



Operating instructions
Welding aid for Aseptoflex Vario adapter

GB

E30452



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1 Preliminary note

You will find instructions, technical data, approvals and further information using the QR code on the unit / packaging or at www.ifm.com.

1.1 Symbols used

- ✓ Requirement
- ▶ Instructions
- ▷ Reaction, result
- [...] Designation of keys, buttons or indications
- Cross-reference
-  Important note
Non-compliance may result in malfunction or interference.
-  Information
Supplementary note

1.2 Warnings used



CAUTION

Warning of personal injury

- ▷ Slight reversible injuries may result.

2 Safety instructions

- Read this document before setting up the product and keep it during the entire service life.
- The product must be suitable for the corresponding applications and environmental conditions without any restrictions.
- Only use the product for its intended purpose (→ Intended use).
- If the operating instructions or the technical data are not adhered to, personal injury and/or damage to property may occur.
- The manufacturer assumes no liability or warranty for any consequences caused by tampering with the product or incorrect use by the operator.
- Installation, set-up, operation and maintenance of the product must be carried out by qualified personnel authorised by the machine operator.

3 Intended use

The welding aid absorbs the thermal energy during the welding operation and helps to stabilise the adapter.

4 Installation

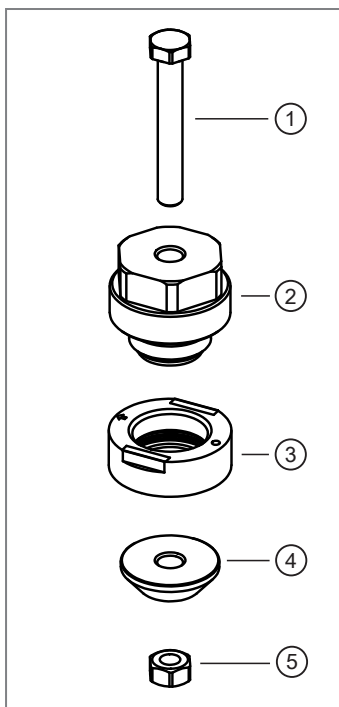
These accessories may only be replaced by more effective measures such as internally cooled mandrels with the same geometry, provided that the sealing edge is protected but not negatively influenced by the accessories themselves and their mounting forces.



CAUTION

During the welding operation, the adapter, the surrounding material and the welding aid can increase in temperature to over 65 °C (149 °F).

- ▷ Risk of burns.
- ▶ Allow all components to cool down.



- 1: M10 fastening screw (19 mm width across flats)
- 2: Welding aid with M12 internal thread
- 3: Optional welding adapter for tank applications
- 4: Counter plate with through-hole for fastening screw (1)
- 5: M12 nut

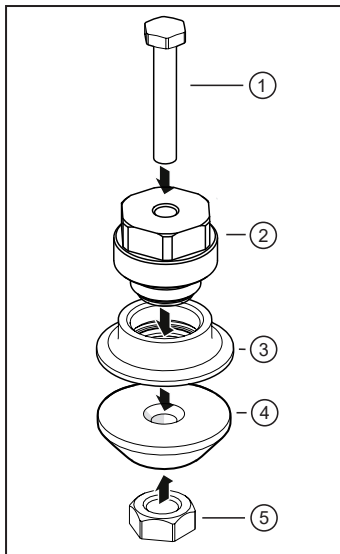
4.1 Use on adapter plates and tanks

The welding aid (in pipes) and the additional counter plate (in tanks, if accessible from the inside) must be used.

These accessories may only be replaced by more effective measures such as internally cooled mandrels with the same geometry, provided that the sealing edge is protected but not negatively influenced by the accessories themselves and their mounting forces.

- ▶ Screw the welding aid (2) hand-tight into the adapter (3) to be welded in.
- ▶ Position the counter plate (4) with its through-hole underneath the welding adapter (3).
- ▶ Insert the fastening screw (1) from above through the screwed-in welding aid (2) with the adapter (3) and the counter plate (4) and screw it with the nut (5) using a spanner. Max. tightening torque 20 Nm.
- ▶ Feed forming gas according to the state of the art from both sides in such a way that the weld seam is separated from the atmosphere or the influence of oxygen.
- ▶ Carry out the welding operation → Installation instructions Welding adapter.
- ▶ After each welding, including the cooling phase, check the thread of the welding adapter for ease of movement.
- ▶ After completion, remove all components from the welding adapter.

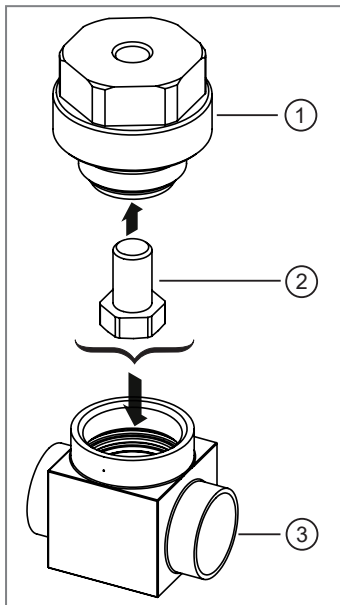
- ▶ Replace the welding adapter if damaged.



- 1: M10 fastening screw (19 mm width across flats)
- 2: Welding aid with M12 internal thread
- 3: Adapter to be welded in
- 4: Counter plate with through-hole for the fastening screw (1)
- 5: M12 nut

4.2 Use on pipes and inline housings

- ▶ Screw the screw (2) into the welding aid (1) from below to prevent the forming gas from escaping.
- ▶ Screw the welding aid (1) hand-tight into the welding adapter (3) to be welded in.
- ▶ Carry out the welding operation → Installation instructions Welding adapter.
- ▶ After each welding, including the cooling phase, check the thread of the welding adapter for ease of movement.
- ▶ After cooling, remove the welding tool components from the welding adapter and check that the thread and sealing edge are not damaged.
- ▷ Replace the welding adapter if damaged.



- 1: Welding aid with M12 internal thread
- 2: M12 screw
- 3: Inline housing / welding adapter on the pipe or a welding boss on the pipe

4.3 Further accessories for processing the weld seam



Prevent any damage to the sealing edge and the transition area on the welding adapter if subsequent surface post-processing (e.g. grinding / polishing of the weld seam) is necessary.

- ▶ → Operating instructions E30160
- ▶ → Operating instructions E30161
- ▶ → Operating instructions E30162

5 Disposal

- ▶ After use dispose of the product or components in an environmentally friendly way in accordance with the applicable national regulations.