

STERIVALVE®
12, 25, 38, 51 & 76
1/2", 1", 1 1/2", 2" & 3"

Welding Guide

**Welding of Valve Housing for
Bottom Outlet Valve**



This welding guide should be read carefully
before unpacking the Sterivalve®

Order No. _____

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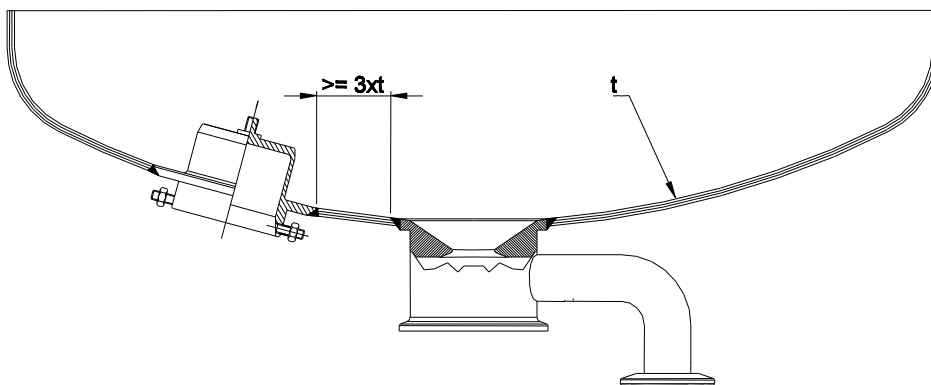
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1. Welding Procedure

1.1 Placement of the valve housing

The valve housing is usually placed according to the figure below, but other locations may exist. Therefore you should always check the relevant vessel drawings. Position the outlet of the valve housing according to the relevant drawing.

The distance from the valve housing weld seam to any other weld seam should be a minimum of three times for the thickness of the material of the dished end, $3 \times t$, according to the 1987 Swedish standards for pressure vessels, TKN 87.



Welding (TIG)

- A hole for the valve housing is cut in the dished end.
- Grind the edge of the hole to prepare a suitable weld gap.
- Position the valve housing in the hole in the dished end. Make sure that the valve housing outlet is correctly oriented.

Valve size	Diameter of weld flange (hole)
Sterivalve® 12	ø 48 mm
Sterivalve® 25	ø 79 mm
Sterivalve® 38	ø 84 mm
Sterivalve® 51	ø115 mm
Sterivalve® 76	ø148 mm

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- The valve housing is tack welded with a TIG-welder from the outside. The correct filler depends on the material in the dished end and valve housing. For a dished end and valve housing of 316L filler Avesta 316L (SKR), 316L-Si/SKR-Si or similar type may be used.
- Seal off between the bench and the dished end with the aid of tape etc. Fill the dished end with an inert protective gas.
- Starting from the outside, weld the valve housing to the lower dished end in one operation. Make sure that the weld is well burned-through and that it is free from pores and cracks. Use as low heat as possible (low current). High heat can deform the valve.
- Continue welding until the weld opening is completely filled.
- Turn over the dished end and weld from the inside in order to smooth out the weld seam. If it is considered necessary some filler material may be used.

2. After Welding

On completion of welding, the dished end and the bottom outlet valve house are allowed to cool slowly. No cooling medium other than air may be used. The inside and outside of the weld is ground and polished to the required finish.

Sterivalve® is a registered trademark.
Sterivalve® is patented and design protected.

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