



EQUIPMENT

PROCEDURE

INSTRUCTIONS

REMOVING AND REPLACING WELDED-ON COVERS AND TANKS

REMOVING THE WELD

There are times when it becomes necessary to remove a welded-on cover from a transformer tank or the top section from the bottom section of a form-fit tank. This may be done by either chipping out the joining weld or cutting out the weld with a gas cutting torch. The equipment required and

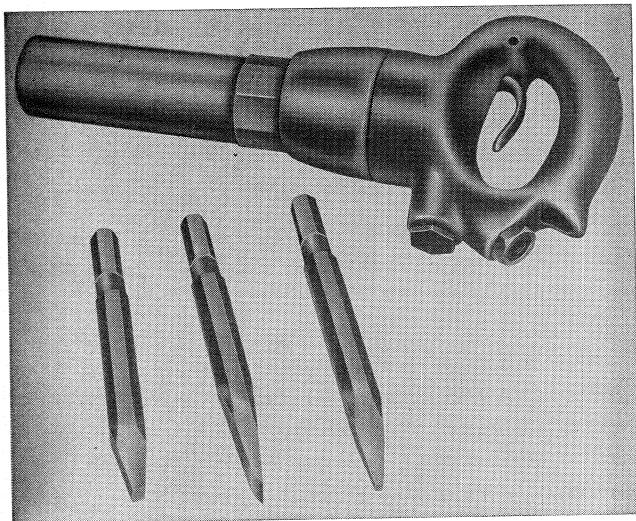


FIG. 1. Recommended Equipment

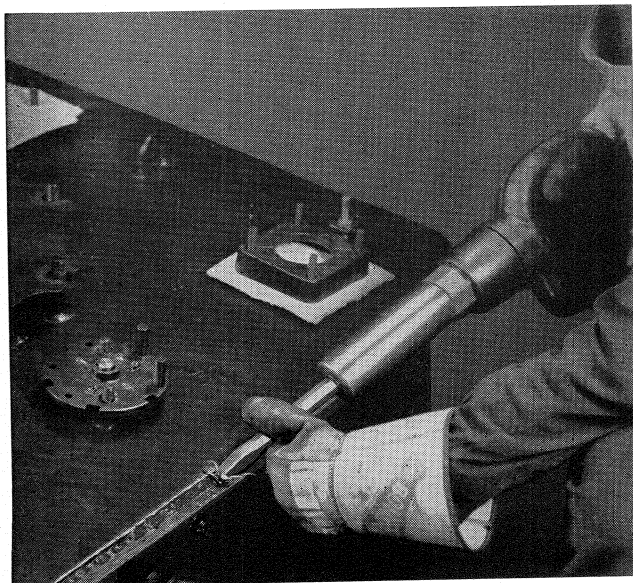


FIG. 2. Removal Procedure

a suggested procedure to remove the weld is described below.

CHIPPING OUT A WELD

Equipment. The equipment recommended to remove a weld by chipping is:

1. A heavy pneumatic chipping hammer.
2. Three-eighths and 1/8 inch diamond-pointed chisels. The chisels should be forged tools, hardened and tempered so that the edges will not turn or spall. The cutting edges of the diamond-pointed chisels should be ground straight with no chamfer.
3. Flat chisels. The flat chisel should have the flat side relieved 1/64", approximately 1/8" back from the cutting edge. This prevents the chisel from "digging-in" and allows the operator better control of its cutting.
4. Gloves and safety glasses should be worn by the operator for his personal protection.

Procedure. It is important to cover any openings into the tank, to avoid entry of chips. To remove a weld by chipping, apply machine oil or grease to the surface of the weld to lubricate the cutting. A 3/8 inch diamond-point chisel is used in the pneumatic hammer and the chisel is held so that the diamond is pointed into the root of the joint. The chisel should cut 1/8" back of the vertical edge of the weld and along the face of the horizontal

