

## SALES AND RENTAL OF HEAT TREATMENT EQUIPMENT

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### SLUG CATCHER FABRICATION

**Customer:** SICIM (Italy)

**Job Description:** To pre-heat and stress 118 welds, consisting of 6x42", 96x24" and 16x12"

Pipe Dimensions:	42", 24" and 12"
Target Temperature:	100°C min
Interpass Temperature:	170°C
Soak Temperature:	610°C ± 10°C
Pressure:	N/A
Product Temp:	N/A

**Job Location:** Shell Corrib Gas Terminal (Ireland)

**Job Date:** Aug 2008 to Feb 2009

**Equipment:**

- 4 x 35kw RHS Induction Heating Machines
- 4 x 80ft Induction Heating Cables
- 4 x 50ft Induction Heating Extension Cables
- 4 x 140ft induction Heating Cables

**Pre-heat Results:** We set up a three-coil configuration on each side of the weld using either a 140ft or 80ft-heating cable depending on pipe diameter size, and set a target temperature of 120°C, temperature was reached in 12 minutes.

**Stress Results:** We set up a four-coil configuration over the weld area to be stressed, and set a soak temperature of 610°C, stress cycle takes seven hours.

