SALES AND RENTAL OF HEAT TREATMENT EQUIPMENT

Laing O’Rourke (St. Neots, Cambridgeshire)

To pre-heat a 36” pipe.

Original Pipe Dimensions: 36” x 16mm w/thk
New Pipe Dimensions: 36” x 19mm w/thk
Pre-heat Target Temp: 120°C
Product: N/A
Flow Rate: N/A
Pressure: N/A
Product Temp: N/A

West Bliney
Kings Lynn
Norfolk

21.08.05 to 24.08.05

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

We set up a 3-coil configuration each side of the weld joint and set a target temperature of 120°C. The target temperature was reached within 12 minutes and after allowing a further 10 minutes for soak time the joint was ready for welding. Welding was completed within approximately 2½ hours.

Customer: Laing O’Rourke
Job Description: To pre-heat a 36” pipe.
Job Location: West Bliney
Job Date: 21.08.05 to 24.08.05
Equipment: 2 x 20kw RHS Induction Heating Machines
Results: We set up a 3-coil configuration each side of the weld joint and set a target temperature of 120°C. The target temperature was reached within 12 minutes and after allowing a further 10 minutes for soak time the joint was ready for welding. Welding was completed within approximately 2½ hours.

Pictures show existing gas main cut and ready for new diversion pipe.