

SALES AND RENTAL OF HEAT TREATMENT EQUIPMENT

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PRE HEAT, NEW TRANSMISSION LINE APPLICATIONS

Customer: NACAP

Client: Gasunie

Job Description: To pre-heat 48", 17 to 21mm wall, gas pipeline on a moving production line at nine different location. At the three front end locations the pre-heat temperature was 150°C minimum and at the six other locations 100°C minimum was required. The pipeline was fabricated in 500m strings and floated out onto the water of the IJsselmeer for further connection. In total 28km of pipeline was laid consisting of in excess of 2300 welds.

Job Location: Side of IJsselmeer
Nr. Wingerwerth
North West Holland

Job Date: 14.05.06 to 31.10.06

Equipment: 7 x 35kw RHS Induction Heating Machines
14 x 30ft Induction Heating Cables
14 x 50ft Induction Heating Extension Cables

Results: At the front end we set up a 2-coil configuration of 2 x 30ft hose at 150°C covering either side of weld. Temperature was achieved in 4 1/2 minutes. At the other locations we set up a 2-coil configuration of 2 x 30ft hose at 100°C covering either side of weld. Temperature was achieved in 4 minutes.

