

PLIDCO® WELD+ENDS® COUPLING

Joins piping without special preparation of pipe ends

Standard PLIDCO® Weld+Ends® Couplings have a single row of clamping screws at each end. Where excessive end-pull loads are involved and welding is not feasible, additional rows of clamping screws can be provided or a PLIDCO® Clamp+Ring may be used. Special installation instructions are necessary for thin wall applications. Contact PLIDCO® for details.

Available in standard sizes 1-1/2" through 48".

Special sizes, diameters, pressures and lengths available upon request.

Buna-N packing is standard.

Viton, Silicone and other packings available upon request.

Standard body materials:

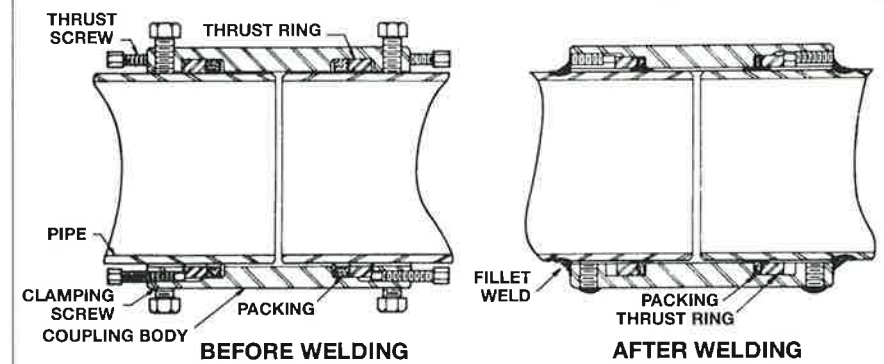
- ASTM A106 Gr. C
- ASTM A105/A350 Gr. LF2
- ASTM A516 Gr. 70

Options:

- Marine epoxy paint for corrosion protection
- NACE MR0175/ISO 15156 compliant material



PLIDCO® WELD+ENDS® COUPLING SPECIFICATIONS



Pipe not anchored: A joint in which the pipe ends could move when subjected to internal or external forces, such as internal pressure, temperature expansion and contraction, underwater currents, ground movement or any combination thereof. The assigned Plidco® Weld+Ends® **Pipe Not Anchored** rating (as listed in chart) considers only static force created by the internal pressure. It does not consider any additional external forces such as temperature expansion and contraction, underwater currents, ground movement or any combination thereof. These additional external forces must be determined by the customer. If any of these forces cannot be restrained by customer proven techniques, a Plidco® Clamp+Ring must be used.

Anchored pipe: A joint in which the pipe ends would not move when subjected to the types of forces listed under **Pipe Not Anchored**. The Plidco® Weld+Ends® **Anchored Pipe** rating is the maximum pressure at which the pipeline can be operated. It assumes that the pipeline is suitably anchored by welding, by the use of an appropriately rated Plidco® Clamp+Ring or by other customer proven techniques.

MAXIMUM WORKING PRESSURE PSI

API Pipe Sizes	O.D.	Length Between Packing	Approx. Overall Length	Pipe Anchored or Welded	* Pipe Not Anchored	Approx. Wt. Lbs.
1-1/2	3-1/4	2	6-13/16	2000	2000	12
2	3-3/4	2	6-13/16	2000	2000	13
2-1/2	4-1/2	2	6-13/16	2000	1848	14
3	5	2	6-13/16	2000	1247	16
4	6	3-1/8	8-1/2	2000	1131	30
6	8-1/2	3-5/8	9	2000	696	60
8	11	3-3/4	10	2000	513	105
10	13	4-1/8	10-1/2	1500	396	120
12	14-7/8	4-1/8	10-1/2	1200	328	140
14	16-1/2	4-5/8	14	1200	311	225
16	18-1/2	4-5/8	14	1200	238	250
18	21	5-9/16	16	1200	251	395
20	23-1/2	5-9/16	16	1200	203	520
22	25	5-9/16	16	1200	252	475
24	27-1/8	5-9/16	16	1200	212	540
26	29	5-9/16	16	1000	180	555
28	31-1/8	5-9/16	16	1000	155	635
30	33-1/8	5-9/16	16	1000	135	665
32	35-1/4	5-9/16	16	1000	159	740
34	37-3/8	5-9/16	16	1000	140	815
36	39-1/2	5-9/16	16	1000	125	895
38	41-3/8	5-9/16	16	900	126	905
40	43-1/4	5-9/16	16	800	114	915
42	45-3/4	5-9/16	16	960	103	1115
46	49-1/8	5-9/16	16	650	101	1000
48	51-1/8	5-9/16	16	600	92	1045

PLIDCO® RISER TYPE WELD+ENDS®

For easier replacement of underwater risers

Installation is rapid!

The Riser Type Weld+Ends® is socket-welded at the surface to the new replacement riser and lowered into the water. A diver cuts off the old riser, stabs the new fitting over the cut-off pipe, then tightens the clamping and thrust screws for a complete leak-proof seal without welding.

PLIDCO® Riser Type Weld+Ends® are designed to simplify the replacement of underwater risers on offshore oil and gas lines without welding underwater.

This fitting has additional clamping and thrust screws to provide a seal for high pressure and for resisting extreme end-pull.

Special installation instructions are necessary for thin wall applications. Contact Plidco for details.

Available in standard sizes 1½" through 48".
Special sizes, diameters, pressures and lengths available upon request.

Buna-N packing is standard.
Viton, Silicone and other packings available upon request.

Standard body materials:

- ASTM A106 Gr. C or ASTM A105/A350 Gr. LF2

Options:

- Marine epoxy paint for corrosion protection
- NACE MR0175/ISO 15156 compliant materials

API Pipe Sizes	O.D.	Approx. Over-all length	Pipe Anchored Or Welded	* Pipe Not Anchored	Approx. Wt. Lbs.
2"	3¾"	10¾"	2000 Psi	2000 Psi	20 lbs.
2½"	4½"	10¾"	2000 Psi	2000 Psi	28 lbs.
3"	5"	10¾"	2000 Psi	2000 Psi	30 lbs.
4"	6"	10¾"	2000 Psi	2000 Psi	40 lbs.
6"	8½"	10¾"	2000 Psi	1522 Psi	65 lbs.
8"	10¾"	18"	2000 Psi	1437 Psi	160 lbs.
10"	13"	18"	1500 Psi	694 Psi	205 lbs.
12"	14¾"	18"	1200 Psi	575 Psi	225 lbs.



PIP045

PLIDCO®

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PLIDCO® WELD+ENDS INSTALLATION INSTRUCTIONS

!! WARNING!!

IMPROPER SELECTION OR USE OF THIS PRODUCT CAN RESULT IN EXPLOSION, FIRE, DEATH, PERSONAL INJURY, PROPERTY DAMAGE AND/OR HARM TO THE ENVIRONMENT.

