

Benennung / Designation	Werkstoff Material	Sach-Nr. / Part No.						
		U 32/25	U 50/40	U-S 50/40	U 80/65	U 100/125	U 125	U 162
Gehäuseanschluß U housing connection U	1.4404 / 3.1B 1.4435 / 3.1B	221-149.01 —	221-149.02 —	— 221-149.18	221-149.03 —	221-149.04 —	221-149.10 —	221-149.06 —

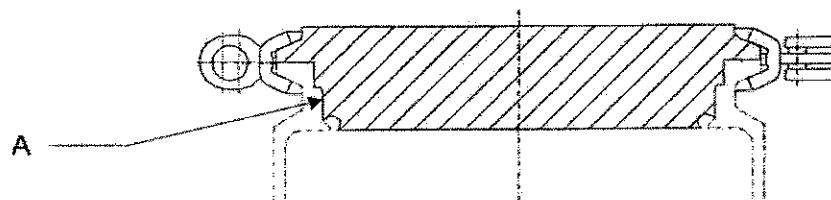
Maße / dimensions in mm								
A	Ø 66	Ø 84	Ø 84	Ø 115	Ø 142	Ø 169	Ø 193	
D	Ø 70	Ø 85	Ø 85	Ø 114	Ø 154	Ø 184	Ø 212	
H	25	25	65	30	30	30	30	
H1	12	12	12	15	15	15	15	
S	2	2	2	2,5	2	3	4	

zulässiger Druck in bar bei Verwendung mit: / permitted pressure in bar with using:

Klappring / hinged clamp	1.4401	16	16	16	16	16	10	10
gegossenem Halbring / cast clamp	1.4408							

Erforderlicher Verschluss / necessary plug

Pos. / item	Werkstoff Material	Sach-Nr. / part no.						
		U 32/25	U 50/40	U-S 50/40	U 80/65	U 100/125	U 125	U 162
A	1.4404	221-144.01	221-144.02	221-144.02	221-144.03	221-144.04	221-144.06	221-144.05



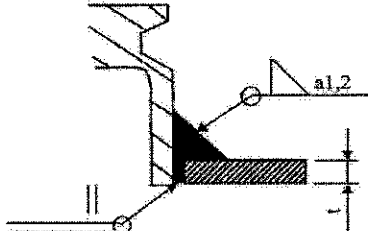
Achtung !
Beim Einschweißen der Flansche
Anschweißanweisung Nr.
21S00949D beachten.

Attention !
Observe welding instructions
No. 21S00949D
for welding the flanges


Manufacturer's Welding Instructions (WPS) for
Housing Connection U

TUCHENHAGEN
Datum/date: 2004-04-21
221RLI002534E_0.DOC

Location: Büchen	Preparation method: mechanical
Manufacturer's welding method: 141 (WIG)	Cleaning method: brushing or pickling
Reference No.:/	Specification of the parent metal:
WPAR No.: /	1.: 1.4404 (X2CrNiMo 1713 2)
Welders: qualified welder acc. to EN 287-1 AD-HP3	
Welding procedure: 141 DIN EN 24063	Workpiece thickness [mm]: t = 2; 2,5; 3; 4
Weld type: I – weld, fillet weld	Outside diameter [mm]: /
Drawing for preparing the joint: /	Welding position: PA (horizontal); PD (overhead)

Structure of the joint	Welding procedure
<p>Produce I-weld and fillet weld</p> 	<ol style="list-style-type: none"> 1. Insert locking into housing connection U and fix with clamps 2. Tack housing connection U with 4 tack-weld spots at welding neck 3. Produce fillet weld using backing gas 4. If necessary, produce I - weld (for tightness only) using Ø 1mm 1.4430 filler rod. 5. After cooling down, remove blind cover 6. Visual inspection of I – weld 7. Check fillet weld with A-tolerance gauge

Workpiece thickness t [mm]	Weld bead	Procedure	Filler metal Ø [mm]	Current strength I [A]	Voltage U [V]	Kind of current / polarity of the electrode	Welding speed [cm/min]	Heat Application [kJ/cm]
2; 2,5	Fillet weld	141	1,6	80 - 100	10 - 15	≠/-	3 - 7	5 - 7
3	Fillet weld	141	1,6	90 - 110	10 - 15	≠/-	3 - 7	6 - 8
4	Fillet weld	141	1,6	120 - 140	10 - 15	≠/-	3 - 7	7 - 10
2; 2,5; 3; 4	I-Weld	141	1	50 - 60	10 - 15	≠/-	3 - 7	5 - 7

<p>Filler material (Procedure / Standards / Brand): 1.:EN 12072, 19.12.3 Lsi (Material No.1.4430)</p>	<p>Inert gas: DIN EN 439 I1, R1 Flow rates in l/min: 13 - 15</p>
	<p>Backing gas: DIN EN 439 I1, R1 Flow rates in l/min: 10 - 20</p>
<p>Manufacturer:</p>  <p>Merhof, 30.08.2001</p> <p>Name, Date and Signature (Welding Supervision)</p>	