WELDING INFO

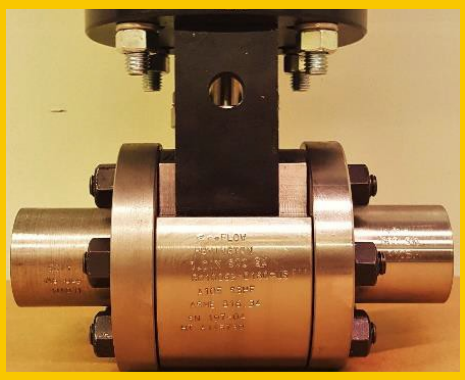
REMINGTON VALVE

Severe Service Ball Valves













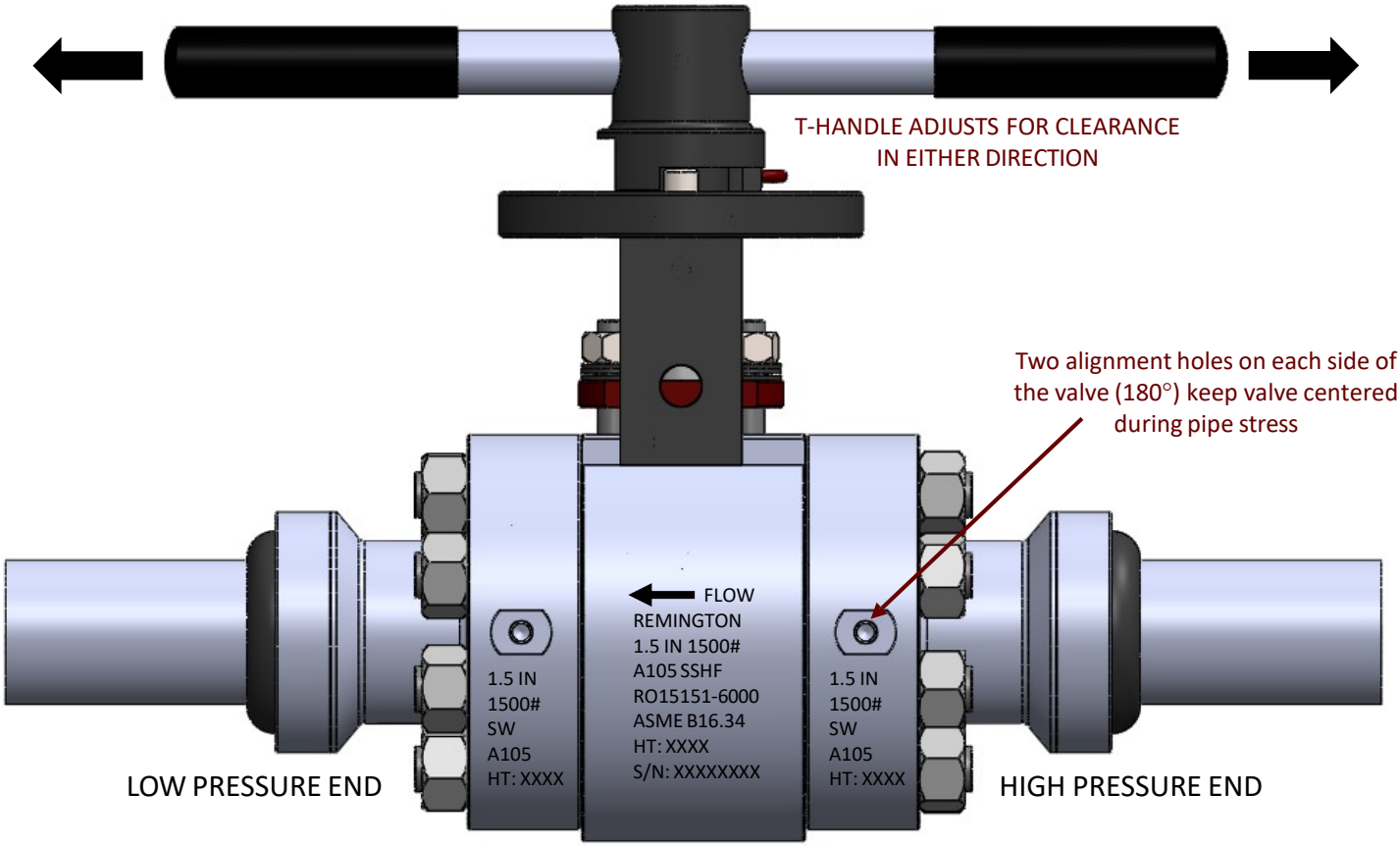
WELDING INFORMATION

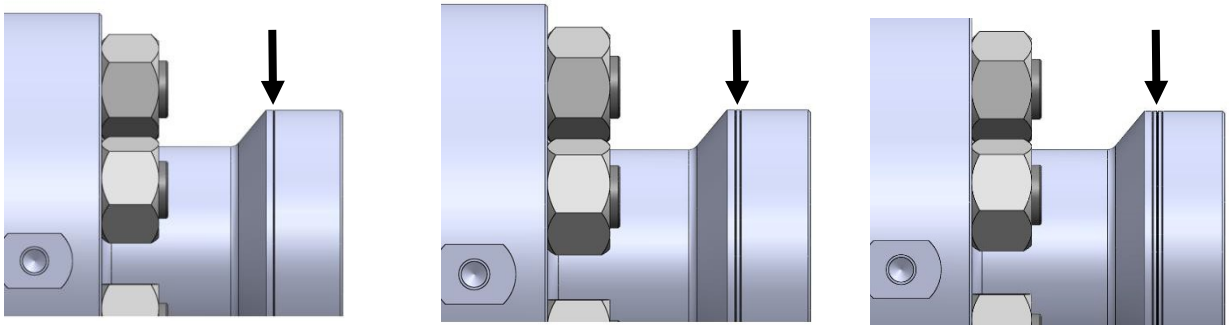
Installation, Operation, and Maintenance Manual

CRITICAL SERVICE
FIELD PROVEN
ENGINEERED
SUPPORT
SERVICE

Manufactured in Houston, Texas

Simplifying the way you buy valves





1 GROOVE: A105 | 2 GROOVES: F22 | 3 GROOVES: F91

POST WELD HEAT TREAT GUIDE LINE PER B31.1

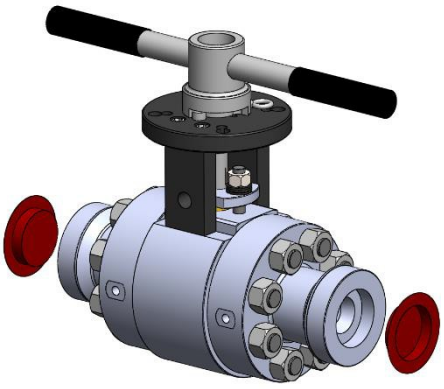
NOTE: Make sure the arrow points towards lowest pressure side.