READ CAREFULLY

The person in charge of the installation must be familiar with these instructions and communicate them to all personnel involved. Do not use or select a Plidco Weld+Ends until all aspects of the application are thoroughly analyzed. Do not use the Plidco Weld+Ends until you read and understand these installation instructions. Every effort has been made to securely package this product prior to shipment. Thoroughly inspect for any damage that may have occurred during shipment. If you have any questions, or encounter any difficulties using this product, please contact:

PLIDCO "DEPARTMENT 100" at 440-871-5700
toll free U.S. & Canada at 800-848-3333

Safety Check List

- ☐ Read and follow these instructions carefully. Follow your company's safety policy and applicable codes and standards.
- ☐ Be absolutely certain that the correct seal material has been selected for the intended use.
- ☐ Determine the type of joint that the Plidco Weld+Ends coupling is expected to connect. See (a), (b) and (c) below and determine the appropriate pressure rating from the ratings listed on the label of the Plidco Weld+Ends coupling.

(a) Pipe Not Anchored

A joint in which the pipe ends could move when subjected to internal or external forces, such as internal pressure, temperature expansion and contraction, underwater currents, ground movement or any combination thereof. The assigned Plidco Weld+Ends *Pipe Not Anchored* rating considers only the end force created by the internal pressure. It does not consider any additional external forces such as temperature expansion and contraction, underwater currents, ground movement or any combination thereof. These additional external forces must be determined by the customer. If any of these forces cannot be restrained by customer proven techniques, a Plidco Clamp+Ring must be used.

(b) Anchored Pipe

A joint in which the pipe ends would not move when subjected to the forces listed under *Pipe Not Anchored*. The Plidco Weld+Ends *Anchored Pipe* rating is the maximum pressure at which the pipeline can be operated (see *After Welding* rating). It assumes that the pipeline is suitably anchored by welding, by the use of an appropriately rated Plidco Clamp+Ring or by other customer proven techniques.

(c) After Welding

Some specially ordered and designed Plidco Weld+Ends have a separate *After Welding* rating. Refer to the label and/or Plidco's Order Acknowledgement form to determine the *After Welding* rating, if applicable.

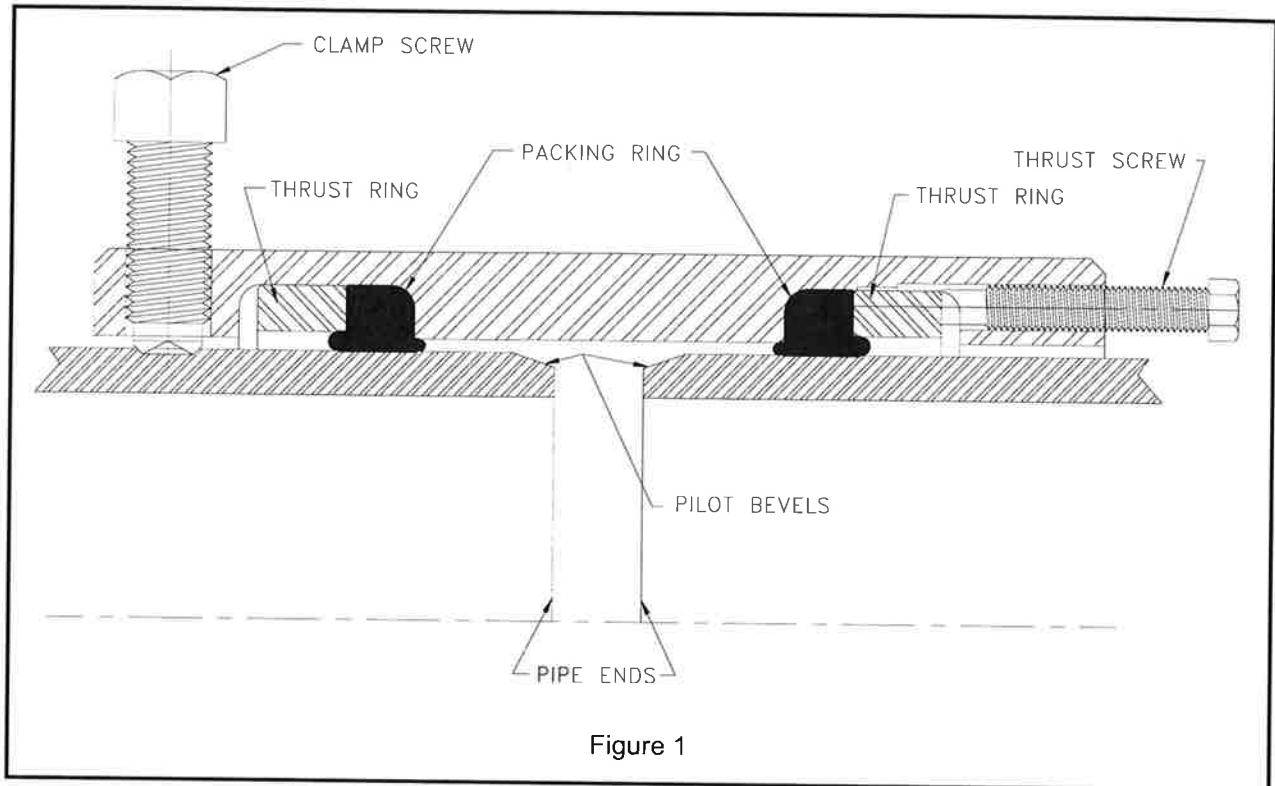
- ☐ Pipe wall thickness less than those listed may be pushed inward by the force of the clamp screws. Contact Plidco for recommended maximum working pressure and revised clamp screw torque values for pipe wall thicknesses thinner than listed below.

Minimum Pipe Wall Thickness for a Plidco Weld+Ends	
Nominal Pipe Size (inches)	Wall Thickness (inches)
1½	0.200 (5.1 mm)
2	0.218 (5.5 mm)
2½	0.276 (7.0 mm)
3	0.237 (6.0 mm)
4	0.237 (6.0 mm)
6	0.280 (7.1 mm)
8	0.322 (8.2 mm)
10	0.365 (9.3 mm)
12	0.406 (10.3 mm)
14	0.438 (11.1 mm)
16 & larger	0.500 (12.7 mm)

- ☐ A Plidco Clamp+Ring should be considered whenever the wall thickness is less than those listed. A Plidco Clamp+Ring should also be considered where high external forces (such as underwater currents or thermal contractions) are anticipated, even if the pipe has an adequate wall thickness.
- ☐ Pipelines should be carefully blocked at elbows and bends to prevent pullouts caused by internal and external forces; or a Plidco Clamp+Ring should be used. The pipeline should be evenly supported before repressuring. Follow applicable B31 codes during repressuring.
- ☐ If the Plidco Weld+Ends coupling is welded according to our instructions, or a suitable Plidco Clamp+Ring is used, it can be considered an anchored joint.
- ☐ Observe the pressure and temperature ratings on the label of the Plidco Weld+Ends coupling. Repressuring should be accomplished slowly and steadily without surges that could vibrate the pipeline and fitting. Industry codes and standards are a good source of information on this subject. Except for testing purposes, do not exceed the design pressure of the Plidco Weld+Ends. Refer to the *Field Testing* section for precautions. Personnel should not be allowed near the installation until the seal has been proven.

