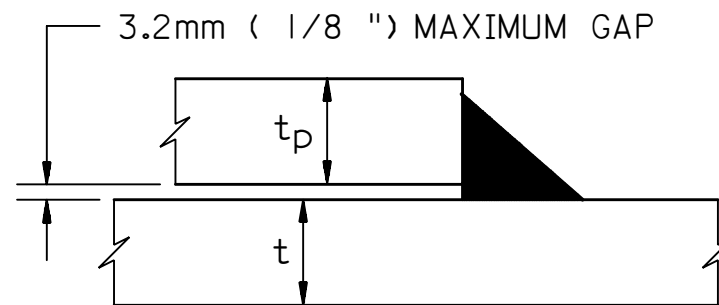
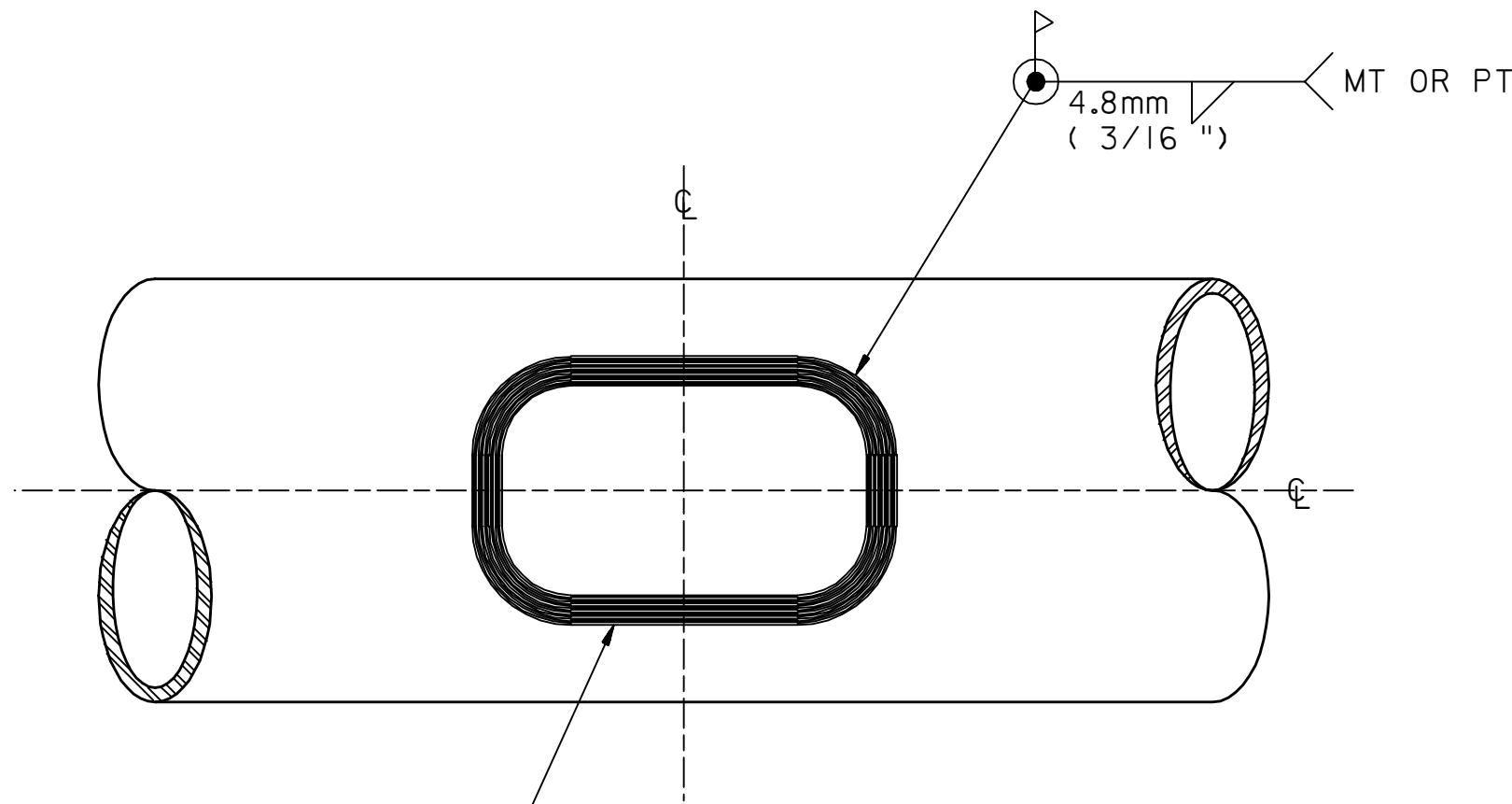
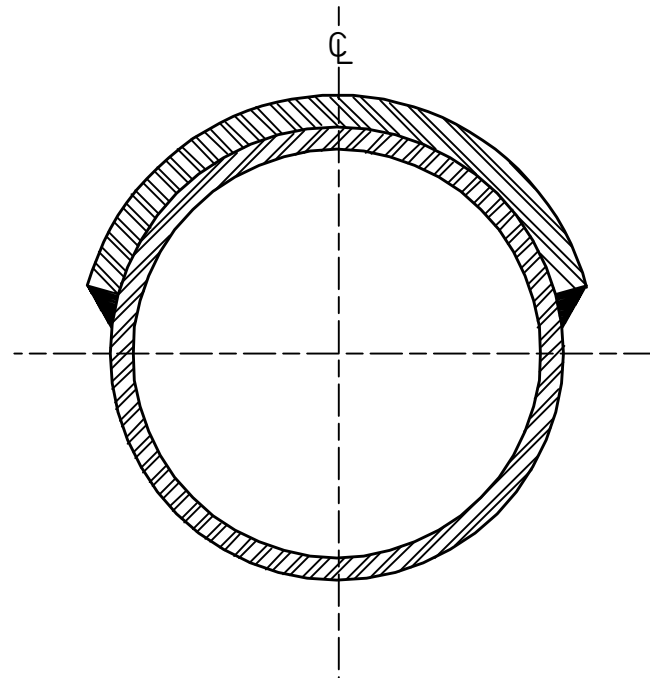
