- 1. EXTERNAL ENDFITTING MATERIAL: ALLOY STEEL FORGING, MTL-5245. COATED WITH MTL-6015, 350 microns, WHITE COLOR, IN ACCORDANCE TO NORSOK M-501, SYSTEM 7B & 7C AS PER QAC-1132.
- 2. ENDFITTING FASTENER MATERIAL: MTL-6040, ELECTRODEPOSITED CADMIUM WITH CHROMATE (ASSEMBLED WITH LOCTITE 577). TORQUE VALUE:

PLACEMENT	FASTENER	TORQUE VALUE		
		ROCOL (COF 0.09)	EASY RUN (COF 0.08)	
BODY TO JACKET	3/4"-16 UNF	231 +5/-0 ft-lbs [313 +7/-0 N.m]	222 +5/-0 ft-lbs [301 +7/-0 N m]	
OUTER COLLAR TO JACKET			222 137 0 H-103 [301 777 -0 N.HI]	

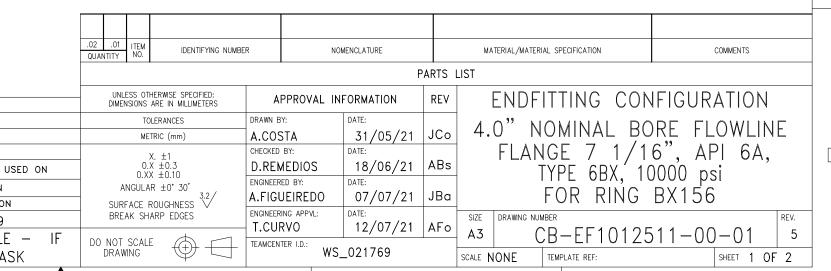
3. FLANGE BOLTS FOR HYDRATIGHT HL TENSIONER:

 $\emptyset$ 1 1/2"-8 UN x 15 1/2", STUD BOLTS (MTL-6040), ELECTRODEPOSITED CADMIUM WITH CHROMATE (12 PER FLANGE). ø1 1/2"-8 UN, HEX NUTS (MTL-6040), ELECTRODEPOSITED CADMIUM WITH CHROMATE (24 PER FLANGE). TORQUE (TO BE CONSIDERED DRY): 3038 Nm (2241 ft/lbs); PRELOAD: 467 kN (104951 lbs) BOLTS NOT SHOWN FOR CLARITY.

- 4. MASS: 950 Kg (APPROX.).
- 5. NOMINAL DIMENSIONS GIVEN; DIMENSIONS APPLY PRIOR TO COATING.
- 6. MANUFACTURING ASSY DRW: B-EF1012511-00-01
- $\langle$  7 angle stencil with red color and low stress stamp marking identification in APPROXIMATE LOCATION SHOWN IN ACCORDANCE WITH WS-MFG-4236. ASSEMBLY DRAWING: B-EF1012511-00-01 BODY DRAWING: B-EF1012511-01-01 JACKET DRAWING: B-EF1012511-08-01 OUTER COLLAR DRAWING: B-EF1012511-09-01 INTERMEDIATE OUTER COLLAR DRAWING: B-EF1012511-24-01
- $\langle$  8 angle SEAL AND INTERNAL SURFACES: 625 INCONEL, 3.00 MINIMUM THICKNESS PER MTL-5143.
- $\langle$  9 angleHARDNESS TESTING PERFORMED ON INCONEL 625 OVERLAY REGION OF FLANGE FACE AT 3 EQUI-DISTANT WITHIN 6.0mm BANDED REGION OUTSIDE OF BX156 SEALING REGION. REFER TO DOCUMENTATION INCLUDED IN FLEXIBLE PIPE MANUFACTURING DATA DOSSIER FOR ACTUAL RESULTS WHERE THE MINIMUM HARDNESS SHALL BE 220 HBN.
- (10) IDENTIFICATION PLATE DRAWING: B-OAXXXXXXX-00-03
- (11) MAXIMUM ALLOWABLE LOAD TO SUPPORT THE ENDFITTING: 330H CONSIDERING THE INTERNAL DIAMETER OF THE PLSV INSERT WITHIN THE RANGE OF: 397mm - 405mm.

REVISIONS				
REV	DESCRIPTION		DATE	
1	ORIGINAL ISSUE	TCo	12/07/21	
2	NOTE 14 WAS ADDED, SEE ECR WS00062238.	TCo	16/12/21	
3	UPDATED NOTE 13, SEE ECR WS00064923.	TCo	22/02/22	
4	INSERTED NOTE 15, SEE ECR WS00066517.	TCo	21/03/22	
5	UPDATED NOTES 14 AND 15, ADDED DIMENSION, SEE ECR WS00083432	AFo	04/01/23	

- $\sqrt{5} \backslash (12)$  N2 TEST PORT 3/8"-18NPT MUST BE ASSEMBLED IN ORDER TO FACE THE ADJACENT SURFACE OF THE HOLE. NO THREAD OF THE HOLE SHOULD BE EXPOSED. A SPECIFIC TORQUE VALUE IS NOT REQUIRED, ONLY THE APPLICATION OF THE THREAD SEALANT.
  - VENT PORTS: 1"-12UNF, VENT VALVE MODEL: DUKRON DR UZC-G604IV2. TORQUE WITH TEFGEL (COF.0.1): 44 + 2.5/-0 ft-lbs  $\begin{bmatrix} 60 + 5/-0 & N.m \end{bmatrix}$
- $\sqrt{5}$  $\langle$ 14 $\rangle$  BOLT HOLE FOR ANODE CABLE. SETSCREW M12 MUST BE ASSEMBLED IN ORDER TO FACE THE ADJACENT SURFACE OF THE HOLE. NO THREAD OF THE HOLE SHOULD BE EXPOSED. A SPECIFIC TORQUE VALUE IS NOT REQUIRED. ONLY THE APPLICATION OF THE THREAD SEALANT.



**Baker Hughes** 

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WSI.1012511-RD-4042-X

**NEXT ASSEMBLY** 

- DO NOT SCALE -

APPLICATION

DOCUMENTATION

QAC-1209

IN DOUBT ASK

6

DESIGN ID: WS\_021769/05

