



4 Professional Choices for Hygienic Wall and Ceiling Cladding

Datasheet 9 Hot Welding Joints

1. Welding limits the ability of the installation to deal with expansion and contraction. Welding is not suitable in applications where temp variation is more than 10 deg C. The installation temperature must be similar to the final operating conditions, and must be 10 deg C min. Panels must be allowed to acclimatise for 24 hrs prior to fitting
2. Moisture and condensation can reduce the adhesive bond. Panels must be stored flat and above the floor. The substrate must have a moisture content of max 16 WME.
3. All substrates that require a welded joint finish must be smooth and level. Ply board, bonded plaster, and bonded plaster board are ideal. Brick or block work will require one of these finishes to be applied prior to welding.
4. It is recommended to test weld a piece of waste material before commencing with the finished work. It is also recommended to have the client approve a sample of the weld quality before proceeding.
5. Panel and wall surfaces must be cleaned and ready to accept adhesive and sticking tape.
6. If the project requires a Joint Strip along the bottom edge e.g. where a transition between vinyl floor and panel is required, fit the back of the 2 part Joint Strip before panels.
7. Check panels are square and removes any edge burrs. Bevel the edge of the wall board prior to fitting, using a sharp blade this creates a larger surface area to accept weld.
8. Fit double-sided padded tape (50mm wide) to the wall where the joint will fall. Make sure that the tape is well adhered to the substrate.
9. Apply 50mm wide padded double sided tape to the wall, floor to ceiling, bridging the gap where two boards will meet. Apply Proclad 2 part PU adhesive using a notched trowel to the wall stopping short of the tape by 50mm.

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10. Place the board onto the wall making sure the tape runs down the edge of the board, offer the next board up leaving a gap between the boards of 1.5mm to 2mm to accept the weld the gap can be achieved by using spacers, the padded tape will bridge the gap behind the boards.
11. Always clean the area to be welded and the welding rod with a solvent cleaner – ensuring that no residue is left behind.
12. Set the welding gun to 50oC and allow warming up for 5 mins. Apply weld to gap from ceiling to floor using a constant even speed.
13. Trim weld top and bottom of sheet. Spray surface of weld with soapy water to reduce risk of damaging surface of the boards when removing excess weld with sharp blade. The weld should be flush with the surface of the boards.

