



Use this guide as you practice hot air welding

Condition	Likely cause	Action
Welding surfaces reject each other.	1) Oil, mastic, dirt or bitumen, etc. fouling weld surfaces inhibiting weld. 2) Insufficient heat transferring to one or both surfaces.	Thoroughly clean surfaces to remove all traces of dirt. Turn heat up – move nozzle closer to weld area – slow gun movement down. Assert more roller pressure (use any one or a combination of the above to correct).
Weld looks good but comes apart when tested.	1) Insufficient heat and/or roller pressure.	Slightly increase heat, work a little slower and apply more roller pressure closer to the weld.
Hot shiny plastic oozes out from weld area.	1) Far too much heat.	Either reduce heat or increase speed, or both.
Weld is strong but job is very distorted.	1) Too much heat.	Fine tune heat control or work slightly faster.
Weld not consistent.	1) Fluctuating hot air force and temperature. 2) Weld envelope not properly repaired.	Check heat supply has sufficient capacity. Ensure there is a closed pocket between the welding surfaces.
Blow holes in weld seam.	1) Water is being trapped between welding surfaces. 2) Roller has rolled over the top of the hot air nozzle	Use hot air tool to blow moisture clear of weld area and ensure hot air weld stream drives water clear. Ensure sufficient gap is maintained between hot air nozzle and pressure roller.

Short demonstration videos can be found on our website to give you a better visualisation of this welding technique.

Creating a pocket into which hot air can be blown against back and side walls enables both weld surfaces to reach identical temperature. Firm progressive pressure rolling as close to the nozzle as practicable ensures a perfect and consistent weld.