Pipe Preparation

1. The pipe surface in the area of the repair should be clean, free of coating and burrs and lubricated to prevent abrasion to the seals.
2. For badly misaligned or out-of-round pipe, it is helpful to grind a pilot bevel with a generous taper on the pipe. This will eliminate the risk of damage to the seals while slipping the Plidco Weld+Ends coupling over the end of the pipe. (See Figure 1)



Installation

The seals can be damaged by careless handling. Lifting devices such as chains, cables or lift truck forks should not contact the seals. Failure to do so can result in the seals being damaged or pulled from their grooves.

1. Measure and record dimension "D", as shown in Figure 3. This will be needed later if the Plidco Weld+Ends is welded to the pipe.
2. Coat all exposed surfaces of the seal material with a lubricant. The chart on the next page indicates the lubricants that are recommended for the various seal materials. The customer must determine if the lubricant is compatible with the product in the pipeline.

Petroleum based lubricants	= A
Silicone based lubricants	= B
Glycerin based lubricants	= C
Super Lube® Grease (1)	= D

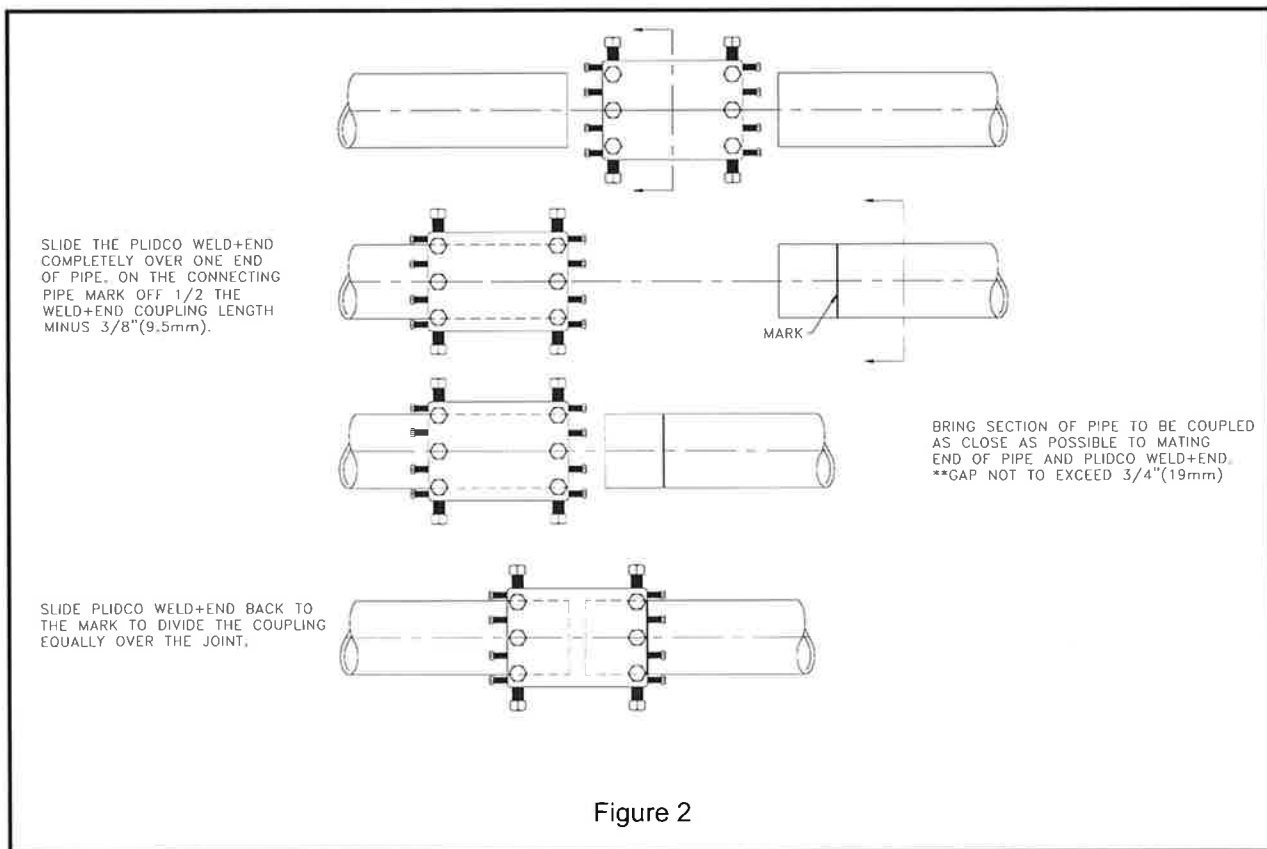
Buna-N	A, B, C, D
Viton	A, B, C, D
Silicone	C, D
Neoprene	B, C, D
Aflas	A, B, C, D
Hycar	A, B, C, D
Teflon	A, B, C, D
Kevlar	A, B, C, D

Temperature (2)

225°F (107°C)
250°F (121°C)
300°F (149°C)
250°F (121°C)
225°F (107°C)
180°F (82°C)
500°F (260°C)
750°F (399°C)

- (1) Super Lube® Grease is a product of Synco Chemical Corporation. (www.super-lube.com)
- (2) Temperature limit is for the seal material only and does not imply the pressure rating is necessarily applicable at this limit.

3. Slide the Plidco Weld+Ends coupling completely over one end of the pipe. Mark on the pipe one-half the Plidco Weld+Ends coupling's length from the middle of gap (recommended gap not to exceed 3/4 inch (19 mm)). Slide the Weld+Ends coupling back to the mark to divide the coupling equally over the joint. (See Figure 2)



4. Clamp screws have case hardened cup points which are used to secure the coupling to the pipe. The shanks are mild steel and fully weldable. Clamp screws must be tightened evenly, maintaining an equal space between the pipe and the coupling using the recommended torque values. Clamp screws are designed for the assigned *Pipe Not Anchored* rating, which considers only the end force created by the internal pressure. (See Safety Check List, (a) *Pipe Not Anchored*)
5. Accurate clamp screw torque values are very important when the Plidco Weld+Ends coupling is used on a pipeline joint that is NOT ANCHORED. Do not exceed the *Pipe Not Anchored* rating listed on the label of the Plidco Weld+Ends until subsequent welding has been completed or the pipe is anchored by other means, such as a Plidco Clamp+Ring. FAILURE TO DO SO CAN RESULT IN EXPLOSION, FIRE, DEATH, PERSONAL INJURY, PROPERTY DAMAGE AND/OR HARM TO THE ENVIRONMENT.
6. Check all the clamp screws to make certain each has been tightened to the minimum torque specified in the chart below. As noted in the *Safety Check List*, contact Plidco for the maximum allowable working pressure and the revised clamp screw torque value for thin wall pipe.

Cup Point Clamp Screws	Minimum Torque	
	(ft-lbf)	(Nm)
5/8-11	100	136
3/4-10	150	240

7. Thrust screws activate the seals. They are made of mild carbon steel and are fully weldable. They should be tightened gradually and uniformly around the circumference. First, snug all the thrust screws firmly. Then advance each thrust screw about 1/8 of a turn before proceeding to an adjacent thrust screw. It will be necessary to make many circuits around the coupling before completing the thrust screw torque operation. Use the recommended torque values shown in the following chart.

