



INSTRUCTIONS

GEI-28008B

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 5/16 inch size and over, where adequate precautions can be taken for the fire hazard which exists with oxy-acetylene cutting operations.

Before weld removal is started, make a sketch of the cover weld noting the normal size. Note especially if there are locations where the weld is made larger to reinforce points 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 either dry nitrogen or carbon dioxide. Maintain a small flow of the gas during the gouging operation. (This precaution is not necessary for Pyranol* filled transformers).

Oxy-acetylene cutting torch equipment is necessary with gouging tips similar to Air Reduction Style No. 183. For best performance of the gouging operation a cutting torch similar to Airco Series 3000 having a graduated control of the high pressure oxygen flow is recommended. Tip sizes and gas pressures recommended for various fillet weld sizes are shown in Table I.

Clamp the cover during the cutting operation to prevent its raising and admitting sparks and particles of metal and slag. Protect all openings against the entrance 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. Grind the edges of the cut smooth with a disc grinder in preparation for rewelding. Keep the cover tightly clamped until all cleaning operations are completed.

TABLE I

Fillet Weld Size	Tip Size	Oxygen Pressure	Acetylene Pressure
5/16 in.	# 8	60 psi.	8 psi.
3/8 and 7/16 in.	# 10	70 psi.	9 psi.
1/2 in. and up	# 12	75 psi.	9 psi.

CHIPPING METHOD

Where 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 raising, 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 Pyranol. Brush both gasket surfaces with water glass (sodium silicate compounded to G-E Specification DSOP24). Attach a strip of dry asbestos gasket of approximately 1/16 inch thickness and one and a half inch width to the tank flange or cover. Fold this gasket once to make it approximately 3/4 inch wide. Locate its 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 Pyranol and oil-filled transformers, seal

*Registered trade-mark for G-E assets

These instructions do not purport to cover all details or variations in equipment nor to provide for every possible contingency to be met in connection with installation, operation or maintenance. Should further information be desired or should particular problems arise which are not covered sufficiently for the purchaser's purpose, the matter should be referred to the General Electric Company.

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