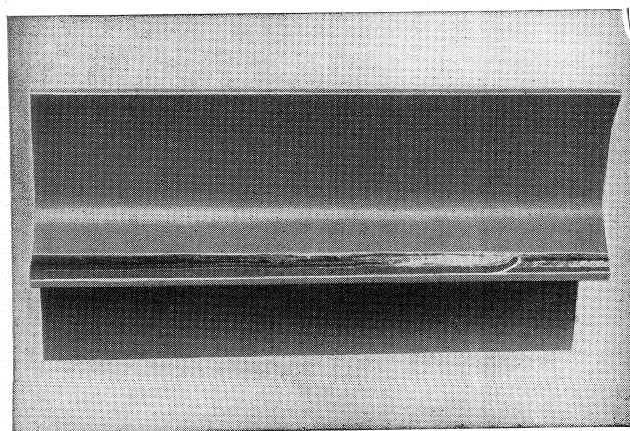


FIG. 3. Weld Partially Removed

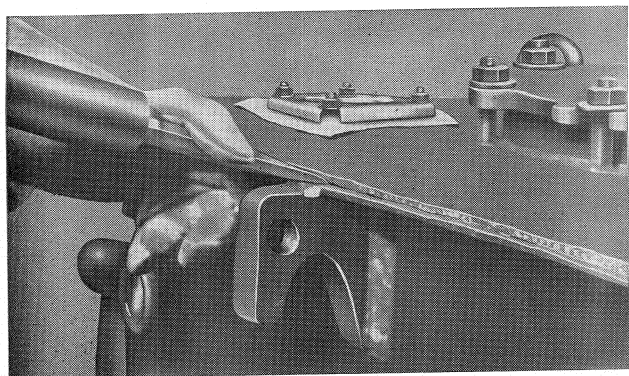


FIG. 4. Carefully Breaking the Seal

flange to remove as much of the weld as possible. Should the weld not be completely removed in one pass with the $\frac{3}{8}$ inch diamond-point chisel, more oil or grease should be spread over the remaining weld and the flat chisel used to cut the weld flush with the horizontal and vertical surfaces of the joint. The small diamond-point chisel should then be used to remove any remaining weld metal from the root of the joint.

The flat chisel is then driven directly into the root of the joint to crack the seal, as shown in Fig. 4. To prevent the chisel from being driven between the joint and deforming the plates, it is moved slowly along the joint. A lifting force upon the cover or the top section will help to break the seal.

WELD REMOVAL BY GAS CUTTING

Equipment. The equipment recommended to remove a weld by gas cutting is:

1. A heavy duty gas cutting torch, preferably of the oxy-acetylene type.
2. Heavy duty flame cutting tips or Airco #6 or #8, Style 183 or Oxweld #19, Style 1511 gouging tips.
3. A number of C-clamps.
4. A heavy machinist's or pneumatic hammer and a flat chisel to break the weld seal.
5. Protective equipment such as gloves and colored goggles for safety protection of the operator, nitrogen to purge the transformer tank and hand operated carbon dioxide fire extinguishers.

Procedure. To remove a weld by gas cutting the following procedure is suggested. Connect a bottle of dry nitrogen to the filling plug opening and flush the gas space with nitrogen. Keep nitrogen flowing into the gas space while the weld is being removed to blanket the core and coils and to prevent combustible gases collecting within the transformer case.

The cutting or gouging tip is assembled to the cutting torch. The gas pressures should be ad-

justed to the recommended pressures for the size tip used. Usually 60 to 80 psi oxygen pressure and 5 to 6 psi acetylene pressure. The torch is lighted and the flame adjusted to give a neutral flame. Heat the weld at one corner of the tank to a white heat, then simultaneously set the torch in motion along the weld and release the cutting oxygen. Move the torch axially along the weld with an oscillating motion, forward slowly an inch or two, then backward quickly about one-half inch, to permit the flame to fan out and wash the molten weld metal from the root of the joint. Continue along the weld in this manner, gauging the depth of the cut so that the entire cross-section of the weld is removed in one pass.

Apply C-clamps to clamp the side or sides from which the weld has been removed to prevent the joint opening prior to complete weld removal.

After the weld has been removed completely around the tank, remove the C-clamps and drive the flat chisel directly into the root of the joint to break any remaining weld seal, as shown in Fig. 4.

REPLACING A WELDED-ON COVER

To replace a welded-on cover that has previously been removed as described above, the following is recommended:

Preparing the Cover for Replacement.

1. Chip or grind any irregularities around the cover edge left during the weld removal operation when the cover was removed from the case. The cover edge should be square and expose clean metal.
2. Clean the underside of the cover three inches back from the cover edge to a smooth surface. A disc grinder is recommended for this operation.