Thrust Screws	Torque Range	
	(ft-lbf)	(Nm)
3/8-16	20 - 25	28 - 34
1/2-13	30 - 40	41 - 55
5/8-11	70 - 80	95 - 109

Repressuring and Field Testing

Repressuring after the installation should be done with extreme caution; slowly and steadily without surges, which could vibrate the pipeline and fitting. Industry codes and standards are a good source of information on this subject. Except for testing purposes, operating pressure must not exceed the *Anchored Pipe*, *Pipe Not Anchored* or *After Welding* rating, as appropriate. The Plidco Weld+Ends can be field tested up to 1½ times the *Anchored Pipe* or the *After Welding* rating, as applicable. In the unanchored condition the Plidco Weld+Ends must not be tested above the *Pipe Not Anchored* rating. Read and fully understand the definition of *Anchored Pipe*, *Pipe Not Anchored* and *After Welding* as listed in the *Safety Check List* before pressurizing the line. Personnel should not be allowed near the repair until the installation has been proven.

Field Welding Instructions

Failure to follow field welding instructions could result in explosion, fire, death, personal injury, property damage and/or harm to the environment.

PIPELINE SHOULD BE FULL AND UNDER FLOW USE ANCHORED PIPE OR PIPE NOT ANCHORED RATING AS APPLICABLE

Use weld material with equal or greater tensile strength than the pipe. Carefully control the size and shape of the circumferential fillet welds. The weld is required to anchor the joint and give longitudinal stability to the pipeline. The size of the fillet weld should be at least 1.4 times the wall thickness of the pipe. This assumes a 1.0 joint efficiency. You may need to select a different joint efficiency based on your level of inspection or your company's welding policy.

Strive for a concave faced fillet weld, with streamlined blending into both members; avoid notches and undercuts. The smoother and more streamlined the weld, the greater the resistance to fatigue failure. The worst possible shape would be a heavy reinforced convex weld with an undercut. Improper weld shape can lead to rapid fatigue failure, which can cause leakage, rupture or an explosion with attendant serious consequences.

Welders and weld procedures should be qualified in accordance with API Standard 1104, *Welding of Pipelines and Related Facilities*, Appendix B, *In-Service Welding*. We strongly recommend the use of a low hydrogen welding process such as GMAW or SMAW using low hydrogen electrodes (E-XX18) because of their high resistance to moisture pick-up and hydrogen cracking. SMAW electrodes must be absolutely dry. It is very important that the field welding procedure closely follow the essential variables of the qualified procedure so that the quality of the field weld is represented by the mechanical tests performed for the procedure qualification.

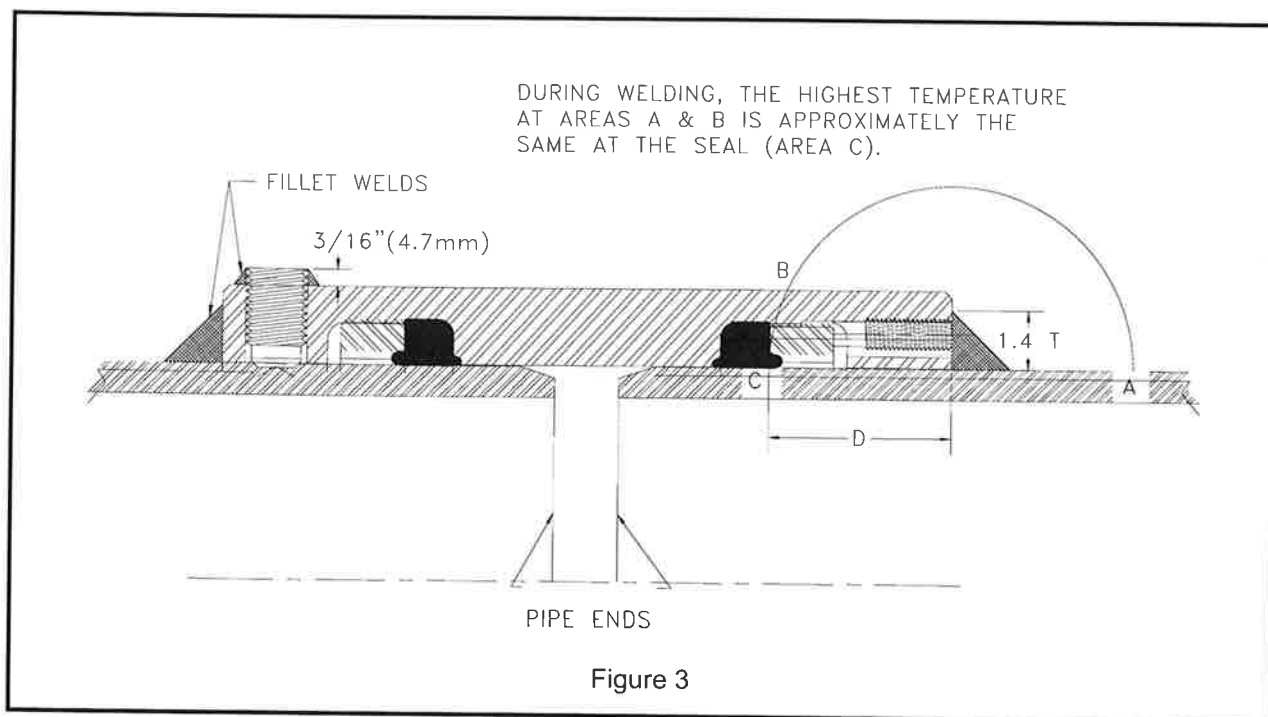
We do not recommend the use of thermal blankets for pre-heating. Thermal blankets can generate hot spots and reduce the ability of the Plidco Weld+Ends to dissipate welding heat in the vicinity of the seals. We recommend a small torch, such as a cutting torch, being careful not to aim the flame directly into the gap between the Plidco Weld+Ends and the pipe towards the seals. The flame from a preheat torch is helpful in burning off oils and other contaminants. Do not use a large torch, commonly called a rosebud, because of the difficulty controlling the size of the area being preheated.

Dimension "D", as measured during the initial installation, may now be used to mark off locations "A" and "B", as shown in Figure 3. These locations are the same distance from the weld as the seal location "C". To prevent damage to the seals, monitor the heat generated by welding or preheating, particularly at location "A" and "B", by using temperature crayons or probe thermometers. If the heat generated approaches the temperature limit of the seal material, which is indicated in the seal lubrication chart, welding should be discontinued or sequenced to another part of the fitting so that the affected area has a chance to cool.

Welding Sequence

1. Caution should be observed so that welding or preheating does not overheat the seals. Sequence the welding so that the heat is not concentrated in one area.
2. Thrust screws should be cut or burned off flush. Start with the fillet weld to the pipe around circumference and include seal welding the thrust screws. (See Figure 3)

3. Cut or burn off clamp screws approximately 3/16" (4.8 mm) above the outside surface of the coupling and seal weld. After the circumferential fillet welds are finished, one clamp screw per end may be removed to serve as a vent while welding the remaining clamp screws and also as a final test point for leakage if so required. (See Figure 3)



Storage Instructions

Plidco Weld+Ends couplings should be stored in a dry environment to prevent the unpainted surfaces from rusting. Storage temperatures should not exceed 120°F (50°C). Cover with a dark polyethylene to keep the direct sunlight from the seals. It is best to exclude contamination, light, ozone and radiation. Improperly stored Plidco Weld+Ends couplings can cause the gasket material to become cracked and brittle and lose its ability to seal.

