

## SALES AND RENTAL OF HEAT TREATMENT EQUIPMENT

Dragon Works, Chester Road, Saltney, Chester CH4 8RW

Tel: +44 (0) 1244 670810 Fax: +44 (0) 1244 680491

E-mail: sales@rapidheatsystems.com Website: www.rapidheatsystems.com



### HOT TAP SPLIT TEE 24" MAIN GAS LINE

**Customer:**

**GAZ DE FRANCE**

**Job Description:**

To pre-heat a 24" split tee and the 24" pipe that it sits on (Simultaneously) requiring two circumferential welds.

Pipe Dimensions:	600mm x 8mm w/thk
Target Temperature:	100°C min
Product:	Natural gas
Flow Rate:	5.6m/s
Pressure:	Not given
Product Temp:	Not given

**Job Location:**

Courthezon, Orange, France

**Job Date:**

11.06.08 to 12.06.08

**Equipment:**

2 x 35kw RHS Induction Heating Machines  
2 x 80ft Induction Heating Cables  
2 x 50ft Induction Heating Extension Cables  
1 x Rapid Heat 75 Booster  
2 x Rapid Heat 75 Booster Wands  
(for 600mm o/d pipe)

**Results:**

We set up a three coil configuration on each side of the weld area using the two 35kw machines and set target temperatures of 150°C, this was to create a "damming" effect and to minimise heat loss through the cold pipe during "booster" heating.

We then applied 25 seconds of heating with the two boosters wands (simultaneously) from both sides of the pipe, this gave us 1.2 minutes worth of welding time (enough time to weld a full welding rod) after the first welding run was complete, Booster heating application time was reduced and welding time was increased, and this was due to the joining of the split tee to the pipe and the transfer of heat from the 35kw machines through the weld joint.

The job was a complete success and completed in the allocated time.

This was the first time that the process of using the above equipment has been carried out on a "Live Line" and Rapid Heat Systems have now applied for patent on this process.

UK Pat App 0817312.2

