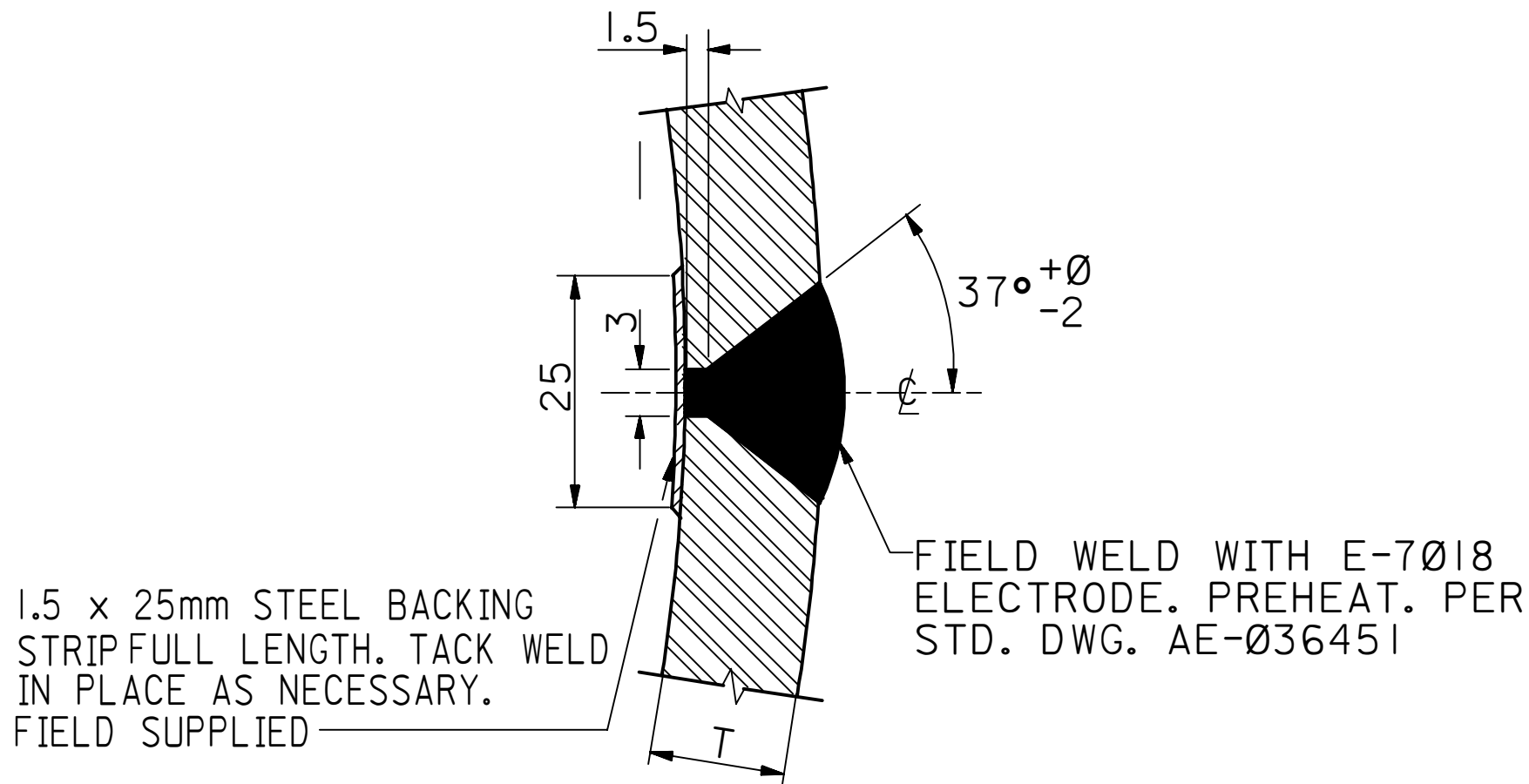


Ø4	ØØ1	AC-Ø36279	L	99Ø
REV. NO.	SHT. NO.	DRAWING NO.	INDEX	PLANT NO.