Traceability

Plidco Weld+Ends couplings, as most Plidco products, have a unique serial number by which the fitting is fully traceable. Additionally, all elastomer seals have a unique batch number by which the seal material is traceable.

Notes

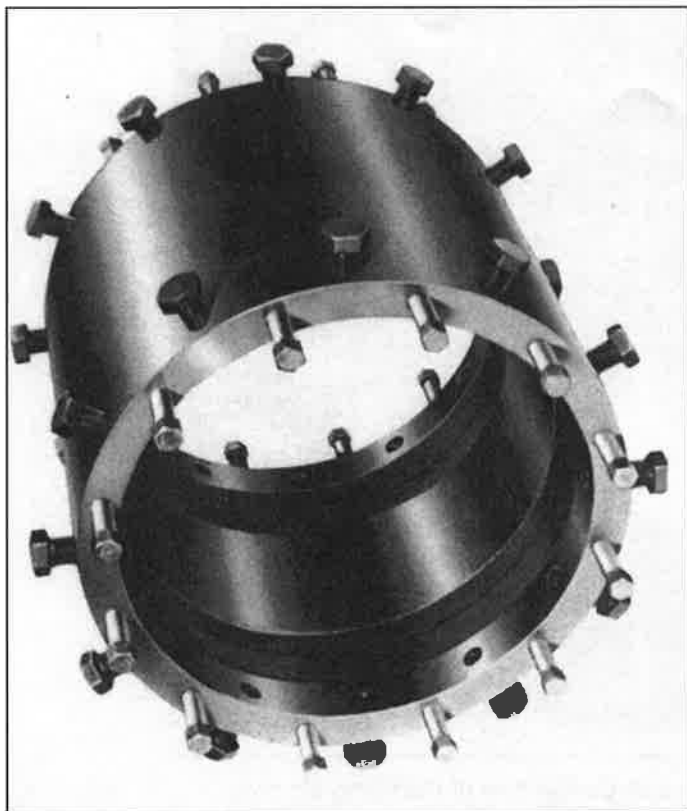
THE PIPE LINE DEVELOPMENT CO.

PLIDCO INTERNATIONAL, INC.

870 CANTERBURY ROAD • CLEVELAND, OHIO 44145

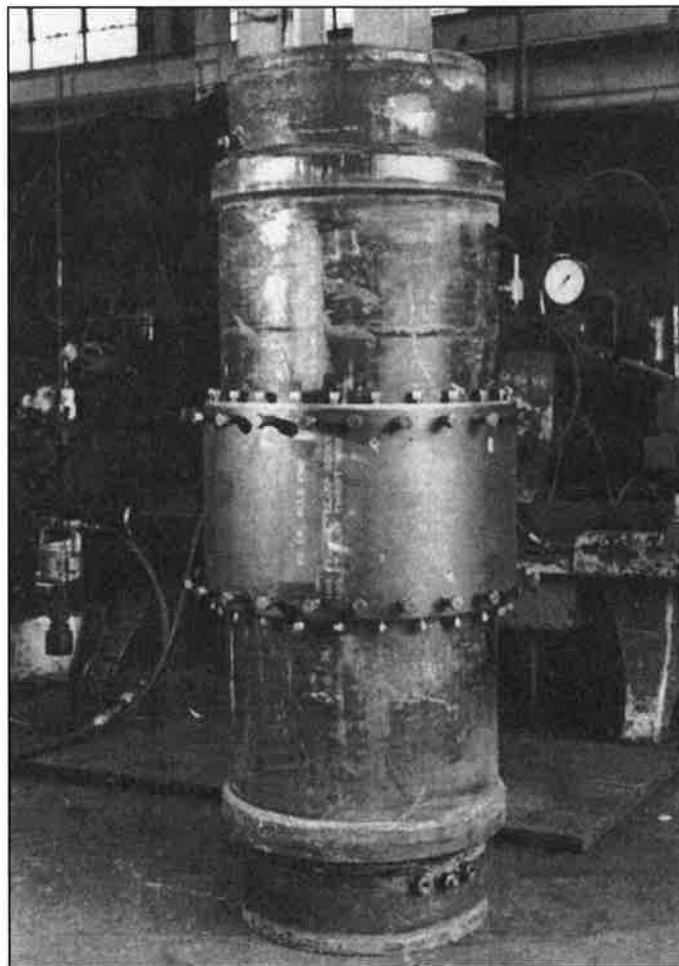
PLIDCO WELD+ENDS PARTS LIST

SIZE OF COUPLING	PACKING RINGS		END THRUST SCREWS		CLAMPING SCREWS		SIZE OF COUPLING
	O.D.	CROSS SECTION	SIZE & THREAD	NUMBER PER SET	SIZE & THREAD	NUMBER PER SET	
1-1/2"	3-5/32	3/8 x 1/2	3/8-16 x 2-1/4	6	5/8-11 x 1-3/4	6	1-1/2"
2"	3-5/32	3/8 x 1/2	3/8-16 x 2-1/4	6	5/8-11 x 1-3/4	6	2"
2-1/2"	3-25/32	3/8 x 1/2	3/8-16 x 2-1/4	8	5/8-11 x 1-3/4	8	2-1/2"
3"	4-9/32	3/8 x 1/2	3/8-16 x 2-1/4	8	5/8-11 x 1-3/4	8	3"
4"	5-7/16	3/8 x 1/2	3/8-16 x 2-1/4	12	5/8-11 x 1-3/4	12	4"
5"	6-7/16	3/8 x 1/2	3/8-16 x 2-1/4	12	5/8-11 x 1-3/4	12	5"
6"	7-33/64	3/8 x 1/2	3/8-16 x 2-1/4	16	5/8-11 x 1-3/4	16	6"
7" O.D.	7-15/16	1/2 x 3/4	1/2-13 x 2-1/2	20	5/8-11 x 1-3/4	20	7"
8"	9-25/32	1/2 x 3/4	1/2-13 x 2-1/2	20	5/8-11 x 1-3/4	20	8"
10"	11-15/16	1/2 x 3/4	1/2-13 x 2-1/2	24	5/8-11 x 1-3/4	24	10"
12"	13-61/64	1/2 x 3/4	1/2-13 x 2-1/2	28	5/8-11 x 1-3/4	28	12"
14"	15-15/64	1/2 x 1	1/2-13 x 2-1/2	32	5/8-11 x 1-3/4	32	14"
16"	17-15/64	1/2 x 1	1/2-13 x 2-1/2	32	5/8-11 x 1-3/4	32	16"
18"	19-31/64	5/8 x 1-1/16	5/8-11 x 3	32	3/4-10 x 2-7/8	32	18"
20"	21-31/64	5/8 x 1-1/16	5/8-11 x 3	32	3/4-10 x 2-7/8	32	20"
22"	23-31/64	5/8 x 1-1/16	5/8-11 x 3	48	3/4-10 x 2-7/8	48	22"
24"	25-31/64	5/8 x 1-1/16	5/8-11 x 3	48	3/4-10 x 2-7/8	48	24"
26"	27-31/64	5/8 x 1-1/16	5/8-11 x 3	48	3/4-10 x 2-7/8	48	26"
28"	29-31/64	5/8 x 1-1/16	5/8-11 x 3	48	3/4-10 x 2-7/8	48	28"
30"	31-31/64	5/8 x 1-1/16	5/8-11 x 3	48	3/4-10 x 2-7/8	48	30"
31"	32-31/64	5/8 x 1-1/16	5/8-11 x 3	48	3/4-10 x 2-7/8	48	31"
32"	33-31/64	5/8 x 1-1/16	5/8-11 x 3	64	3/4-10 x 2-7/8	64	32"
34"	35-31/64	5/8 x 1-1/16	5/8-11 x 3	64	3/4-10 x 2-7/8	64	34"
36"	37-31/64	5/8 x 1-1/16	5/8-11 x 3	64	3/4-10 x 2-7/8	64	36"
38"	42	5/8 x 1-1/16	5/8-11 x 3	72	3/4-10 x 2-7/8	72	38"
40"	44	5/8 x 1-1/16	5/8-11 x 3	72	3/4-10 x 2-7/8	72	40"
42"	46	5/8 x 1-1/16	5/8-11 x 3	72	3/4-10 x 2-7/8	72	42"
44"	48	5/8 x 1-1/16	5/8-11 x 3	84	3/4-10 x 2-7/8	84	44"
46"	50	5/8 x 1-1/16	5/8-11 x 3	84	3/4-10 x 2-7/8	84	46"
48"	52	5/8 x 1-1/16	5/8-11 x 3	84	3/4-10 x 2-7/8	84	48"

