



Thermit Australia Pty. Ltd.

WELD DATA SHEET SkV-F

RAIL AS31, AS41, AS47, AS50, AS53 & AS60Kg

RAIL SIZE	GAP SIZE (mm)	TORCH HEIGHT (mm)	Working Pressure kPa		PREHEAT TIME (min)	MOULDS REMOVED (min)	CROWN GAP OVER 0.5 METRES (mm)	COMMENTS
			OXY	PROP				
AS31	24-26	35	500	150	2	5	1.5-2.0	Use preheat burner E03600
AS41	24-26	35	500	150	2	5	1.5-2.0	Use preheat burner E03600
AS47	24-26	35	500	150	2	5	1.5-2.0	Use preheat burner E03600
AS50	24-26	35	500	150	2	5	1.5-2.0	Use preheat burner E03600
AS53	24-26	35	500	150	2	5	1.5-2.0	Use preheat burner E03600
AS60	24-26	35	500	150	2.5	5	1.5-2.0	Use preheat burner E03600

SPECIAL INSTRUCTIONS:

Welding information on this sheet should only be used when using **THERMIT** AUSTRALIA Pty. Ltd. materials and equipment exclusively