

20	100	925930-8A	7	066
PLANT NO.	INDEX	DRAWING NO.	SH. NO.	REV. NO.

NOTES:

- WELDS MARKED THUS 1 2 3 IS THE NORMAL WELDING SEQUENCE (SEQUENCE MAY BE VARIED ACCORDING TO CIRCUMSTANCES)
- DO AS MUCH WELDING AS POSSIBLE AT A POINT REMOTE FROM THE LEAK.
- WELDING PER (G.I.M.) GENERAL INSTRUCTION MANUAL 434.001.
- USE LOW HYDROGEN ELECTRODES E 7018. ALL CIRCUMFERENTIAL WELD PASSES TO BE UPHILL.
- ALL DIMENSIONS IN MILLIMETERS UNLESS NOTED OTHERWISE.

REFERENCE DRAWINGS

STD. END BELLS FOR WELD OVER SLEEVE 30" & 31" O.D. PIPE	AB-036528
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TYPICAL INSTALLATION DRAWING

02	6-11-86	MNL	REDRAWN FOR CLARITY.			
REV. NO.	DATE	BY	DESCRIPTION	CHKD	CERT.	APPD.

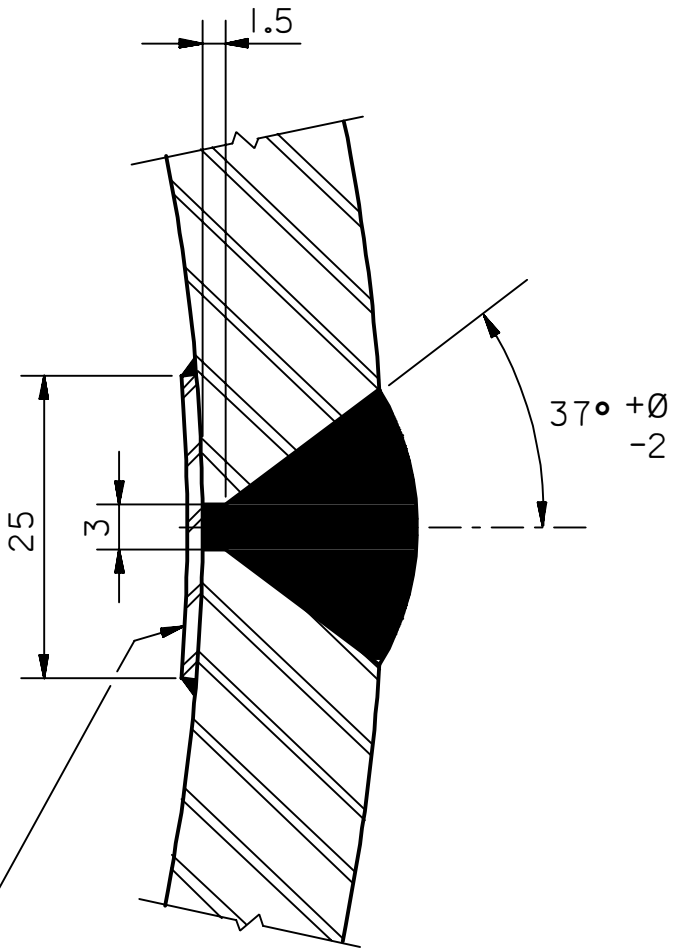
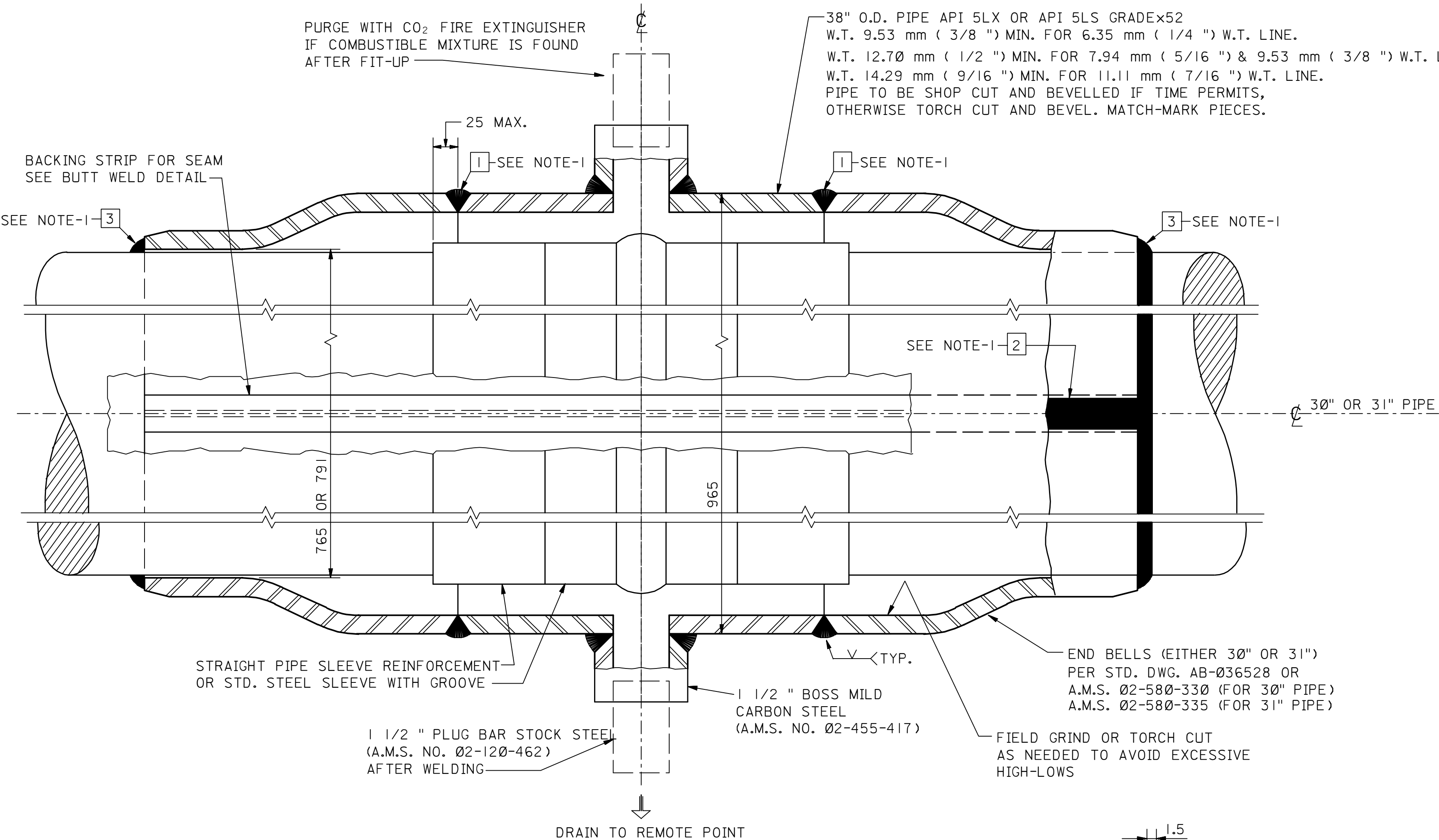
FOR ARABIAN AMERICAN OIL COMPANY

DRAWN BY NJF CHECKED BY NAK SCALE: NONE
DATE STARTED _____ DATE COMPLETED _____
OPR'G. DEPT. _____ ENG. DEPT. _____

THIS DRAWING IS NOT TO BE USED FOR CONSTRUCTION OR FOR ORDERING MATERIAL UNTIL CERTIFIED AND DATED	CERTIFIED DATE
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WELD-OVER SLEEVE FOR
REPAIR OF LEAKING SLEEVES
ON 30" & 31" O.D. PIPE

STD. DWG.			METRIC	
PLANT NO.	INDEX	DRAWING NO.	SH. NO.	REV. NO.
990	L	AB-036526	001	02



1.5 x 25 mm STEEL BACKING STRIP FULL LENGTH TACK WELD IN PLACE AS NECESSARY

DETAIL - BUTT WELD FOR SEAM