ASHZIP™



welded sheet joints

flexible standing seam roofing systems

ASH=LACY

www.ashandlacy.com

Applications

Under certain conditions there may be a requirement to weld in some locations on an Ashzip roof.

Depending upon the application this may be done on site or under factory controlled conditions.

Such applications would include;

- Cranked sheets
- Split sheets
- Taper joints
- Drainage channels
- Penetrations

In such cases the integrity of the sheet is maintained by employment of skilled approved welders.

For embossed plain stucco sheets the weldina Ashzip process is simple, sheets are simply cut to suit and welded as required. For painted Ashzip, more work is required. The original paint finish needs to be etched back, primed and then touched up. Both options offer a reliable solution to the above listed applications.

Painted sheets welding process

The following example is based on bespoke produced cranked sheets under factory conditions in three steps.

Step 1

The Ashzip sheets are cut to the required length and the paint finish is etched back.



Step 2

The sheets are then welded to the required crank detail ready for re-painting



Step 3

Sheets are then primed and paint re-applied to the required finish. It can be seen from the image below that the colour match cannot be distinguished from the original paint finish



Welding and touching up can also be carried out on site with the same results in terms of paint finish. Normally this would be for longer sheets or where roof penetrations are coming up through the roof.

Penetrations

Penetrations can be placed through the roof on site. Rigid insulation should be used around penetration areas to reduce dishing of the sheets during the welding process as the roof would be subject to higher than normal levels of foot traffic. This should also be considered where maintenance of mechanical equipment is required.

Expansion & Contraction

The designer is to ensure that natural expansion and contraction of the Ashzip system can occur and that weld joints do not impede this process. This may require that fixed points are moved to suit.

Appearance

A good flat finish can be achieved if simple guidelines are followed. These are:

- 1. Use rigid insulation under weld locations.
- 2. Specify a low maintenance system.
- 3. Use spreader board for operatives and their equipment to be placed on.

Examples of neat finished details and construction details are shown on the following pages









Tapered roofs

In certain cases tapered sheets will not be able to run from eaves to ridge in one length due to the geometry of the building. This is covered in the full Ashzip design guide.

Below is an example of where sheets are split and welded. A joint detail is included on the following page

Welding contractors

Weldright UK 9 Avening Close Worcester WR4 9LH 01905 453808

M R Site Services Unit 6 Worcester Trading Estate Blackpole Worcester WR3 8HR 01905 755055





Welding specification

Welding personnel should be qualified to:

- Welding quanlification 012 compliant with EN 288 4
- ASME IX
- EN287/BS EN ISO 9696-2:2004

Material & grades

- Ceriated Tungsten 1.6, 2.4 or 3.2mm diameter
- Aluminium filler wire grade 5556A to BS EN ISO 18273:2004
- Ashzip aluminium 3000 series 0.9mm thick minimum

Method Statement

All site welding should be carried out in conjunction with the relevant welding companies method statement of works

Note

This document is to be read in conjunction with all relevant NBS specifications and the Ashzip design guide. Fabrications and Flashings Fasteners and Accessories Over-Roof Conversion Systems Rainscreen Cladding Systems Standing Seam Roofing Systems Spacer Support Systems

West BromwichBromford Lane, West Bromwich, West Midlands B70 7JJTel:0/21 525 1444Fax: 0/21 525 3444also at: LondonGateway 3, Davis Road, Off Cox Lane, Chessington, Surrey KT9 ITDTel:0/20 8391 9700Fax: 0/20 8391 9701GlasgowUnit 4b, Albion Trading Est, South Street, Whiteinch, Glasgow Gl4 0SYTel:0/41 950 6040Fax: 0/41 950 6080

E-mail enquiries to: sales@ashandlacy.com

Ash & Lacy reserve the right to amend product specifications without prior notice. The information, technical details and fixings advice are given in good faith but are intended as a guide only. For further information please contact Ash & Lacy Building Systems. All products are supplied in accordance with the Ash & Lacy Terms & Conditions of Sale.



www.ashandlacy.com