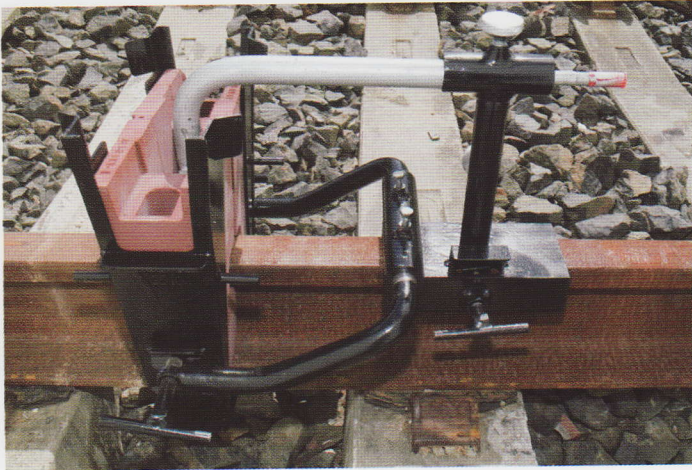


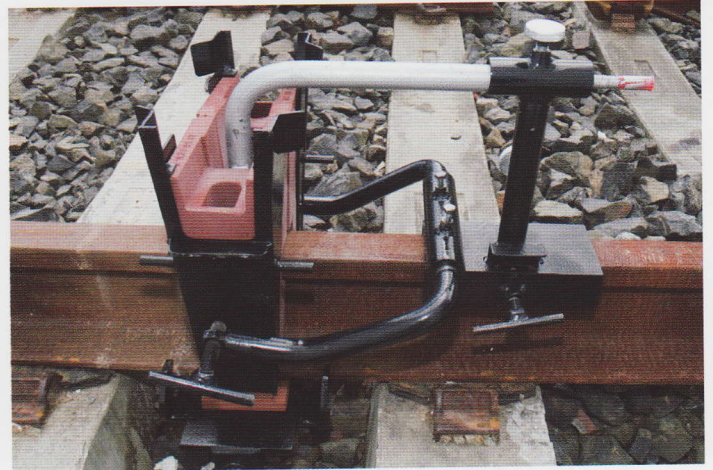


# SKV-Elite SU

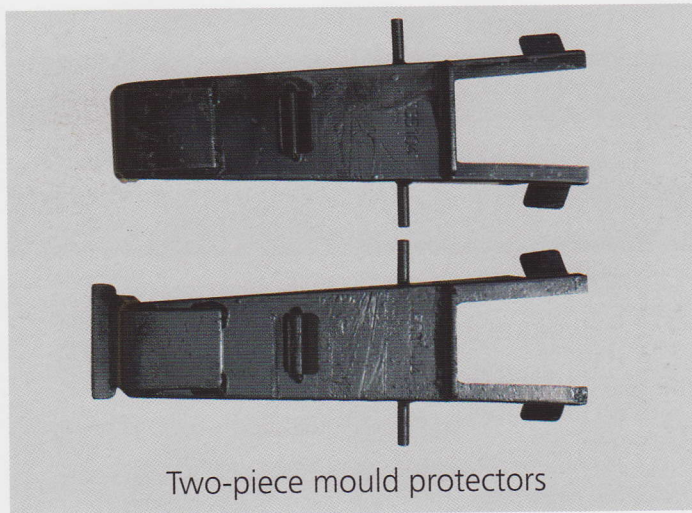
Single use crucible system



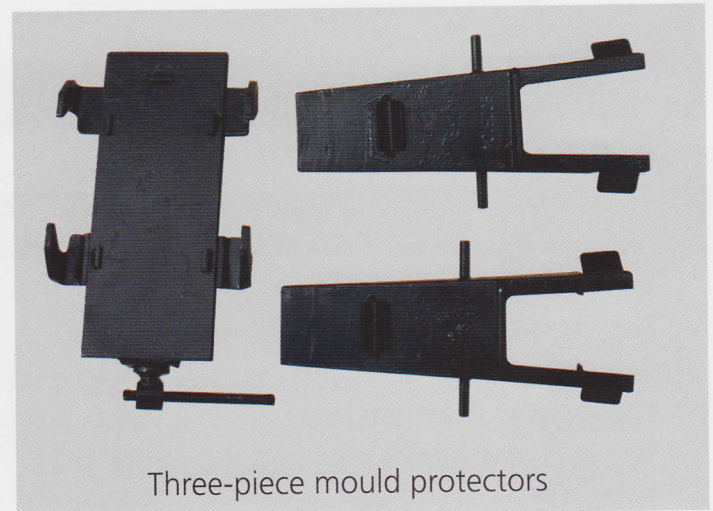
Two-piece mould system



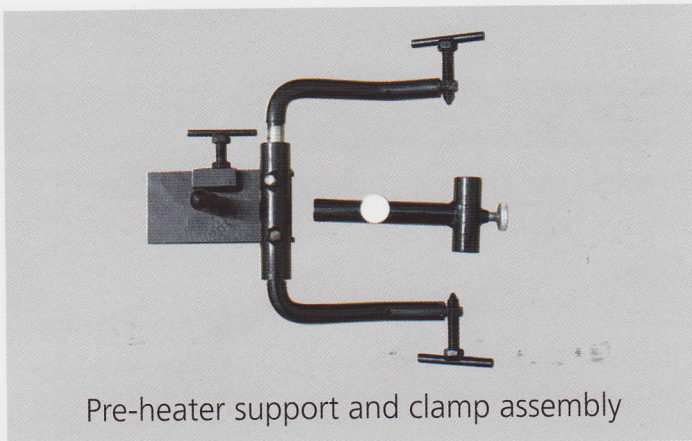
Three-piece mould system



Two-piece mould protectors



Three-piece mould protectors



Pre-heater support and clamp assembly

- Increased weld reliability by optimised heat distribution
- Fast installation
- High track availability
- Paste or sand luting
- Best properties in fatigue strength and weld cleanliness
- Available in 2 or three piece moulds
- EN147-1 certified

**THERMIT AUSTRALIA PTY LTD** A member of the Goldschmidt Thermit Group

Phone 61 2 4340 4988 Fax 61 2 4340 4004 Email [info@thermit.com.au](mailto:info@thermit.com.au) Web [www.thermit.com.au](http://www.thermit.com.au)



# SKV-Elite SU

Single use crucible system

Guide to operating parameters

## Set up

Weld Gap } 28-30mm

## Pre-heating

Preheating torch type } EO3610  
Preheating torch tip height } 40mm fixed torch tip height  
Oxygen } 400kPa set working pressure  
LPG } 150kPa set working pressure  
Rail profiles } pre-heating times  
41-53kg rail } 3.0 minutes  
60kg rail profile } 3.5 minutes  
68kg rail profile } 4.0 minutes

## Thermit welding portion details

Portion grade } SKV-E-SU Z90,Z100,Z90HC,Z110 or HPW

## De-moulding, weld shearing and grinding operations

Remove SU crucible & slag trays } 3.0 minutes  
Remove rail clamp & mould protectors } 5.0 minutes  
Remove moulds, clean away sand & mould residue } 5.5 minutes  
Locate weld shear unit, lock & shear weld } 6.0 minutes  
Removal of alignment wedges, frames or jacks } 20 minutes  
Restore track condition } 25 minutes  
Commence grinding operations } 45 minutes  
Complete weld visual inspection.

## Environment and worksite clean up

All welding waste materials should be placed in the used single use crucible container and disposed of in accordance with environmental regulations as specified by the relevant track authorities.

Welding information on this data sheet should only be used for guidance purposes and only in conjunction with Thermit Australia P/L Products exclusively.

WDS SKV-E-SU 16.01.2007

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Phone 61 2 4340 4988 Fax 61 2 4340 4004 Email [info@thermit.com.au](mailto:info@thermit.com.au) Web [www.thermit.com.au](http://www.thermit.com.au)