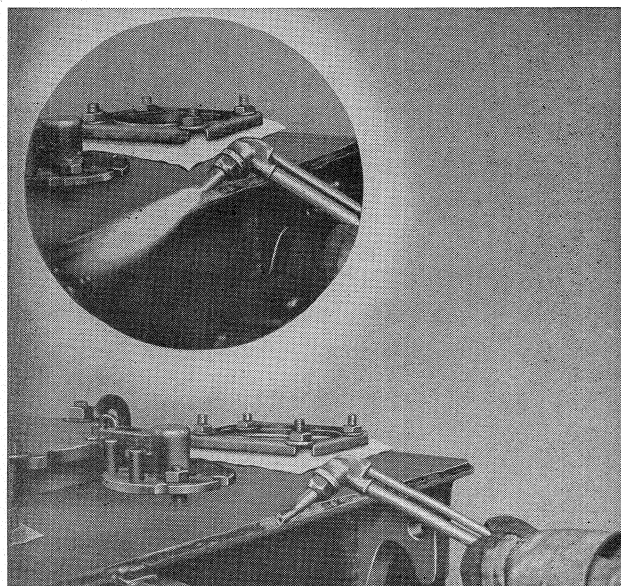


FIG. 5. Removing Weld by Gas Torch

3. Remove and wipe all foreign material from the cover, especially from the underside to prevent dirt falling into the transformer when the cover is placed in position on the transformer case.

Preparing the Case Flange to Receive the Cover.

1. Place a blanket of clean paper or cloth over the entire transformer a few inches below the case flange. This blanket should be attached and continuously sealed with wide masking tape around the entire interior of the case. This is necessary to prevent any foreign material falling into the transformer.

2. Remove any raised irregularities from the top surface of the flange by chipping or grinding. A sanding disc will do the job very effectively, or a grinder may be used; in either case, it should be used so that the material removed from the flange will be thrown away from the transformer case rather than into it. This surface must be smooth to permit the cover to fit tightly and uniformly around the case.

3. Gently brush cuttings and debris collected on the blanket over the transformer to the center of the blanket. Remove this debris, then carefully pull the sealing tape from the case walls to free the blanket. Make certain that the edges of the blanket are kept above the center of the blanket at all times so that any foreign material on the blanket will not roll into the transformer.

Applying the Asbestos Sealing Gasket to the Case Flange.

1. Brush a $\frac{1}{2}$ " wide coating of #7386 red cement $1\frac{1}{2}$ " to 2" back from the edge of the flange completely around the case. Care must be observed to prevent any cement extending onto the weld area as it will cause weld porosity.

2. Place a $\frac{1}{8}$ " diameter asbestos rope #3879 completely around the case flange in the center of the freshly applied cement. There must not be any openings in the gasket. Use a good butt joint, or allow one end to extend a little in back of the other.

Positioning the Cover and Preparing for Welding.

1. Lower the cover onto the case flange so that it is in its approximate final position without sliding across the asbestos gasket. Normally the flange will extend approximately $\frac{1}{2}$ " beyond the cover edge.

2. Clamp the cover and flange tightly together around its entire periphery with C-clamps. Place the C-clamps near the edge of the cover so that the welding operator can weld under the clamps.

The cover edge should be tight against the flange before any welding is done at that point.

Welding the Cover to the Flange.

1. Cover all openings in the cover.
2. Apply a $\frac{1}{8}$ " fillet sealing weld around the

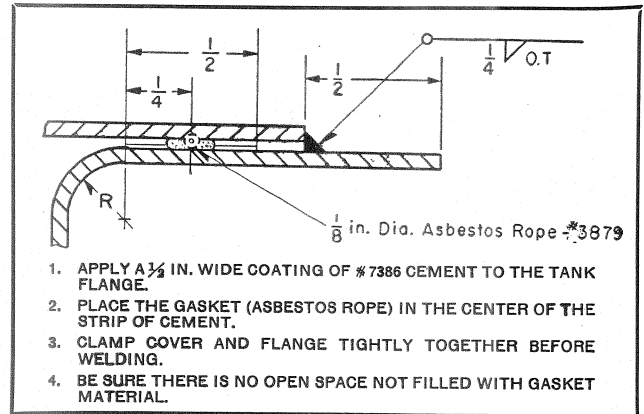


FIG. 6. Method of Joining Cover to Flange

cover starting at one corner of the case and welding around it. Use Westinghouse $\frac{5}{32}$ " diameter DH-coated electrodes (#972 076 for 50% packages). This is an American Welding Society Type E-6020 electrode and is recommended for horizontal fillets or downhand welding. It is recommended for this weld because of its high penetrating properties. Either a-c or d-c (reverse polarity preferred) current may be used with a current setting of 155 to 175 amperes.

