SALES AND RENTAL OF HEAT TREATMENT EQUIPMENT

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.