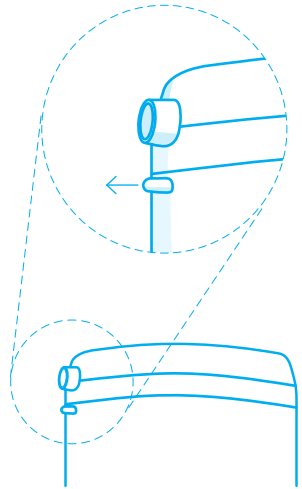
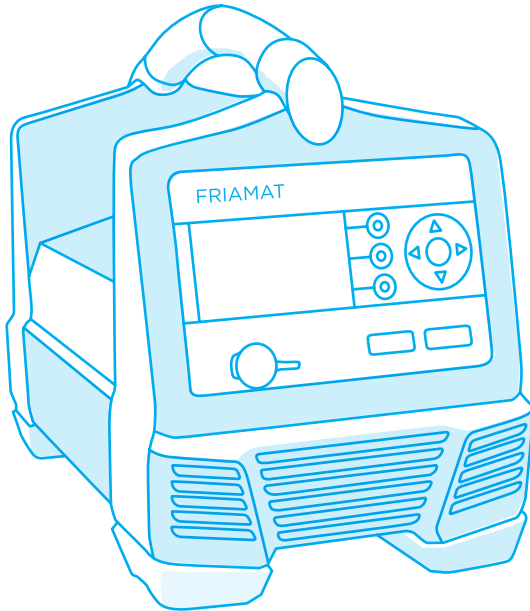
Use provided reader to scan the fitting's barcode.



This can be entered manually if needed. See FAQs.

# 11

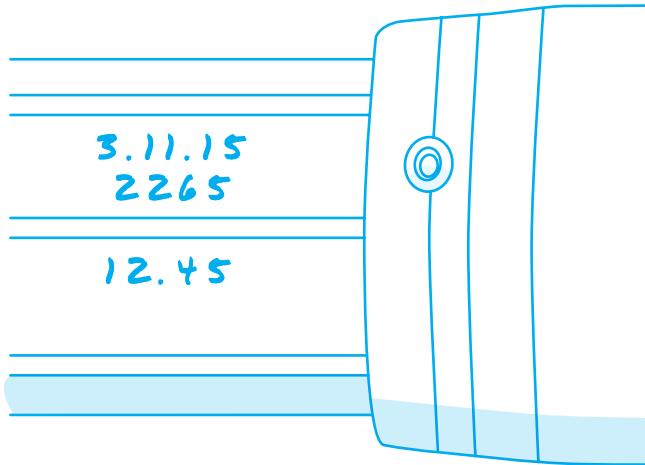
The welder will count down remaining weld time.



Indicator barbs will pop up on the fitting.

# 12

The cooldown timer appears after welding.  
Wait for this to finish before removing the welder leads.



Cooling is essential before testing the weld.

# FAQs

## Minimum power requirements

- When using a generator, it must have a minimum output of 6.25kVA.
- A 10 amp GPO is recommended for optimal performance and results.

## Maximum extension length

- Extension leads must have a conductor cross section of 2.5mm<sup>2</sup> up to 50m in length or 4mm<sup>2</sup> up to 100m in length.

## Barcode is not scanning

- Try shading barcode with your hand or scanning an identical fitting.
- Use Barcode Structure for manual entry.

## The welder is showing a calibration warning

- Servicing is required every 12 months, contact your local Reece Civil branch to book in for servicing. It is important to not delay as to ensuresafe operation and handling, as well as maintaining optimal welding performance.
- You will be given a limited number of additional uses once the calibration warning appears.

# FAQs

## Barcode Structure

Barcode according to ISO 13950 in 2/5 interleaved ANSI.



— Manufacturer's mark

— Electrical resistance in Ohm  
15 - 17

— Dimension  
9 - 11

— Fusion time in seconds  
19 - 21

— Fusion voltage in volt  
13 + 14

— Temperature compensation  
+ / -  
22 + 23

# FAQs

## Common error codes

No.	Text in Display	Remedy
02	Temperature outside range	Ambient Temperature is too high, set up a tent if necessary
03	Resistance outside tolerance	Issue with fitting, please check contacts, replace if necessary
05	Fitting winding open circuit	Issue with fitting, please check contacts, replace if necessary
08	Mains voltage outside range	Power outside permitted range, ensure generator and extension cables are within recommended range
13	Mains failure	Supply voltage may be too low, ensure good connection at contacts
23	Generator failure	Generator may not be suitable, ensure it meets minimum requirements.
30	Exhaust failure	Clear out exhaust fan of welder unit using an air compressor.