



GENERAL NOTES:

1. ALL MATERIALS TO BE HDPE PE-100 AS PER SABS ISO 4427 / SANS 4427
2. HOOP STIFFNESS OF MANHOLE SHAFT TO BE 8KN/m²

GENERAL WELDING SPECIFICATIONS:

1. BUTT WELDING OF PIPES TO COMPLY TO SABS 0268-1:1999, SANS 10268-1.
2. HOT GAS WELDING TO COMPLY TO SABS 0268-3:1999, SANS 10268-3.
3. HOT GAS EXTRUSION WELDING TO COMPLY TO SABS 0268-4:1999, SANS 10268-4.

GENERAL FINISHING NOTES

1. F1 - REMOVE FILLER EXPULSION AND FINISH WELD SMOOTH WITH PIPE SURFACE.
2. F2 - REMOVE FILLER EXPULSION AND FINISH WELD WITH SMOOTH ROUNDED EDGE.
3. F3 - FINISH PIPE WITH SMOOTH ROUNDED EDGE
4. F4 - REMOVE INTERNAL WELDING BEAD.

WELDING NOTATION FOR JOINTS. SEE SABS 0270/SANS 10270 PAR 5AS WELL AS ANNEX A.

1. W-1A = REF TABLE A.1 FILLET GROUP A FIG 1A.
2. W-2A = REF TABLE A.1 FILLET GROUP A FIG 2A.
3. W-3A = REF TABLE A.1 FILLET GROUP A FIG 3A.
4. W-3B = REF TABLE A.1 BUTT GROUP B FIG 3B.
5. W-BUTT = REF TABLE A.2 BUTT GROUP B.

OTHER RELEVANT MANUFACTURING STANDARDS,

1. SABS 0268-1 / SANS 10268-1
2. SABS 0269 / SANS 10269
3. SABS 0270 / SANS 10270
4. SABS 1269 / SANS 1269
5. SABS 1655 / SANS 1655
6. SABS 1671 / SANS 1671-1

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