3. Remove the C-clamps from the cover and flange.

4. Remove the slag from the weld bead and wire brush.

5. Weave a $\frac{1}{4}$ " fillet weld over the $\frac{1}{8}$ " fillet weld using Westinghouse $\frac{5}{32}$ " diameter FP electrodes and a welding current of 150 to 160 amperes. This electrode (S#1528 912 in 50% packages) is also a coated electrode. It is an American Welding Society Type E-6012 and may be used with a-c or d-c (straight polarity preferred) current.

6. Clean the slag from the weld and brush. Paint the weld, the flange and the edge of the cover with primer and touch-up paint.

FORM-FIT TANK TOP SECTIONS

To replace the top section of a form-fit tank that has been previously removed as described above, the following is recommended:

Preparing the Top Section for Replacement.

1. Chip or grind any remaining irregularities left along the bottom face and edge of the flange

REMOVING AND REPLACING WELDS

of the top section. The flange edge should be square and expose clean metal. The bottom side of the flange should be smooth.

2. Wipe all foreign material from the flange.

Preparing the Flange of the Bottom Section to Receive the Top Section.

1. Wrap and attach with masking tape an 8" to 12" wide strip of heavy paper or cloth around the iron directly above the flange.

2. Remove any irregularities from the top surface of the flange by chipping or grinding. When grinding, one should use the grinder so that the material removed is thrown away from the transformer rather than against the iron core. Brush and wipe all foreign material from the flange with a dry cloth. This surface must be smooth to permit the top section to fit tightly and uniformly around the case.

3. Remove the 8" to 12" wide protecting material previously placed around the iron.

Applying the Sealing Gasket to the Flange of the Bottom Section.

1. Brush a 1½" wide coating of #7386 red cement 2" back from the edge of the flange of the bottom section. Care must be observed to prevent any cement extending onto the weld area as it will cause weld porosity.

2. Place the sealing gasket #1598 upon the freshly applied cement with the tape edges outward, completely around the flange. There must not be any openings in the gasket. Use a good butt joint or allow one end to extend a little in back of the other.

Positioning the Top Section and Preparing for Welding.

1. Lower the top section slowly over the transformer assembly until it is seated on the flange of the bottom section.

2. Clamp the flanges of the top and bottom sections together tightly around its entire periphery with C-clamps. Place the C-clamps near the edge of the flange so that the welding operator can weld behind the C-clamps. The two flanges must be tight together before any welding is done at a given point.

Welding the Top Section to the Bottom Section.

1. Apply a 1/8" fillet sealing weld around the top surface starting at one corner of the case and weld around it. Use Westinghouse 5/32" diameter DH-coated electrodes S# 972 076 for 50# packages.

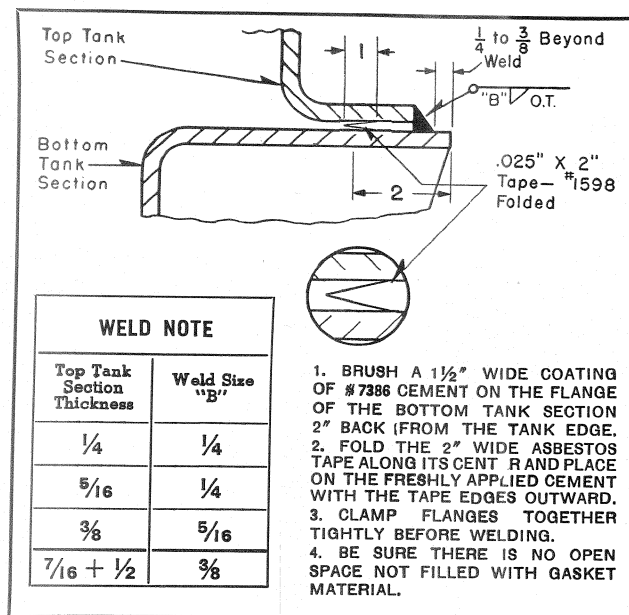


FIG. 7. Joining of Flanges, "Form-Fit" Tank

This is an American Welding Society Type E-6020 electrode and is recommended for horizontal fillets or downhand welding. It is recommended for this weld because of its high penetrating properties. Either a-c or d-c (reverse polarity preferred) current may be used with a current setting of 155 to 175 amperes.