ALL REMINGTON VALVES ARE TESTED AT THE FACTORY PRIOR TO SHIPMENT TO B16.34 REQUIRMENTS

- HYDROSTATIC SHELL TEST AT 1.5 TIMES THE 100°F RATED WORKING PRESSURE
- HIGH PRESSURE LIQUID SEAT CLOSURE TEST AT 1.1 TIMES THE 100°F RATED WORKING PRESSURE
- FCI 70-2 CLASS VI LOW PRESSURE GAS SEAT TEST

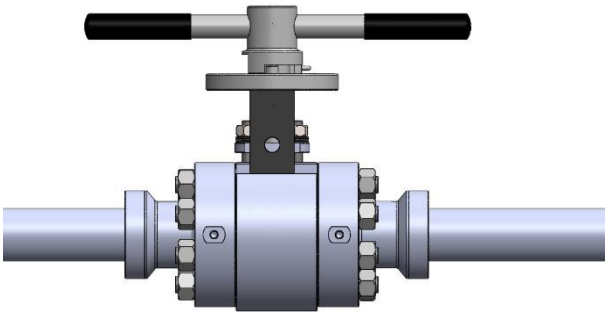
(REMINGTON VACUUM TEST BALL AND SEAT TO VERIFY CLASS VI SEAL PRIOR TO INSTALLATION)

WELDING VALVE IN-LINE



- Remove protective covers from the ends.

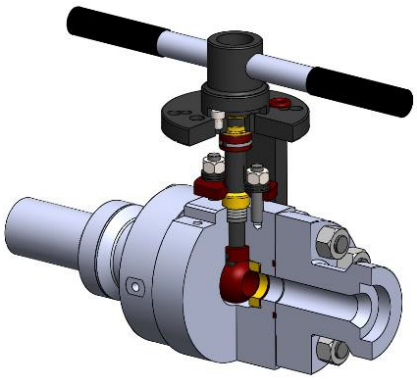
POSITION VALVE IN-LINE



- Position valve in-line, Butt Weld Valves should be in the **OPEN** position .