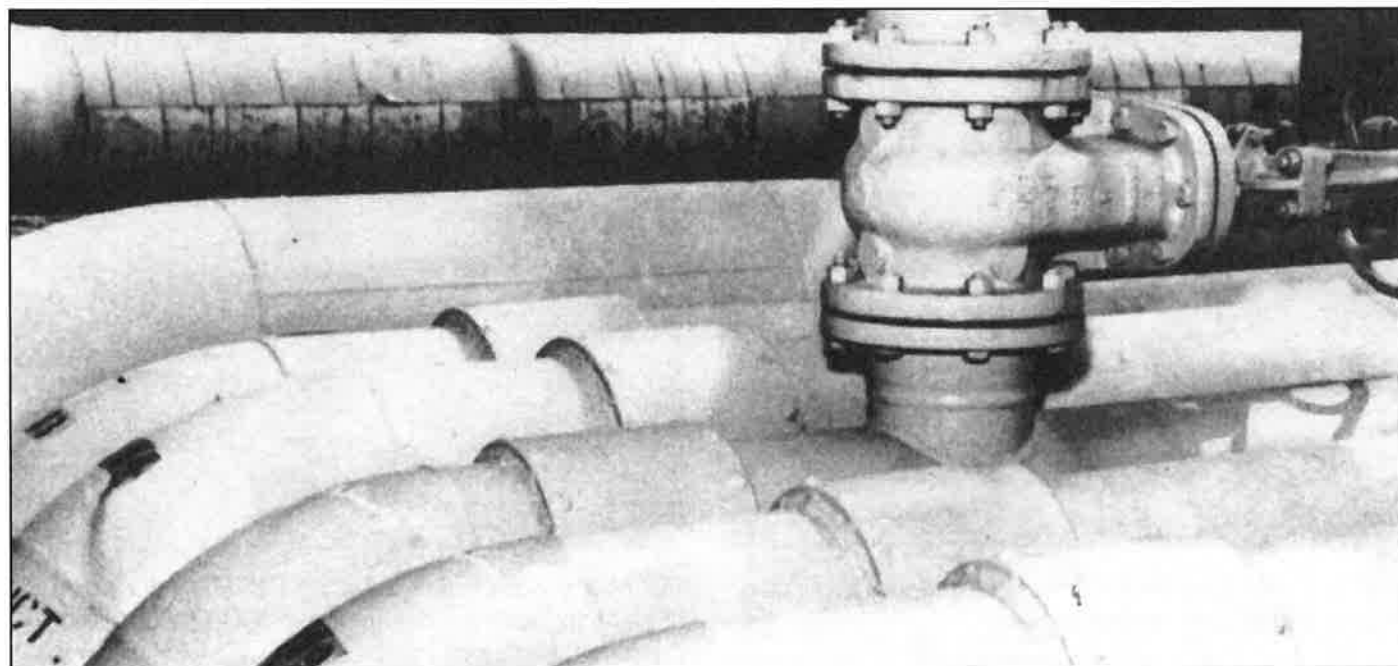


Plidco Weld+Ends, a safety welding coupling for oil, gas, chemical process and other pipelines, joins piping without special preparation of pipe ends.

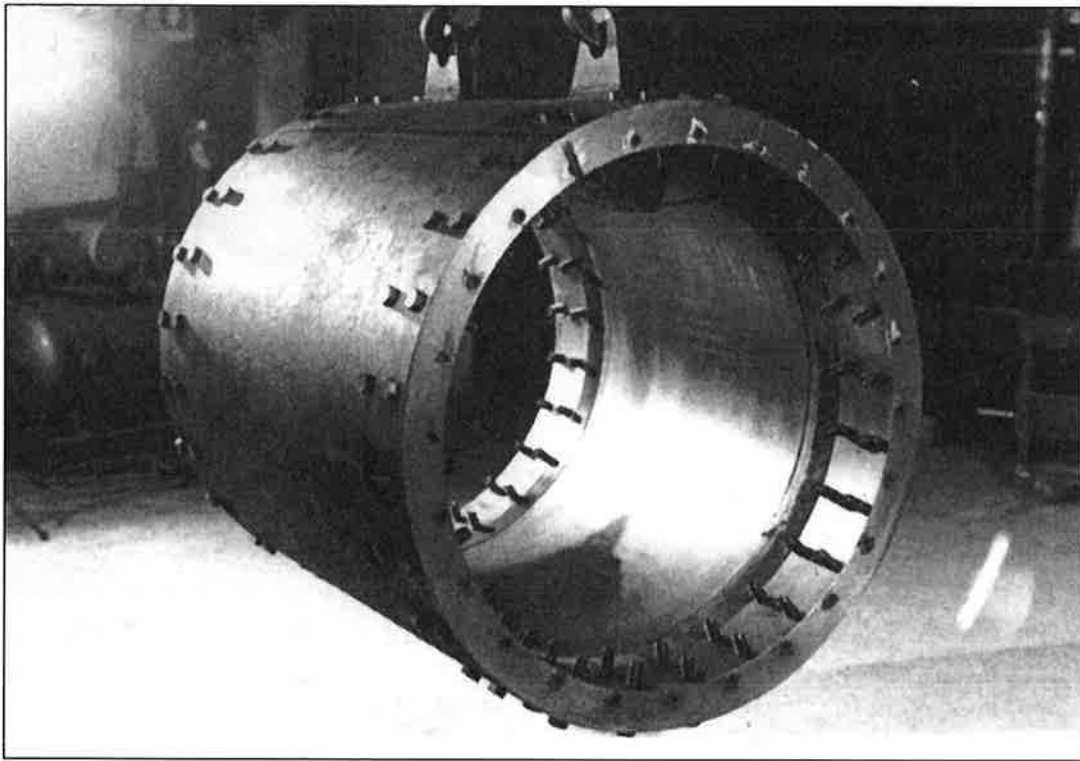
Pipelines can be put back in operation at recommended pressures, keeping downtime to an absolute minimum.



