

Welding procedure specification of R.J.Pipe

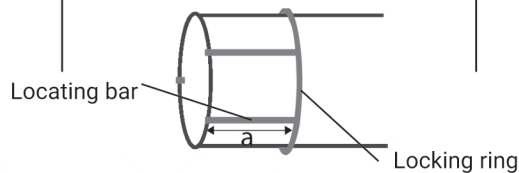
Welding Instruction

If R.J.Pipe is cut out during installation or customer purchases the pipes without welding ring from producer, it is possible to use below instruction for the purpose of welding the locking ring around R.J.Pipe's spigot.



Welding process	Shielded metal arc Welding (SMAW)		
Type of Joint	Single weld		
Technical specification of base metal	Type of cast iron	Standard	Thickness
	SG cast iron	EN-GJS400-15	5 to 12 mm
Technical specification of filler metal	Type of Electrode	ANSI/AWS-A5.15	Electrode diameter
	ENiFe-CI		3.25 mm
Electrical specification	Transfer mode	Current polarity	
	Short circuit	DCEP current and electrode is connected to the positive pole and use minimum amperage	
Welding method	75 to 100 Amps	22 to 24 Volt	Welding speed: 3-6 m/s
Welding Position	Horizontal		

Joint Scheme



Dimensions specifications of locking rings and its installation place

Weathering steel or DIN 16MnCr5 (EN1.7131) Locking rings should be placed in a certain distance of spigot end.

DN	80	100	125	150	200	250	300	350	400	450	500	600	700	800
Locking ring (diameter)	13	13	13	14	14	14	14	14	14	14	16	16	16	16
Locking ring (Length)	340	400	480	565	730	895	1055	1220	1380	1540	1705	2030	2350	2694
a	97	101	104	108	114	119	123	124	124	134	136	136	165	170
Tolerance	±1						±2							

Locating bar measurements

DN	80	100	125	150	200	250	300	350	400	450	500	600	700	800
X(± 1)	90.5	94.5	97.5	101	107	112	116	117	117	127	129	129	158	162
Ø(+0.5)	13		14						16					