NOTE:

THE FLOW ARROW INDICATES PREFERRED FLOW DIRECTION.



- Verify the valve is in the **OPEN** position.

WARNING: USE THE FOLLOWING PRECAUTION

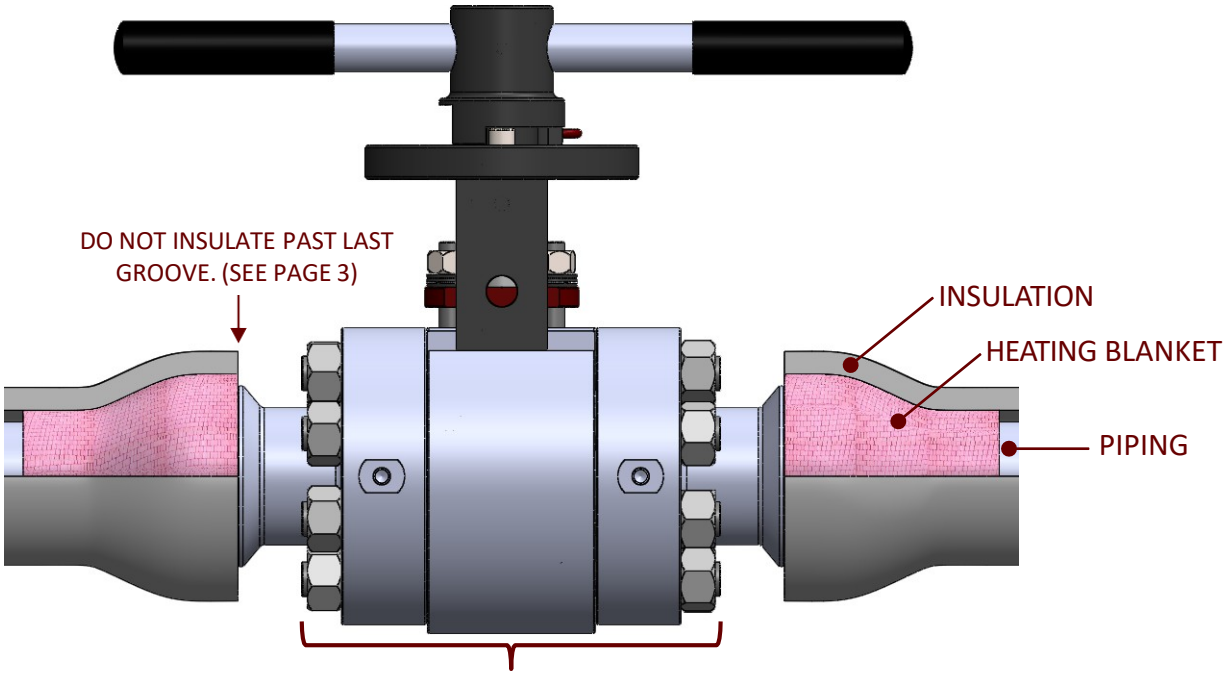
Before welding Butt Weld valves, the valve must be in the **OPEN** position to protect the ball from weld splatter or surface damage to the coating.

NOTE: Always attach welding ground strap to the same end being welded. Strapping across the valve may cause arcing and damage the coated surfaces.

CAUTION:

Valves should never be used as part of a load bearing structure.

CAUTION!
DO NOT POST WELD HEAT TREAT BOTH SIDES OF THE VALVE AT THE SAME TIME. DOING SO MAY DAMAGE THE VALVE AND VOID THE WARRANTY.

