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	INSTALLATION INSTRUCTIONS	Rev. 0 Data: 02-05-2016	Pagina 1 di 9

Rev. N°	Data	Modifica	Autore	Approvata da:
0	02-05-2016	Primo rilascio della procedura	Responsabile Sistema Qualità (Bonanomi Marco)	Responsabile Commerciale (Marco Pozzoli)

1. Purpose

To define the instruction for installation of Meccanica Segrino isolating joints manufactured at the Meccanica Segrino facilities in Italy.

2. Scope

All the isolating joints of type ANSI150 and ANSI300/600

3. Instructions

- DO NOT lift the isolating joint by the ends. Support the product with strapping on both sides of the hub while lifting and moving the isolating joint.
- MAKE SURE the working pressure of the joint is compliant to the working pressure of the pipeline.
- MAKE SURE the pipelines to connect to the insulating joint are axial to each other.
- If the joint has to be installed to an aerial pipeline, the supporting points will have to be as close as possible to the joint itself.
- Oxyacetylene welding procedure is not suitable for welding the joints to the pipeline. If this procedure can't be avoided, especially for joints whose diameter is less than 8"(200 mm), keep the central body cool with wet clothes. The temperature in this point must not exceed 70°C.
- During the electric welding the contact cable must be connected to the side which is being welded.
- Each joint is coated with a non-conducting epoxy paint. This coating should remain on the product to insure the insulating capability of the joint.
- The Insulating Joint is factory tested for electrical resistance prior to shipment.
- If the original coating is removed or if an additional coating is to be applied, it is the responsibility of the user to assure that the joint remains non-conducting.

- The isolation Joints are designed for direct welding to the pipeline by qualified welders using qualified procedure, taking care to avoid overheating. In order to avoid **OVERHEATING**, follow the instructions listed below:
 - ✓ DO NOT preheat the body for any reason.
 - ✓ During the welding of joint pups to the pipeline, DO NOT allow the temperature of the body to exceed 70°C.
 - ✓ In case stress relieving of the welding is required DO NOT allow the temperature of the body to exceed 70°C.
 - ✓ Generally, according to field welding procedures, the external temperature of the body doesn't have to reach 70°C.


To avoid or to remove overheating problems, apply the following countermeasures:


- Use thermal crayon or adequate thermocouple to verify the temperatures on the body or near to the stub.
- If the temperature approaches 70°C, cool the body using damp rags or forced air.
- Stop welding or stress relieving until temperature is below 70°C.

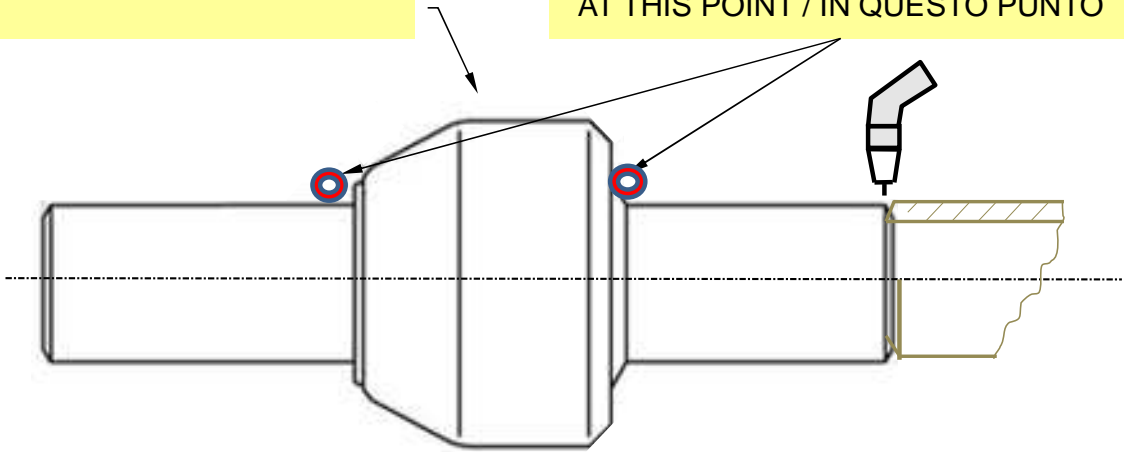
IMPORTANT NOTES

- *Isolating Joints are completely assembled and sealed at the factory and should not be disassembled for installation. DO NOT attempt to disassemble the joint at any time, since this will destroy its electrical integrity and may impair its mechanical strength.*
- *The isolation joint with its body is an isolator, so the welding earth connection must be located on the joint pup, same side of pipeline, otherwise the welding current will be severely impaired;*
- *The temperature of the joint must be kept under 70°C in order to protect the seal gaskets, the isolating rings, the epoxy cured resin and the epoxy coating;*
- *During installation of insulation joint, the operator must be provided with safety devices according to PED requirements (as per design pressure and temperature written on the nameplate).*

ENGLISH

 DO NOT PRE-HEAT THIS CENTRAL BODY

 CEASE WELDING WHEN TEMPERATURE REACHES **70°C MAX**
AT THIS POINT / IN QUESTO PUNTO



ENGLISH

