

## SALES AND RENTAL OF HEAT TREATMENT EQUIPMENT

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### PRE-HEAT, STRESS AND POST-WELD APPLICATIONS - OFF SHORE

**Customer:** Stolt Offshore, Aberdeen.  
LB200 Pipe Lay Barge

**Client:** Dales Fabrications  
Peterhead  
Scotland

**Job Description:** Preheat and post weld heat treatment of deck plates and LB200 jacking rails for main stinger pipe laying unit.

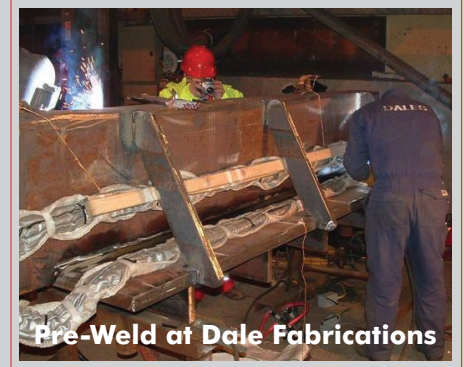
**Material**  
Deck Plate - 50mm ST52-3N  
Section of Rails - 150mm wide SQ690 QL

**Job Location:** Bergen  
Norway

**Job Date:** 06.01.06 to 29.01.06

**Equipment:** 5 x 20kw RHS Induction Heating Machines  
5 x 80ft Induction Heating Cables

**Results:** We set up first four systems to preheat the jacking rails to 170°C so that butting layers could be welded with flux cored wire prior to new segments being welded in place.



Pre-Weld at Dale Fabrications



Actual Stinger Rail  
before removal



Stinger Rail after removal  
Pre-heat base 170 °C



Stinger Arm



LB 2006 Refit