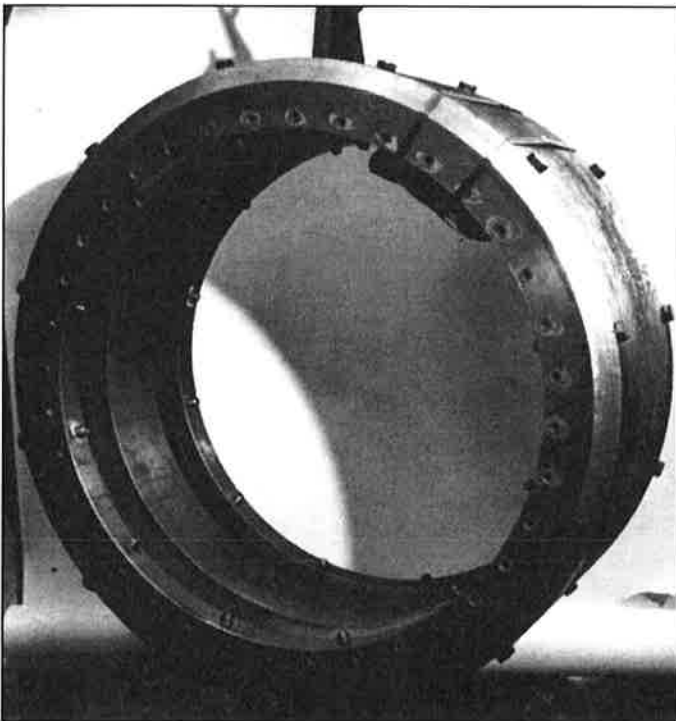
22" Plidco Weld+Ends Coupling under test.



Plidco Weld+Ends Couplings joining pipe sections and welded, in a large refinery in Baton Rouge, Louisiana.

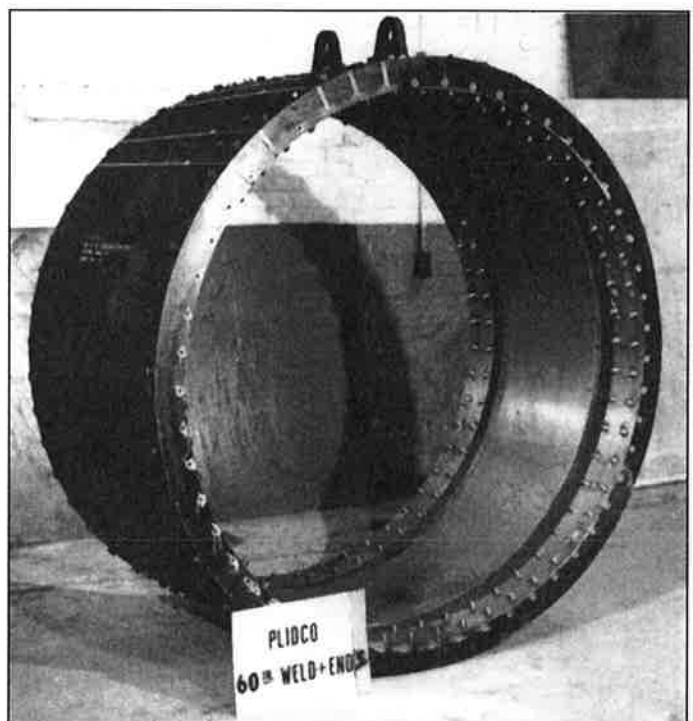


20" X 40-3/8" long Plidco Weld+Ends Coupling with double row of clamping screws, designed for 1000 psig working pressure, anchored pipe, for underwater installation.



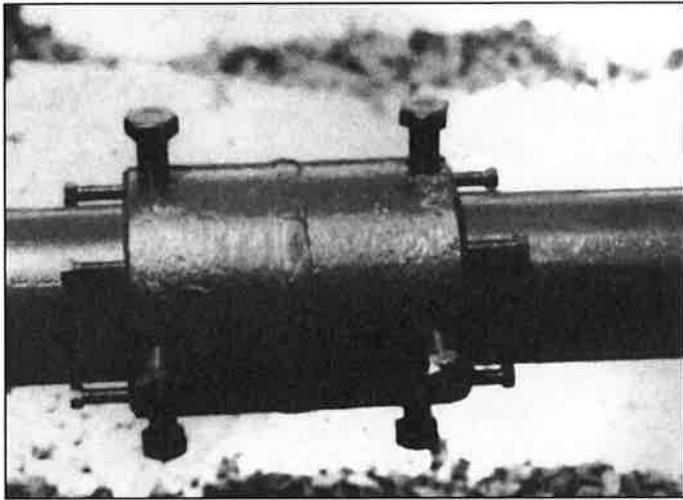
24" Special Plidco Weld+Ends Coupling for 3000 psig working pressure, anchored pipe.

Larger or special sizes and higher working pressures are available on application.

