Pre-Heat and post weld heat treatment of deck plates and LB200 jacking rails for main stinger pipe laying unit.

**Material**
- Deck Plate - 50mm ST52-3N
- Section of Rails - 150mm wide SQ690 QL

**Job Date:** 06.01.06 to 29.01.06

**Equipment:**
- 5 x 20kw RHS Induction Heating Machines
- 5 x 80ft Induction Heating Cables

**Results:**
We set up first four systems to preheat the jacking rails to 170°C so that butting layers could be welded with flux cored wire prior to new segments being welded in place.