2. Remove the C-clamps from the cover and flange.

3. Remove the slag from the weld bead and wire-brush.

4. Weave a $\frac{1}{4}$ " fillet weld over the $\frac{1}{8}$ " fillet weld for top sections made of $\frac{1}{4}$ " and $\frac{5}{16}$ " thick plate, a $\frac{5}{16}$ " weld for $\frac{3}{8}$ " thick top sections and a $\frac{3}{8}$ " weld for $\frac{7}{16}$ " or $\frac{1}{2}$ " thick top sections. Deposit this weld with Westinghouse $\frac{3}{16}$ " diameter FP electrodes and a welding current of 190 to 210 amperes. This electrode is a coated electrode S#1528 913 in 50# packages. It is an American Welding Society Type E-6012 and may be used with a-c or d-c (straight polarity preferred) current.

5. Clean the slag from the weld and brush.

6. Paint the weld and the flanges with primer and touch-up paint.

WELD AT BOTTOM OF TANK WALL

Many transformer designs will have a bottom weld between the tank wall and the tank bottom. This arrangement, which is not of the form-fit design, is illustrated in Fig. 8. It is necessary to remove this

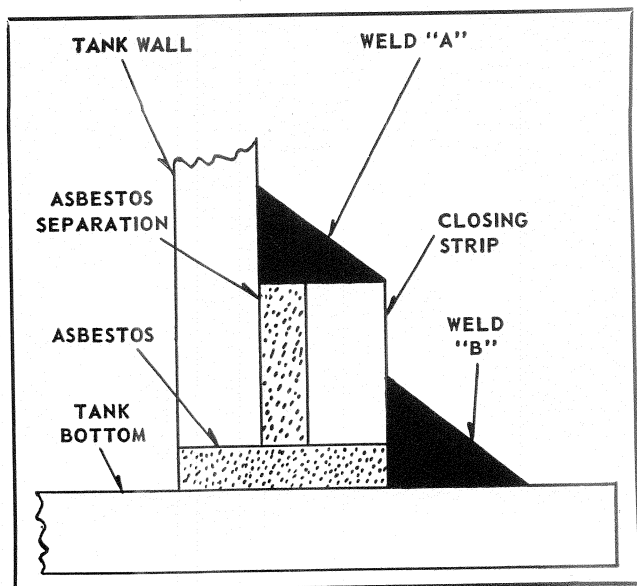


FIG. 8. Weld between Tank Wall and Tank Bottom

weld to lift the tank away from the bottom so that the core and coil assembly can be removed. Because of limited space beneath the coolers it is recommended that the weld be removed by gas cutting.

Removing a Weld at the Bottom of the Tank.

The procedure for the removal of a bottom weld is similar to removing a welded-on cover by gas cutting except as follows:

1. Weld "A" of Fig. 8 must be removed, not weld "B". This is to prevent the gas flame from reaching the oil that has dripped from the core and coil assembly and collected on the tank bottom.

2. Remove the weld completely as well as approximately $\frac{1}{8}$ " of the closing strip to insure adequate separation between the closing strip and the tank wall.

3. Use on Oxweld #13, Style 1511 tip, directing the flame in the direction of the weld as shown in Fig. 5.

4. Remove the tank from the bottom by lifting after all the internal connections between the core and coil assembly and tank are removed.

Replacing Tank and Weld.

1. Before replacing the tank on the base, remove irregularities from the tank surface and the inside of the closing strip by grinding.

2. After replacing the tank, close up the clearance between the tank wall and closing strip. This is to be done by calking with $\frac{3}{16}$ " diameter asbestos rope #3879 all around the tank. Care should be taken that there are no asbestos fibers protruding that might produce a defective weld.

3. Proceed with welding the tank wall to the closing strip using the same method as specified in welding the cover to the flange, except that clamping is not required.



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