

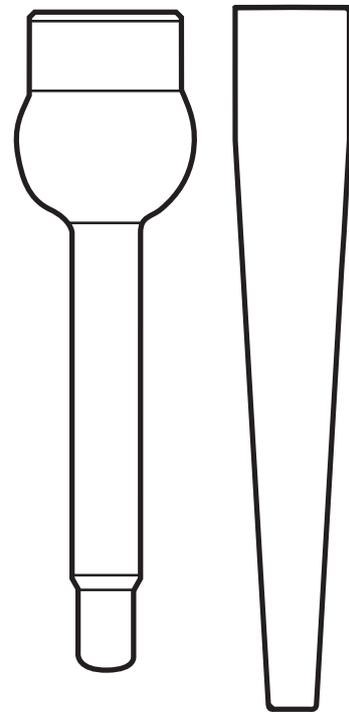
Installation instructions  
Welding thermowell

**E30403**

**E374x1**

**E374x0**

**UK**



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# 1 Welding the thermowell



The welding should only be carried out by qualified personnel.

- ▶ Use materials and welding operations that are suitable for the housing material.
- ▶ Use welding techniques according to EHEDG requirements (Doc 9) to ensure a good weld. In order to apply the required 3 mm radius to the inner surface a second fillet weld is necessary.
- ▶ Ensure the careful preparation of the components:
  - Grind and polish the inside weld to achieve a minimum radius of 3 mm.
  - Ensure the surface roughness of  $R_a \leq 0.8 \mu\text{m}$  for optimised cleanability.

## 2 Welding operation

- ▶ Apply the fixing points of the thermowell at equal distance (crosswise) with a sufficient adhesive force.
- ▶ Apply the welding seams crosswise between the fixing points.
- ▶ Observe the cooling phases between the individual welding operations.
- > They avoid glowing through / warping of the thermowell due to overheating.



Ensure full weld penetration to have no crevice where the weld seam is in contact with the medium according to EHEDG requirements (Doc 9).

## 3 After completion of the welding process

- ▶ Let the workpiece cool down.
- ▶ Slightly grease the thread using a lubricating paste which is suitable and approved for the application.
- ▶ Screw the sensor into the adapter and tighten. Tightening torque: 30...50 Nm.