

Welding rods



Welding rods are designed for extrusion welding of geomembranes (polymeric geosynthetic barriers) made of high-density polyethylene (PE-HD). Extrusion welding is used mainly for details, penetrations, less accessible spots, patches, repairs and connections of different kind.



Extrusion welding

Extrusion welding is a semi-mechanised method in which welding machines, so called extruders, are used. In an extruder the welding rod is plasticized and extruded through the welding shoe onto the place of the intended weld. Before applying the extrudate, the welded surfaces are pre-heated by hot air (a process carried out by the welding machine). The extrusion weld geometry is determined by the shape and dimensions of the welding shoe. The welded surfaces must be adequately prepared before extrusion welding commences and the extrudate is applied. The geomembrane liner suitable for extrusion welding must be of sufficient thickness (the minimum thickness of 1.5 mm is recommended).



Standard types

Welding rods are produced by JUTA a.s. as a complement to the range of geosynthetic liners JUNIFOL®.

WELDING RODS		Melt mass-flow index (MFI) EN ISO 1133 (190 °C/5 kg) g/10 min.	Density EN ISO 1183 g/cm ³		
JUTA WR PLUS		1.0 ± 0.4	0.946 ± 0.004		
JUTA WR PREMIUM		2.6 ± 0.4	0.944 ± 0.005		
PACKAGING					
rod diameter (mm)	profile	SMALLER SPOOL (30 cm in diameter)		BIGGER SPOOL (35 cm in diameter)	
		rod weight (kg)	box (60×48×30 cm)* pallet (1.2×1.0×1.35 m)*	rod weight (kg)	box (40×50×40 cm)* pallet (1.2×1.0×1.35 m)*
3	round	2.4 ± 5 %	8 spools	4.8 ± 5 %	4 spools
4			12 boxes		18 boxes
5					

* length × width × height the weight of the box approx. 20 kg / every spool is wrapped hermetically

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