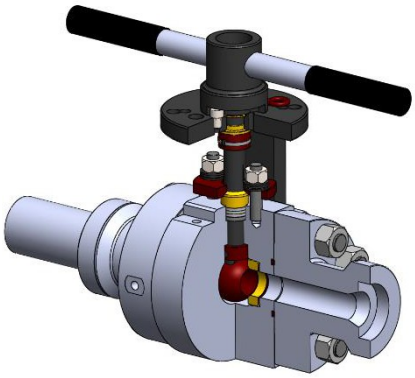


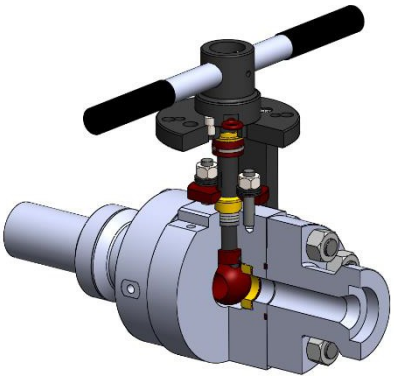
WARNING: USE THE FOLLOWING PRECAUTIONS!
- HEATING BLANKETS AND ISULATION SHOULD ONLY COVER THE WELD AREA.
- INSTALL HEATING BLANKETS WITH NO GAPS OR OVERLAPS.
- BLANKETS SHOULD NOT COVER ANY PART OF THE CENTER SECTION.

GUIDELINE ONLY

PWHT Requirements per ASME B31.1					Holding Time based on Nominal Thickness	
Material	Part Number ASME Sec. IX	Group Number	Preheat °F(°C)	Holding Temp. Range, °F(°C)	Up to 2in. (50mm)	Over 2in. (50mm)
A105[a]	1	2	200(95)	1,100-1200 (600-650)	1 hour / inch (25mm) 15 minutes minimum	2 hours plus 15 minutes for each additional inch over 2 inches (50mm)
A182-F22 Cl. 3	5A	1	300(150)	1,300-1,400 (700-760)		
A182-F91	15e	1	400(205)	1,350-1425 (730-775)		

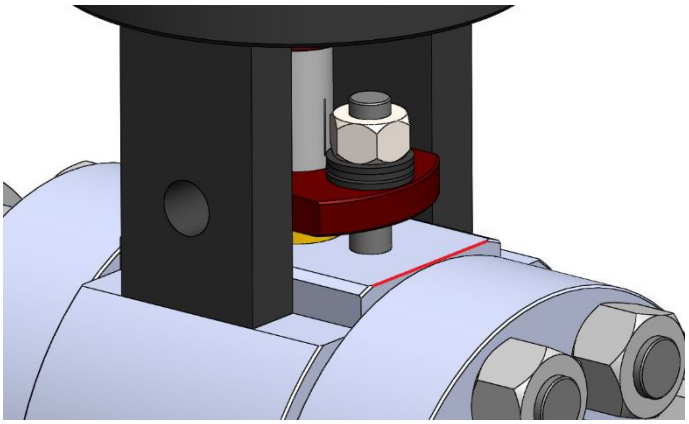
VERIFY OPERATION AFTER WELDING





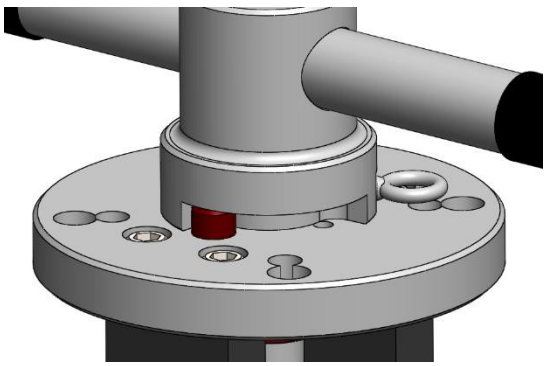
- After installation, **OPEN** and **CLOSE** the valve to ensure smooth operation.

INSULATION HEIGHT

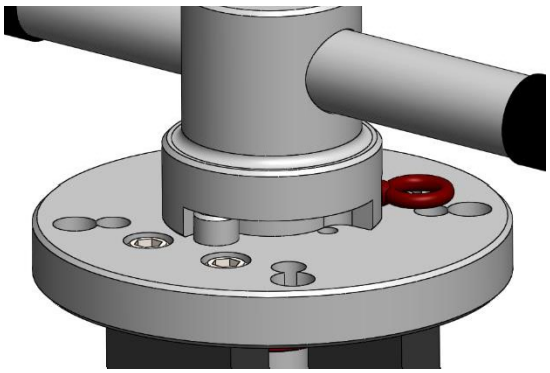


- Do **NOT, if possible,** apply insulation above the body flat. (Red Line)

OPERATION & MAINTENANCE



- Precision mechanical stop to locate the **OPEN/CLOSED** positions.



- Lockout devices can be used to provide secure **OPEN/CLOSED** positions.

Custom designs for the toughest applications






Simplifying the way you buy valves

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