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SEDE LEGALE E OPERATIVA :COMTEC ENGINEERING S.R.L. VIA MONTELLO, 9 - 31040 BIDASIO DI NERVESA DELLA BATTAGLIA (TV) ITALY
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TECHNOLOGY
ON HALL PIPE SHELL AND FUNDS CYLINDRICAL TANKS

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➢ Application of the half-pipe on the shell:

The half pipe is obtained from coils and applied in a continuous way on the shell, generally there is the presence of a transverse welding intermediate, every 200 meters of half pipe (corresponding to the change of coils). On request this welding can be radiographed.

The stell strip is chamfered on the ends through milling (Fig. 1), and cold formed from a series of rollers and placed directly on to the shell tank.

Fig.1

The diameters of the half pipe available from our company are 60.3, 88.9 and 114.3 mm with thicknesses ranging from 4 to 6 mm.

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The welding is done under the half pipe SAW in single pass (Fig.2) and (Fig. 3).

Fig.2

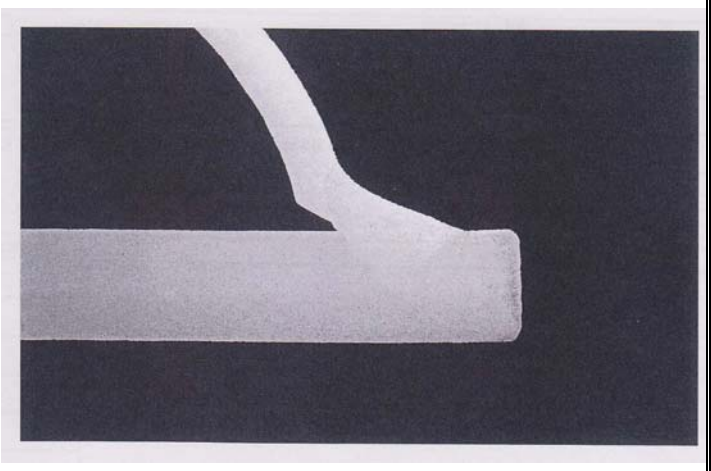

Fig.3

➢ Application of on funds half pipe:

Differently to the funds is the half pipe from tube calendered spiral "Archimedes". Subsequently, the tube is cut, chamfered and applied on the fund.
Is carried out a transverse junction every 3-5 mt of half pipe (Fig.4) and the side welds in this case can be made with both procedure SAW that FCAW.

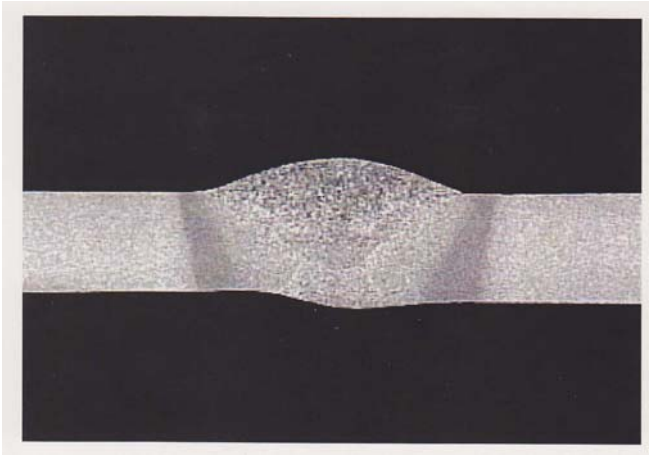

Fig.4

Normally for the application of half pipe reactors follow the procedures listed above, we remain available to the customer for any additional requests.
According to our experience with these detailed rules guarantee a minimum life of 20 years without leakage.