



Thermit Australia Pty. Ltd.

WELD DATA SHEET SkV-F SU

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

RAIL SIZE	GAP SIZE (±1mm)	TORCH HEIGHT (mm)	Working Pressure kPa		PREHEAT TIME (min)	MOULDS REMOVED (min)	CROWN GAP OVER 0.5 METRES (mm)	COMMENTS
			OXY	PROP				
AS41	25	35	350	100	3.5	4.5	1.5 - 2.0	Use preheat burner E03600
AS47	25	35	350	100	5	4.5	1.5 - 2.0	Use preheat burner E03600
AS60	25	35	350	100	6.5	4.5	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