

# SALES AND RENTAL OF HEAT TREATMENT EQUIPMENT

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## HOT TAP - SOUR GAS LINE APPLICATION

**Customer:** The Murphy Group (Warrington)

**Client:** B.H.P

**Job Description:** To pre-heat a 20" pipe and a 4" weldoflange that is to be welded to the topside of the horizontal pipe.

Pipe Dimensions:	20" x 25mm w/thk
Flange Dimensions:	4" x 27mm w/thk
Pre-heat Target Temp:	250°C
Product:	Sour Gas
Flow Rate:	No Flow
Pressure:	45 bar
Product Temp:	6°C

**Job Location:** B.H.P  
Point of Ary  
North Wales

**Job Date:** 12.06.04 to 13.06.04

**Equipment:** 2 x 20kw RHS Induction Heating Machines  
2 x 80ft Induction Heating Cables  
2 x 50ft Induction Heating Extension Cables

**Results:** We reached target temperature at the weld face on the flange within 30 minutes and then started to heat the pipe, which took approximately 30 minutes to reach target temperature. At this point the weldoflange temperature was still within welding procedure parameters. Welding took approximately 3 hours. (See pictures 1, 2 & 3)