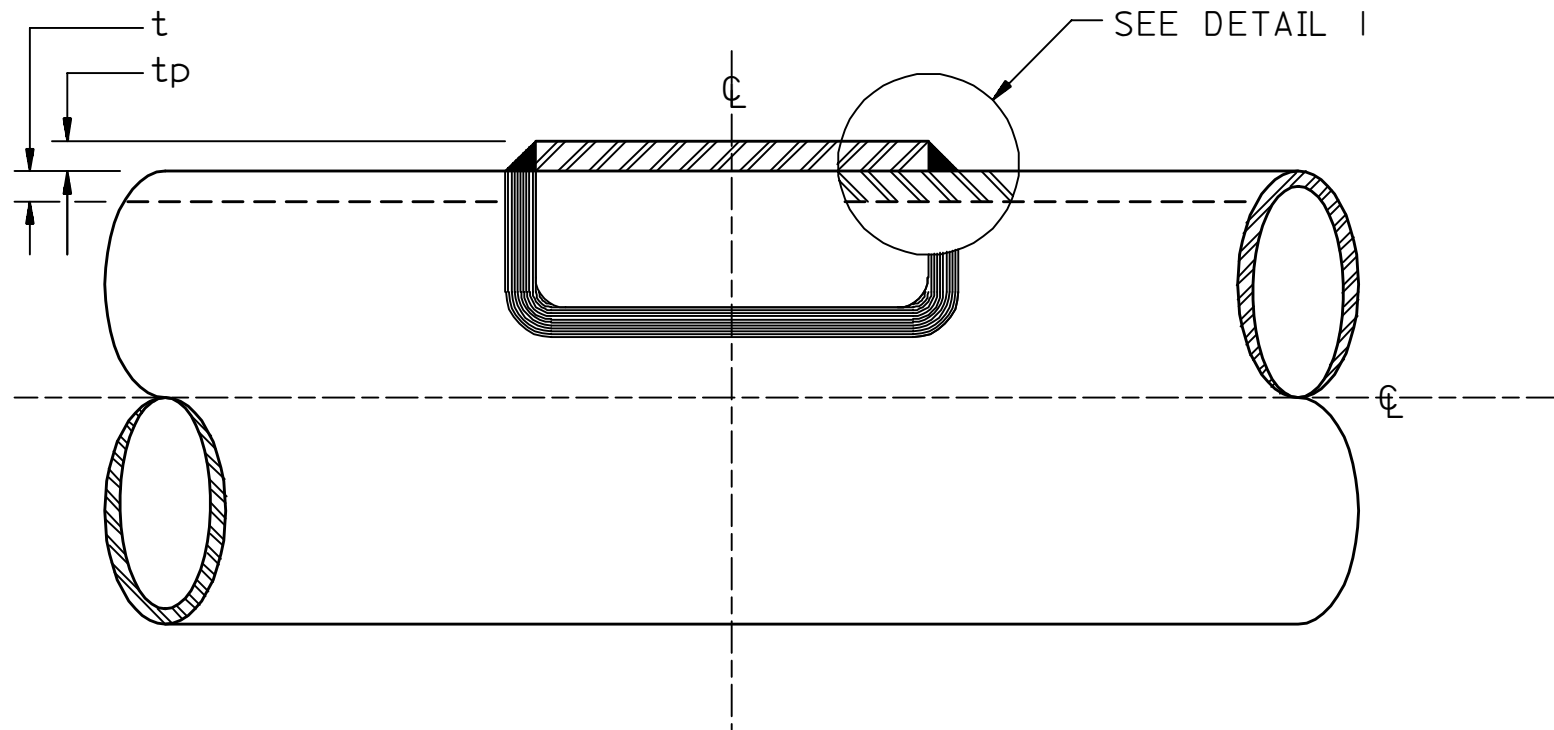


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PLANT NO.	INDEX	DRAWING NUMBER	SHT. NO.	REV. NO.