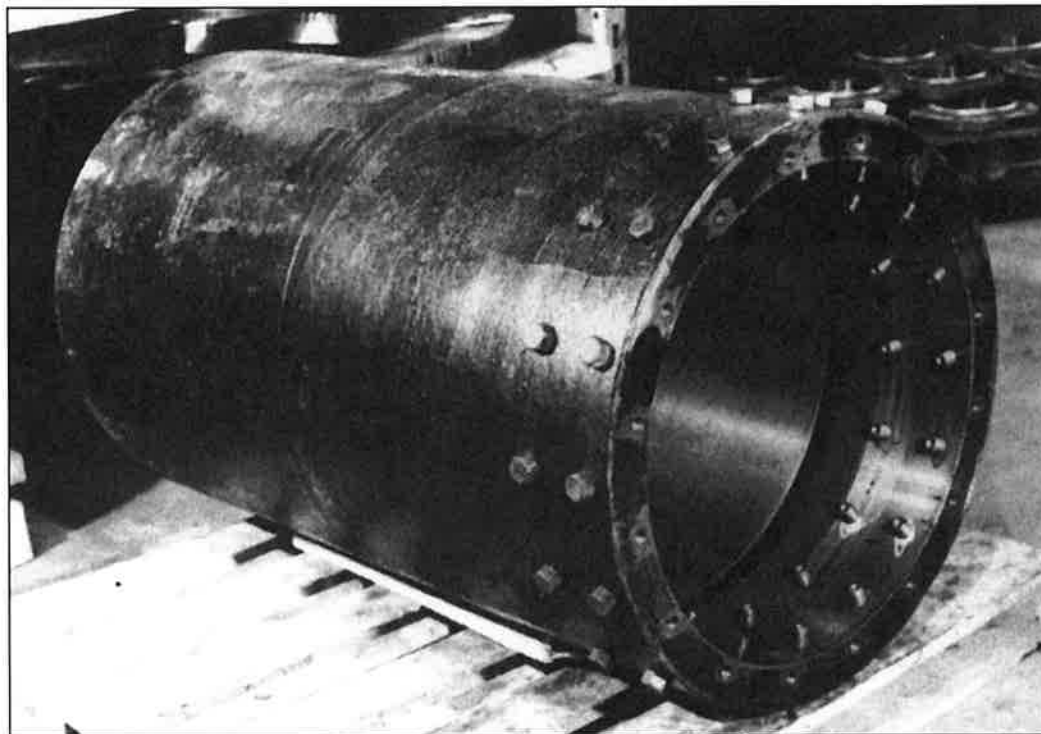
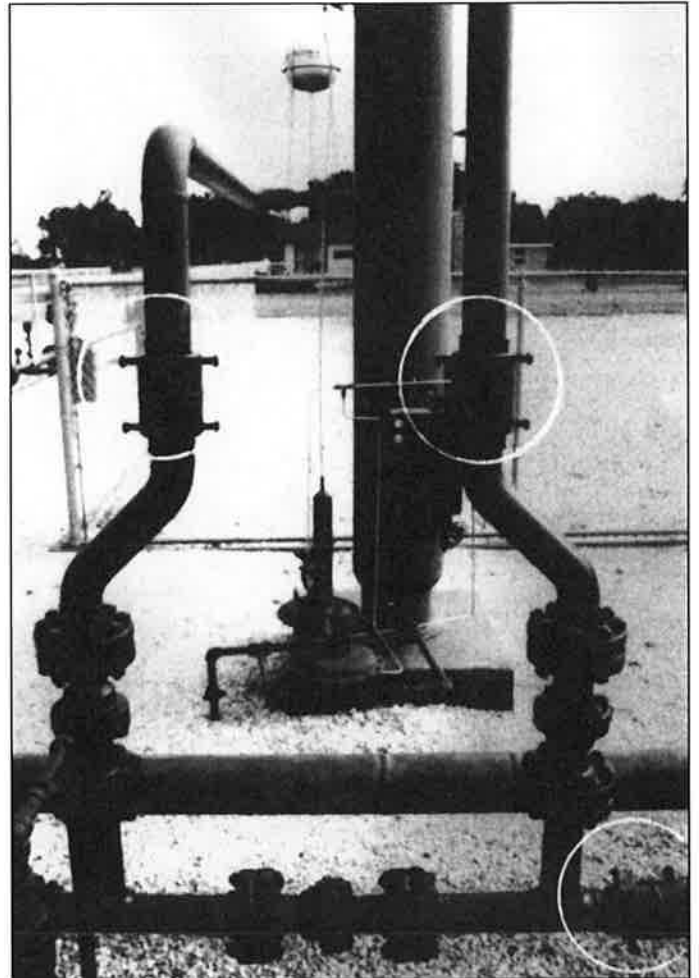


60" Plidco Weld+Ends Coupling, 33" O/A, double row of clamping screws, designed for 1000 psig working pressure, anchored pipe.

Largest Weld+Ends Coupling to date is 72" in diameter.



3" Plidco Weld+Ends Couplings joining pipe sections in a production field in Texas.



Plidco Special Riser-Type Weld+Ends coupling with a double row of clamping screws to simplify replacement of underwater risers where welding is not feasible.

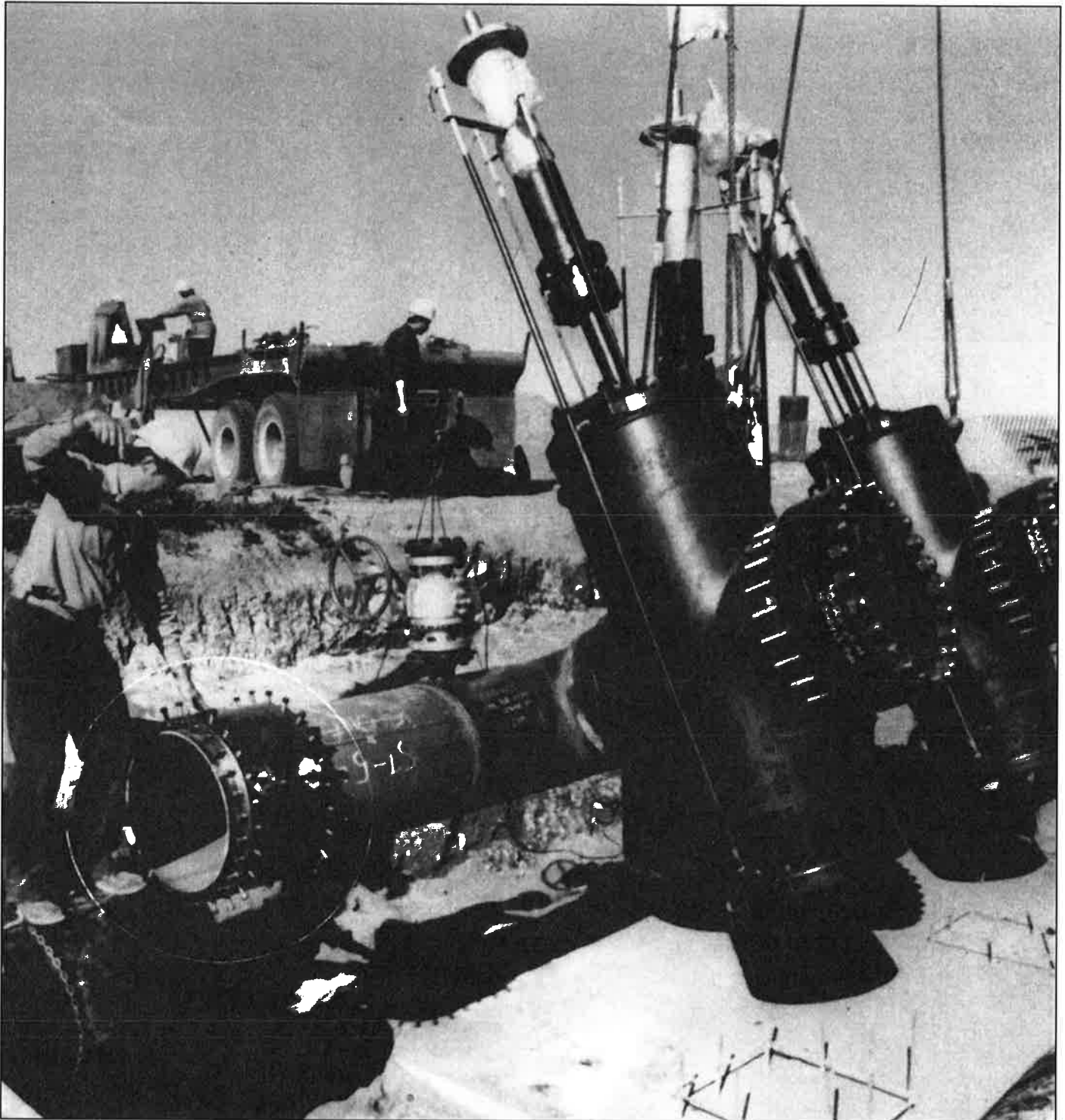


Photo by Jim Cochrane, The Edmonton Journal

The photograph shows a 24" Weld+Ends Coupling used on a valve installation at Interprovincial Pipe Line's Strome Station approximately 180 miles south east of Edmonton, Alberta. This is a part of their 20.5 million dollar expansion program in Western Canada.