Westatlantic Tech Corp
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High Pressure Pipe end couplings Bolted Restraint.

High Pressure Pipe Couplings

High pressure couplings WA-PCR-HP dual bolt: Crude oil, gasoline, gas, asphalt, steam, chemical process and other pipeline connections. Flow can resumed immediately at pressures shown in table below.
No special preparation of pipe ends is required. Cut the pipe and slide the dual bolt coupling on. When clamping and thrust bolts are fully tightened, the pipe is joined and leak proof.

WA dual bolt couplings can be with only bolts tightened or they can be welded.
If welding is required, it can be delayed until conditions are suitable.

Available in standard sizes: *1½" through 48". Special sizes, diameters, pressures and lengths, on application. Buna-N packing is standard. Viton, Neoprene, Hydrogenated Nitrile Seals also available.*

Standard body materials: *ASTM A 105 Forgings*
ASTM A 106 Gr. B Pipes
ASTM A 516 GR. 70 Plates

Manufacturing Procedures :

Welding : GTAW & SMAW
Seals : Per requirement
Hydro-testing : Rigs available from 1" to 48" NB #900
Certification : API – 6H License No. API – 6H 0012

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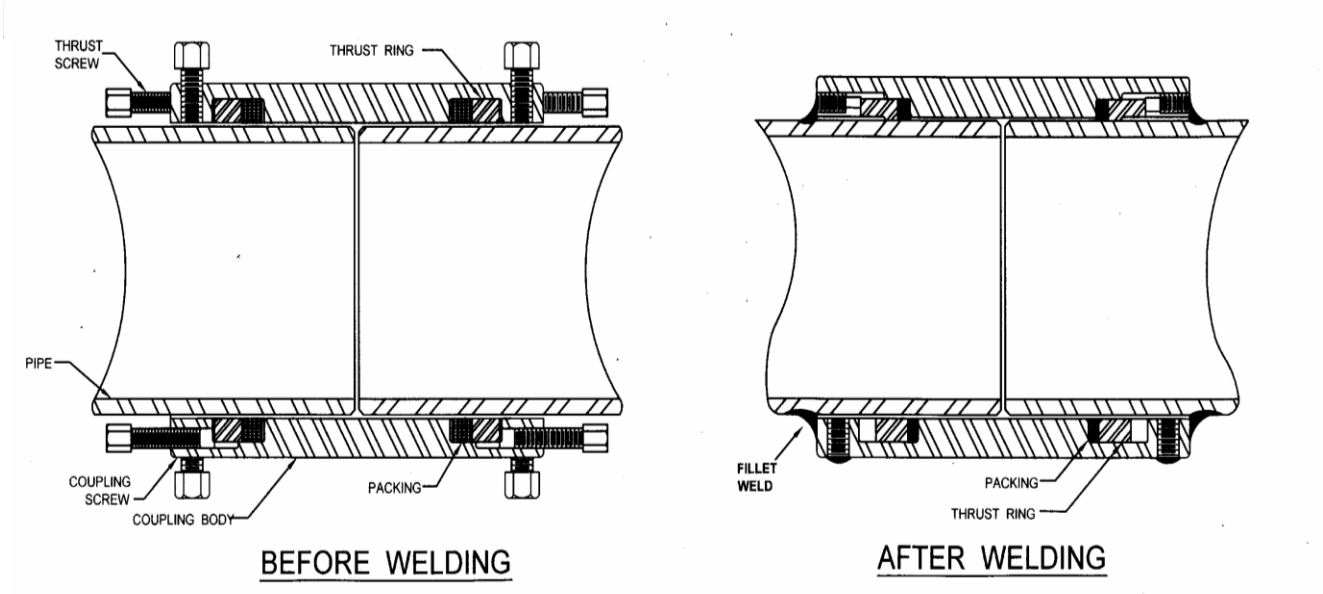
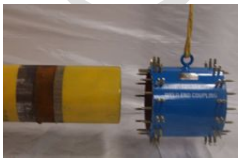


Figure - I

Pipe not anchored: the pipe ends can move freely when subjected to internal or external forces, such as internal pressure, temperature expansion and contraction, underwater currents, ground movement or any combination thereof. see working pressure for "Pipe not Anchored"

Anchored pipe: the pipe ends would not move when subjected to pipe not anchored forces. If the WELD END COUPLING is welded according to instructions, or a suitable Clamp Ring is used, it can be considered an anchored joint .



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HOW TO INSTALL

1. Slide the coupling completely over one end of pipe. (a wide gap is purposely left between pipe ends. This eliminates alignment on large pipelines. Mark off one-half of the Coupling length from middle of gap. Slide fitting back to mark, centering coupling equally over joint.

2. After coupling is positioned, torque the clamp and thrust bolts following installation instructions attached to each unit.
   Bolts adjust and equalize space between pipe and resist pull forces on the pipeline.

3. Thrust bolts push against the steel thrust ring. This compresses the packing ring with causing packing to flow out between pipe and coupling. When thrust bolts are pulled up tight, the joint installation is complete.

4. If welding is required before pipeline operational. Thrust bolts are cut or burned off flush. Ends of the coupling are fillet - welded around circumference.
   Clamping bolts are cut or burned off and sealed.
   Welders should be qualified in accordance with the requirements of API Standard RP 1107, Latest Edition. Follow approved welding procedures (WPS).

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Table: II

Nominal Pipe Sizes (inches)	Wall Thickness (inches)	Wall Thickness (mm)
1 ½	0.200	5.08
2	0.218	5.53
2 ½	0.276	7.01
3	0.237	6.01
4	0.237	6.01
6	0.280	7.11
8	0.322	8.17
10	0.365	9.27
12	0.109	2.76
14	0.438	11.12
16 & Larger	0.500	12.7

Pipe wall thicknesses less than those listed may be pushed inward by the force of the clamp screws. For recommended maximum working pressure on thin wall pipe, contact Westatlantic.

Clamp Rings should be considered whenever the wall thickness is less than those listed. 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 WA Clamp Rings should be used. Pipeline should be evenly supported in the bottom of the trench before repress ring. Follow applicable B31 codes during repress ring.