

## Welding Guidelines\*

WeatherMAX is made from a thermal polymer, which makes it ideal for welding. The table below provides welding information provided by welding equipment manufacturers that have performed testing on WeatherMAX 80 and WeatherMAX FR.

Please be aware that these are only guidelines provided as a starting point. It will take individual adjustments to perfectly dial in the best settings for your facility and equipment.

	Wedge		Hot Air		RF		Impulse	
	w. tape	WO tape	w. tape	WO tape	w. tape	WO tape	w. tape	WO tape
<b>WeatherMAX 80</b>	X	X	X	X	X	-	-	-
<b>WeatherMAX FR</b>	X	-	X	-	X	-	-	-

Material	Heat System	Tape	Machine	Temp	Speed	Pressure	Peel	Tension
WeatherMAX 80	Wedge	SS71	MW T300	400c	2m	0.2	Good	Good
	Wedge	None	MW T300	380c	10m	0.2	Excellent	Excellent
	Wedge	SS71	Triad Spec	430c	40%		Good	Good
	Hot Air	SS71	MW 112 Extreme	600c	10	10 / 17 (W/C)	Good	Good
	Hot Air	None	MW 112 Extreme	675c	27	10 / 17 (W/C)	Excellent	Excellent
	Impulse	SS71	MW Impulse	High	15H, 30c		Good	Good
	RF	Bemis	Thermex 10kw+	.39 amp			Good	Good
WeatherMAX FR	Wedge	SS71	MW T300	400c	2m	0.2	Good	Good
	Hot Air	SS71	MW 112	600c	10		Good	Good
	Impulse	SS71	MW Impulse	High	15H, 30c		Good	Good

WeatherMAX 80 can be welded without tape due to its thermal polymer fiber. There are thousands of installation made with WeatherMAX 80 have used hot air and wedge welding without tape. The seam results are excellent – smooth, strong and even.

We recommend welding without tape for several reasons:

1. Fiber to fiber is a stronger bond
2. It eliminates the extra cost of the tape
3. It eliminates the variations inherent with tape

**WeatherMAX FR requires tape due to the FR coating RF welding requires a machine with a minimum of 10kw power**

\* 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.

