

1 Please note

The following points are for your information only. The relevant regulations and instructions regarding the welding of sockets and adapters can be found in the AD2000 instruction manual for the welding of pressure vessels and pipes.

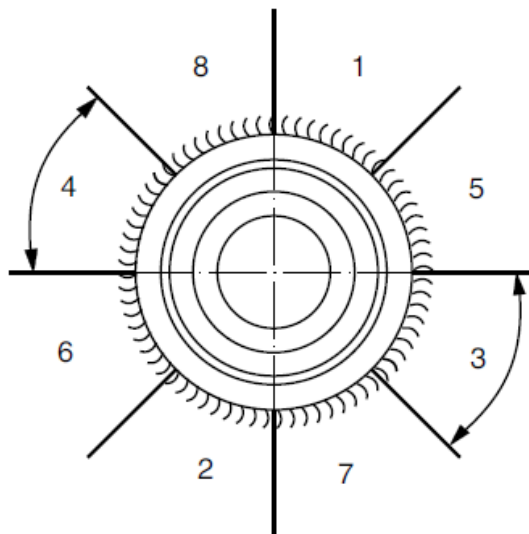
2 Preparation

It is essential to ensure a clean environment when welding stainless steel. No rusty tools should be used.

It is important to ensure that purging gas is used during spot welding in order to avoid contamination of the tank or the pipe. It should first be tack-welded only and not fully welded. Pure argon gas should be used for shielding during welding.

3 Welding process

The welding process should be divided into several steps. It is necessary to weld the second segment opposite of the first one. Then it is necessary to interrupt the welding process until the welded seams have cooled down; welding can be continued thereafter with the next segments (see sketch).



4 Pressure resistance

The pressure resistance of the adapter or socket depends mainly on its material and the quality of the weld. For threaded adapters, the complete length of the thread has to be used in order to ensure maximum pressure resistance.

5 Welding aids

A suitable welding aid is optionally available.

The welding aid absorbs and distributes the temperature during the welding process reducing the welding distortion. It can be removed easily after the welding process.

The welding aid is screwed into the welding adapter hand-tight before tack-welding/welding and unscrewed again after the adapter has cooled down.

| for MT8100-A1 (G1/2A) Drawing: F1-AC-01087-k | for MT8110-A5 (M12x1,5) Drawing: F1-AC-01088-k | for MC1510-K4010-E1 (G1A) Drawing: F1-AC-01089-k |
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