SEE FABRICATION NOTES 2 & 3
FOR PATCH DIMENSIONS

- NOTES:**
- FABRICATION NOTES**
1. THE MINIMUM MATERIAL GRADE REQUIREMENTS FOR CORROSION BARRIER PATCHES ON ANY GRADE OF PIPE SHALL BE API 5L GR. B IF MADE FROM PIPE, OR ASTM A238 GR. B OR C IF MADE FROM PLATE. HIGHER GRADES MAY ALSO BE USED.
 2. THE PATCH WALL THICKNESS SHALL BE AT LEAST 4.8mm ($3/16$ in.)
 3. THE MAXIMUM DIMENSIONS OF THE SLEEVE DEPENDS ON THE PIPELINE BASE MATERIAL AND ARE LISTED AS FOLLOWS:
 - i) FOR PIPELINE MATERIAL GRADES LESS THAN OR EQUAL TO API 5L GR. 60, THE MAXIMUM LENGTH SHALL NOT EXCEED 3m (10ft.) AND THE MAXIMUM WIDTH SHALL NOT EXCEED $1/2$ THE CIRCUMFERENCE OF THE PIPE.
 - ii) FOR PIPELINE MATERIAL GRADES HIGHER THAN API 5L GR. 60, THE MAXIMUM LENGTH OR WIDTH SHALL NOT EXCEED 150mm (6 in.)
- IN ALL CASES, THE PATCH SHALL BE FABRICATED TO FORM WITH THE CONTOUR OF THE PIPE, AND IT'S CORNERS SHALL BE ROUNDED WITH A MINIMUM 51mm (2 in.) RADIUS.
- FIELD INSTALLATION NOTES**
1. THESE PATCHES ARE ONLY TO BE USED AS EXTERNAL CORROSION BARRIERS. THESE PATCHES SHALL NOT BE USED TO REPAIR LEAKS OR MINIMUM WALL THICKNESS VIOLATIONS. REFER TO G.I. 434,ØØØ, PARA. 3.4.6.
 2. THE MAXIMUM FIT-UP GAP BETWEEN THE SLEEVE AND PIPE SURFACE SHALL NOT EXCEED 3.2mm ($1/8$ in.) GRIND FLUSH ANY LONGITUDINAL, SPIRAL, OR GIRTH WELDS ON THE PIPE WHICH INTERFERES WITH THE FIT-UP.
 3. ALL WELDING SHALL BE MADE USING LOW HYDROGEN ELECTRODES IN ACCORDANCE WITH SAUDI ARAMCO WELDING PROCEDURE SPECIFICATION (WPS) PL-R1 AND PL-R2. REFER TO G.I. 434.ØØØ FOR ADDITIONAL MANDATORY WELDING AND SAFETY REQUIREMENTS.
 4. ALL WELDS SHALL HAVE FINAL MAGNETIC PARTICLE OR LIQUID PENETRANT (M.T. OR P.T.) INSPECTION.

TYPICAL INSTALLATION DRAWING									
REV. NO.	DATE	BY	JO/EWO	DESCRIPTION			CHKD.	CERT.	APPD.
SAUDI ARABIAN OIL COMPANY									
DRAWN BY <u>ESSD/RVV</u> CHECKED BY _____ SCALE <u>NONE</u>									
DATE STARTED <u>Ø6-15-92</u> DATE COMPLETED _____									
OPR'G. DEPT. _____ ENG. DEPT. _____									
APP'D FOR CONSTR. _____									
THIS DRAWING IS NOT TO BE USED FOR CONSTRUCTION OR FOR ORDERING MATERIAL UNTIL CERTIFIED AND DATED							CERTIFIED BY _____ DATE _____		
PIPELINE CORROSION BARRIER PATCH									
STD. DWG.									
PLANT NO.	INDEX	DRAWING NUMBER			SHT. NO.	REV. NO.			
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