



INSTRUCTIONS

GEI-280088

POWER TRANSFORMERS

REMOVING AND REWELDING COVERS

INTRODUCTION

Carefully follow these instructions when removing and rewelding transformer covers. If this is done, a strong, sound joint, free from leaks, will result.

REMOVING THE COVER

Welded covers can be removed by either chipping or oxygen gouging (to remove the weld). Oxygen gouging is considerably faster than chipping, and is recommended for all welds of 1/16 inch and over, where adequate precautions can be taken for the fire hazard which exists with oxygen-acetylene cutting operations.

Before weld removal is started, make a sketch of the cover weld noting the normal stresses especially if there are locations where the weld is made tighter to reinforce joints of higher stress. Reweld the cover in accordance with this sketch.

OXYGEN-GOUGING METHOD

Before oxygen gouging of welds on oil-filled transformers, thoroughly flush out the air space inside the tank with carbon dioxide or carbon dioxide. Maintain a small flow of the gas during the gouging operation. (This precaution is not necessary for Pyramul® filled transformers).

Oxy-acetylene cutting torch equipment is recommended with gouging tips similar to Air Reduction Style No. 115. For best performance of the gouging operation a cutting torch similar to Ames Rodin 5000 having a regulated control of the high pressure oxygen flow is recommended. Tip sizes and gas pressures recommended for various steel weld sizes are shown in Table I.

Clamp the cover during the cutting operation to prevent the cutting and abrading sparks and particles of metal and slag. Protect all openings against the intrusion of foreign material. The entire weld may

be removed in one pass, with care to avoid deep gouging of the edges of the tank or cover. Slag and metal adhering to the cover and tank flange after gouging can be easily removed by a light chipping operation. Round the edges of the cut joints with a disc grinder in preparation for rewelding. Keep the cover tightly clamped until all cleaning operations are completed.

TABLE I

Filler Metal Size	Tip Size	Oxygen Pressure	Acetylene Pressure
1/16 in.	# 8	60 psi.	8 psi.
1/8 and 3/16 in.	# 10	70 psi.	8 psi.
1/2 in. and up	# 12	75 psi.	8 psi.

CHIPPING METHOD

When it is desired to remove welds by chipping, this can be accomplished with diamond-point chisels and a pneumatic hammer. Clamp the cover to the flange to prevent sagging, as the weld is chipped away. Protect all openings in the cover against chips entering the transformer.

REWELDING THE COVER

Before rewelding the cover to the transformer tank, thoroughly clean the cover edges and tank flange to remove traces of oil or Pyramul. Break both gasket surfaces with water glass (sodium silicate) conforming to G-E Specification D50P340. Attach a strip of dry asbestos gasket of approximately 1/16 inch thickness and use as a half inch width to the tank flange or cover. Fold this gasket over to make it approximately 1/4 inch wide. Locate the outer edge approximately 1/2 inch from the outer edge of the cover (see Fig. 1). Clamp the cover securely to the tank flange with several "C" clamps, bringing the cover securely down on the gasket.

On both Pyramul and oil-filled transformers, seal

* Registered trade-mark for G-E product

These instructions are intended to give a brief summary of proper and safe methods of removing and rewelding transformer covers. It does not constitute a contract, and the user must refer to the actual drawings for complete details.

GENERAL  ELECTRIC

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