



### Welding Guidelines\*

- Miller Wedge Welder (3M Tape)**

1" Hot Wedge	WeatherMAX 80	WeatherMAX FR
Temperature	400° C; 752° F	400° C; 752° F
Speed	2 M	2 M
Pressure	0.2	0.2

- Miller Hot Air Welder (3M Tape)**

	WeatherMAX 80	WeatherMAX FR
Temperature	600° C	700° C
Speed	10	10
Pressure	N/A	N/A

- Miller Impulse Welder (3M Tape)**

	WeatherMAX 80	WeatherMAX FR
Temperature	High	High
Speed	15 sec Hold, 30 sec Clear	15 sec H, 30 sec C
Pressure	N/A	N/A

- Sinclair Triad Automatic Wedge Welder**

1" Hot Wedge	WeatherMAX 80	WeatherMAX FR
Temperature	430° C	425° C
Speed	40%	30%
Note		With FR Tape

- RF Welding** – WeatherMAX 80 cannot be welded using RF machines. WeatherMAX FR manufactured in 2013 or later can be welded using Sinclair Uniseam Thermalbond FR34200 tape. More testing data to follow on various machines.

Hall Dielectric Bar Sealer	
Preseal Timer	02.01
Seal Timer	05.00
Cool Timer	02.11
Setting	Normal Operation
Temperature	325°

\* All numbers are meant to be a baseline from which to start. Settings may vary based on electrical current available, age of machine, length of time since service, and other variables.