

# WELDING A NEW MEMBRANE TO AN EXISTING AGED MEMBRANE

## PRELIMINARY GUIDELINES

The TPO-FPA Sintofoil series membranes are easily weldable and require no pre-treatment for welding. Even years after installation, these membranes retain their intrinsic property of easy weldability.

However, during application, any membrane may be subject to contamination. Additionally, outdoor exposure leads to the accumulation of dirt, smog, and other deposits that could compromise welding operations unless proper preliminary cleaning is performed.

IMPER ITALIA has developed a standard procedure to effectively weld a new membrane to an existing, installed one, whether dirty or aged, in order to ensure successful repairs or modifications to the waterproofing system.

In certain specific situations, when the membrane is extremely dirty or contaminated, thorough cleaning is essential before welding procedure. Below are the details of the specific method to address such circumstances:



### 1. Remove all traces of dust, dirt, and deposits from the membrane.

After eliminating the heavier dirt and surface deposits from the membrane (such as soil, smog, dust, or other residues) using a broom or pressure washer, scrub the area to be treated with an abrasive sponge like SCOTCHBRITE®, using clean water or IMPER ITALIA's **FUSE PREP PLUS** cleaner.

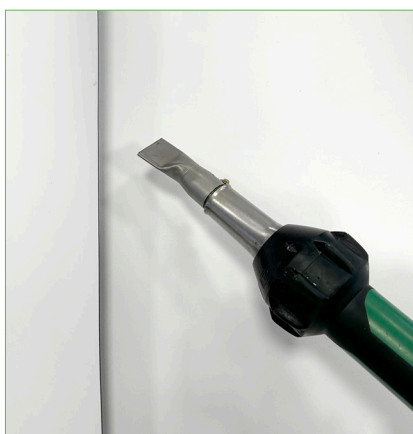
### 2. The area to be cleaned should extend at least 50 mm in every direction beyond the welding area.

This precaution helps to remove any contaminants from the adjacent areas, preventing interference with the welding process and ensuring optimal adhesion of the membrane.





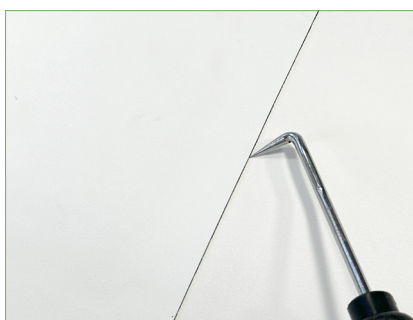
3. Clean with blotting paper and **FUSE PREP PLUS** cleaner until the surface and the paper appear clean.



4. Wait for the **FUSE PREP PLUS** cleaner to evaporate completely. To speed up this process, use light drying with warm air from a heat gun.



5. Weld the new membrane (top layer) onto the existing, clean, and dry membrane (bottom layer) using the manual welding technique.



6. Testing. Check the welds with the appropriate hook tool..

*For more information, contact the technical support service of IMPER ITALIA.*