

Hot Air Welding Sarnafil G/S

Prior to hot air welding Sarnafil G/S each day, or whenever there is a significant change in ambient air temperature, test weld samples should be made to determine the correct welding temperature and speed for the welding equipment being used.

Sarnafil recommend the following initial settings are tested:

Sarnamatic 641, 641mc or 661 230v

Temperature	430°C
Speed	3.0
Air Setting	5

Sarnafil Perimat

Temperature	450°C
Speed	1.8
Air Setting	-

Leister Triac S

Temperature with 40mm nozzle	6 – 6.5
Temperature with 20mm nozzle	5 – 5.5

Leister Triac PID

Temperature with 40mm nozzle	380°C
Temperature with 20mm nozzle	380°C



A test weld is conducted by following the recommended welding procedure for each product and allowing the sample to cool, prior to pulling the upper sheet at the beginning or end of the seam in the seam direction. If a continuous weld has been achieved, the dark underside of the top membrane will delaminate and remain on the top surface of the lower sheet. It should be noted that this is a destructive test and not recommended for the actual roof welds, which should be checked by running a probe/screwdriver (approximately 5mm wide with rounded edges) along the seam, applying pressure into the weld as it is pulled along. Defects should be marked clearly and repaired immediately.