

Supplementary instructions

Welding instructions



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Information:

The following welding instructions are for information only. In general, the relevant welding regulations must be noted. The AD leaflets must also be noted when welding on pressure vessels.

Preparations

When welding stainless steel, utmost cleanliness is necessary. E.g. it is not allowed to use rusty tools or screwed parts. Also make sure that no mild steel is processed in the closer environment.

Use enough inert gas for tack-welding. Make sure that you use tack-welding and not spot-welding. For tack-welding and welding, the protective gas pure argon must be used.

Welding dummy

The suitable welding dummy must be used to avoid the distortion of the welded socket.

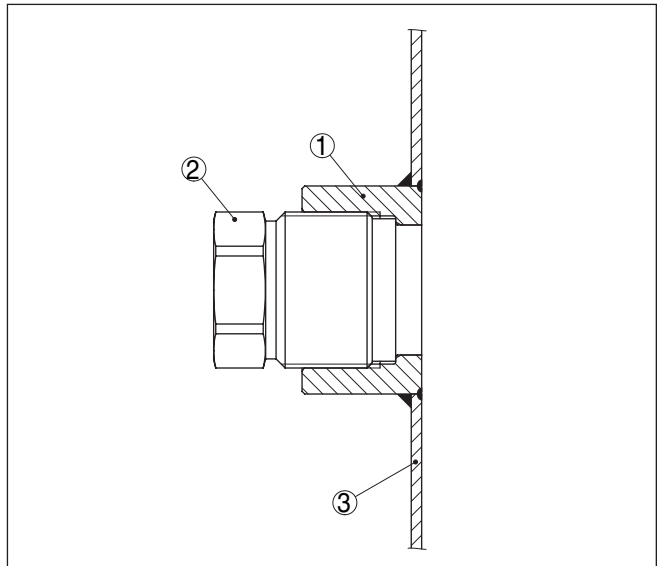


Fig. 1: Welding dummy

- 1 Welding socket
- 2 Dummy
- 3 Pipeline or vessel wall

Welding procedure

It is generally recommended to divide the weld joint into several segments.

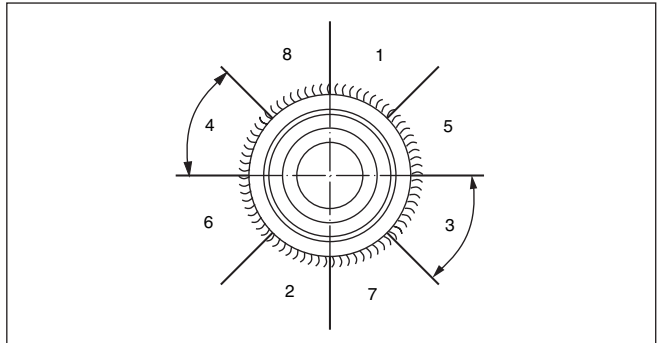


Fig. 2: Segmental welding

After welding a segment, weld immediately the segment that lies exactly opposite. Interrupt the welding process after welding two segments until the weld joint cools or carefully cool the weld joint yourself before you start welding again.

Pressure bearing

The pressure loading capacity depends on the quality of the welding as well as the material of the welded socket. With threaded sockets, the thread length must be used completely bearing.

Printing date:

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