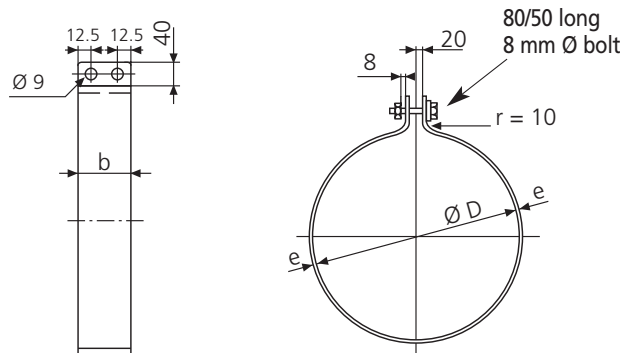


DETAILS OF COPPER GUIDE



COPPER GUIDE

The copper guide is available on request

DN	D mm	e mm	b mm
80	96	5	25
100	116	5	25
125	142	5	25
150	168	5	25
200	220	5	25
250	271	5	35
300	323	5	35
350	375	5	35
400	427	5	35
450	477	5	35
500	528	5	35
600	631	5	50
700	734	5	50
800	837	5	50
900	940	5	50
1000	1043	5	50
1100	1140	5	50
1200	1249	5	50
1400	Contact us		
1500			
1600			
1800			
2000			



SAINT-GOBAIN PAM LAYING RECOMMENDATIONS

- STORAGE
- HANDLING
- BACKFILL
- STANDARD JOINT
- STANDARD Vi JOINT
- STANDARD Ve JOINT
- UNIVERSAL Vi JOINT
- STANDARD V+i JOINT
- UNIVERSAL Ve JOINT DN 100 to 1200 MM
- EXPRESS JOINT
- EXPRESS Vi JOINT
- PIPE CUTTING
- WELD BEAD
- ANCHOR BLOCKS
- ANCHORING
- EXTERNAL COATING REPAIRS
- INTERNAL LINING REPAIRS
- PE SLEEVE INSTALLATION
- HYDRAULIC TESTING
- ASSEMBLY EQUIPMENT
- HORIZONTAL DIRECTIONAL DRILLING
- CONTACTS

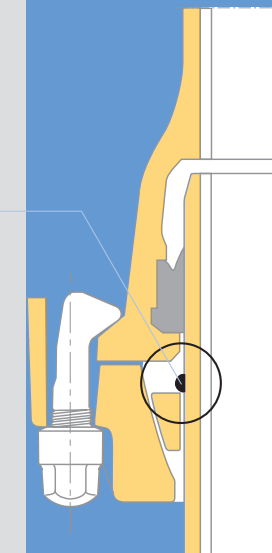


MARKETING DEPARTMENT
21 AVENUE CAMILLE CAVALLIER
54705 PONT A MOUSSON CEDEX
FRANCE
TEL: 03.83.80.73.50
www.pamline.fr

AEP-MEM-15A VERSION 2007 - 4000 EX

PAM LAYING RECOMMENDATIONS

Weld bead

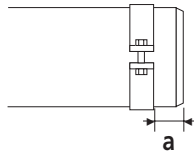


REQUIRED MATERIAL

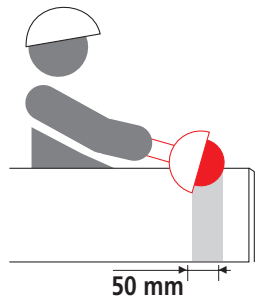
- Min 150 amperes capacity electric welding machine.
- Electric grinder.
- Copper guide, complying with the plan below.
- Recommended electrodes :
 - GRICAST 31
 - 3.2 Ø from Messer Griesheim
 - UTP 86 FN/5 3.2 Ø from Doga
 - XUPER 2230 3.2 Ø from Castolin.

SURFACE PREPARATION

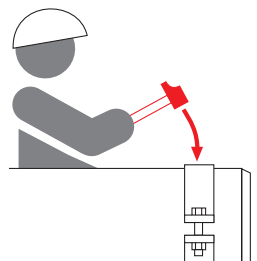
Draw the bead position with the copper guide complying with dimension a.



Scrape the face to be welded lightly grinding it over a strip of about 50 mm.

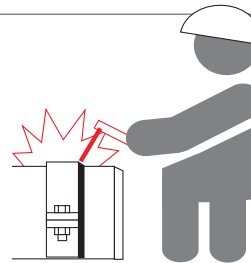


Position and clamp the copper guide upstream of the weld complying with dimension a. The whole pipe periphery should be **clad**. If necessary hammer it.

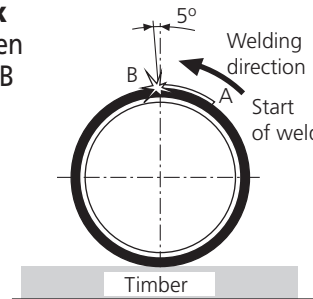


MAKING THE WELD BEAD

Weld against the guide to obtain a straight facet at right angles to the face of the pipe.

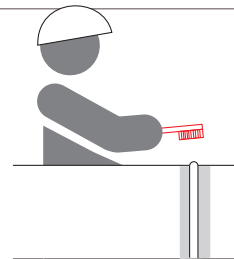


Preferably work the weld between the marks A and B turning the pipe.

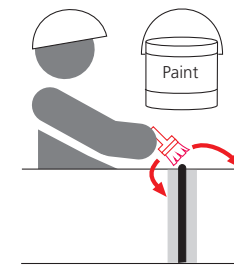


REPAIRING EXTERNAL COATINGS

Brush and clean off the welded area.

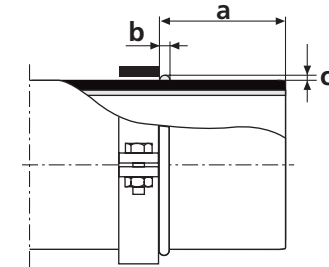


Apply epoxy paint with a brush complying with the proportioning of the constituents.



Paint reference*:
ENDOKOTE 4820

(*) Available on request.



BEAD DIMENSIONS according to the type of joint

DN	Standard locked a +/- 3 mm	Locked Triduct a +/- 3 mm	b +/- 1 mm	c +/- 1 mm	No. of passes
80	85	85	7	3	1
100	90	90	7	3	1
125	95	95	7	3	1
150	95	95	7	3	1
200	100	100	7	3	1
250	110	110	7	3	1
300	115	115	7	3	1
350	114	114	7	3,5	1
400	113	113	8	3,5	1
450	120	120	8	3,5	1
500	125	125	8	4	1
600	135	135	8	4	1
700	158	158	8	4	1
800	150	165	8	4	1
900	155	180	9	4	1
1000	165	200	9	4	1
1100	165		9	4	1
1200	170		9	6+0/-1	1
1400					
1500					
1600					
1800					
2000					

Contact us