



BUILDING TRUST



HOT AIR WELDING GUIDELINES

RoofJoint

Do not install this material until all members of your crew have read and understand these instructions. If you do not understand any part of these instructions CALL SIKI EMSEAL at 1-800-526-8365

Robot Welding

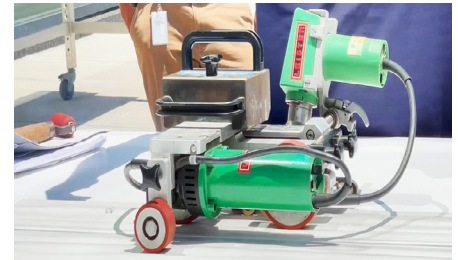
Long RoofJoint Flange to Roofing Membrane

- Machines designed for single-ply roofing typically work well.
- Heat should be set close to ~500°C (~932°F).
- Machine runs at 1.3-meters/minute (4.26-feet/min).

Hand Welding

RoofJoint Flanges to Roofing Membrane

- 3/4-inch (20mm) or 1 1/2-inch (40mm) wide nozzle tips on hot air gun are effective. 3/4-inch (20mm) may produce more reliable results.
- Heat for PVC to RoofJoint PVC welding should be 400-500°C (752-932°F).
- Heat for TPO to RoofJoint TPV welding, 350-400°C (662-752°F).
- For heat calibration on welder with no specific temp reading, gun should be hot enough that, when held 1-inch (25mm) above membrane for 5-seconds, the material will melt, but not scorch/burn. Pressing the heating surface with a finger will readily demonstrate that. (Gloves recommended).
- Progress at 1 1/2-feet/minute (.46-meters/minute). Roll directly behind the tip of the hot air gun.



*Photos above shown with PVC membrane.

NOTE: These settings will vary depending on equipment & environment.

It's recommended to calibrate and test weld at start-up.

EMSEAL JOINT SYSTEMS, LTD
25 Bridle Lane
Westborough, MA 01581 USA
Phone: 508.836.0280
Fax: 508.836.0281
www.emseal.com

EMSEAL, LLC
111 Royal Group Crescent
Woodbridge, ON L4H 1X9 Canada
Phone: +1-416-740-2090
Fax: +1-416-740-0233
www.emseal.com

SIKA CORPORATION
201 Polito Avenue
Lyndhurst, NJ 07071 USA
Phone: +1-800-933-7452
Fax: +1-2019336225
www.usa.sika.com

RJ Hot Air Welding Guidelines
Sika Emseal RoofJoint
July 2024 Version SE-1.1



BUILDING TRUST