DETAIL-BUTT WELD FOR SEAM

NOTES FOR MANUFACTURE AND INSPECTION

1. TOLERANCES: ± 0
 $+1.5\text{mm}$, $A \pm 3\text{mm}$
DIAMETER-SLEEVE TO BE FORMED SO THAT THE INTERNAL DIAMETER MEASURED WITH AN I.D. TAPE WITH WELD BEVELS ABUTTING WILL NOT BE LESS THAN THE TABULATED PIPE DIAMETER MINUS 3mm MAX. I.D. TO EQUAL PIPE DIAMETER.
2. MATERIAL IS TO BE APPROPRIATE FOR THE PIPE GRADE SPECIFIED IN THE PURCHASE ORDER, USING MATERIAL SPECIFICATIONS OF MSS-SP-75 AS FOLLOWS:-
FOR GRADE B OR X42 PIPE USE CLASS WPHY-42.
FOR GRADE X52 PIPE USE CLASS WPHY-52.
FOR GRADE X60 PIPE USE CLASS WPHY-60.
3. CARBON EQUIVALENT (C.E.) BASED ON PRODUCT ANALYSIS BE DETERMINED PER MSS-SP-75.
4. MARKINGS TO BE PER MSS-SP-75 PLUS THE FOLLOWING STENCILS ON EACH HALF:-
C.E. FOLLOWED BY THE C.E. VALUE TO 2 FIGURES.

INSTALLATION NOTES

1. USE SLEEVES OF GRADE TO MATCH PIPE. T OF SLEEVE TO BE AT LEAST 1.25 TIMES PIPE THICKNESS.
2. WELDS MARKED THUS   IS THE NORMAL WELDING SEQUENCE (SEQUENCE MAY BE VARIED ACCORDING TO CIRCUMSTANCES)
3. WELDING PER (G.I.M.) GENERAL INSTRUCTION MANUAL 434.ØØ1.
4. USE LOW HYDROGEN ELECTRODES E-7Ø18, ALL CIRCUMFERENTIAL WELD PASSES TO BE UPHILL.
5. GRIND BEVELS BACK AS NECESSARY TO GET GOOD FITUP.
6. OPEN SLEEVE WITH HYDRAULIC JACK AS NECESSARY TO CLEAR BACK-UP STRIP.
7. SLEEVES SHALL BE SUPPLIED UNPAINTED.
8. ALL DIMENSIONS ARE IN MILLIMETERS UNLESS NOTED OTHERWISE.

REVISION NOTE:-
1. REDRAWN AND CONSOLIDATED SH. 1 & 2 INTO SH. 1
METRIC VERSION ONLY. ADDED TYPICAL INSTALL. DWG.

SLEEVE PIPE SIZE		DIMENSION
PIPE SIZE IN.	PIPE O.D. mm	A mm
6"	168	15Ø
8"	219	2ØØ
1Ø"	273	25Ø
12"	324	29Ø
14" & ABOVE		29Ø

TYPICAL INSTALLATION DRAWING

Ø4	Ø8-13-86	RLO	SEE REVISION NOTE-1			
REV. NO.	DATE	BY	DESCRIPTION	CHKD	CERT.	APPD.

FOR ARABIAN AMERICAN OIL COMPANY

DRAWN BY ULFAT/RASHID CHECKED BY FUB SCALE: NONE
DATE STARTED DATE COMPLETED Ø1-23-78
OPR'G. DEPT. ENG. DEPT.

THIS DRAWING IS NOT TO BE USED FOR CONSTRUCTION OR FOR ORDERING MATERIAL UNTIL CERTIFIED AND DATED
CERTIFIED DATE Ø2-2Ø-78

CORRUGATED WELD REPAIR SLEEVE
PIPE SIZE 6" THROUGH 48"

STD. DWG.			METRIC		
PLANT NO.	INDEX	DRAWING NO.	SHT. NO.	REV. NO.	
99Ø	L	AC-Ø36279	ØØ1	Ø4	

