



Thermit Australia Pty. Ltd.

WELD DATA SHEET SmW-F

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				
AS31	20	65	210	70	4-4.5	4	1.5-2.0	Use preheat burner E02100
AS41	20	55	250	80	4-4.5	4	1.5-2.0	Use preheat burner E02100
AS47	20	55	250	80	5-5.5	4	1.5-2.0	Use preheat burner E02100
AS50	20	55	250	80	5-5.5	4	1.5-2.0	Use preheat burner E02100
AS53	20	55	250	80	5.5-6	4	1.5-2.0	Use preheat burner E02100
AS60	20	55	250	80	8-9	4	1.5-2.0	Use preheat burner E02100

SPECIAL INSTRUCTIONS:

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