



# Extrusion Welding Checklist

## Before you begin

- Check that there's enough extrusion rod for the job.
- Clear the welder of any old material.
- Doublecheck that the shoe matches the seam you want to make.
- Scrape away the oxidation layer on the PE pipes.
- Clean the surfaces of any mud, dust, oil, water, etc.
- Set the pipes in place - tack weld or clamp.
- Set the right temperature for the extrusion rod you're using.

## As you weld

- Preheat the surface where you'll start welding.
- Check the angle of the welder. (How well is the extrusion flowing? Are the surfaces preheating evenly? Does your seam look straight and regular?)
- Balance your travel speed against the extrusion rate.

## After you're finished

- Let the seam cool down before moving or adding any pressure.
- Clear the extrusion welder out and leave it as clean as you can for next time.