

Wrap-around Pipe Sleeve for Field Girthweld Corrosion Protection Installation Instructions

WPC-037/IP/6-01/01



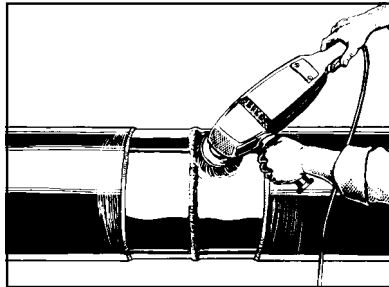
Materials and equipment

1. Appropriate size WPC sleeve and WPCP IV closure
2. Raychem torch (or equivalent)
3. Propane gas tank, hose, regulator and gauge

4. Standard safety equipment such as gloves, goggles, hard hat, etc.

Installation has to be done according to local government regulations and usual safety precautions.

For proper selection of Tyco Adhesives joint protection materials, see Product Selection Guide or contact Tyco Adhesives.



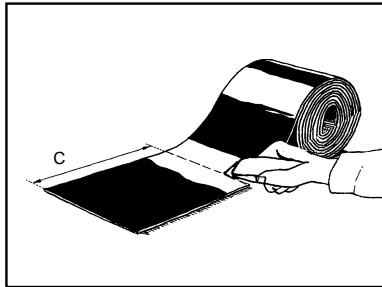
Sleeve application

1. Clean exposed steel and adjacent pipe coating to be covered by WPC sleeve with a hand or power wire brush, to remove loose and foreign materials. Wiping may be necessary to remove the particles from cleaning.

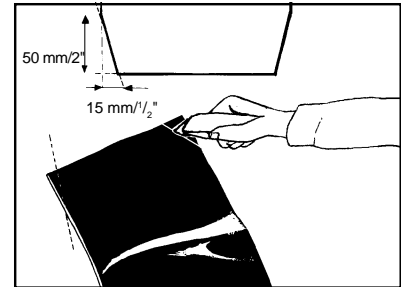
Note:

Coal tar - remove outer paper wrap 5" (125 mm) to 6" (150 mm) adjacent to cut-back to expose coal tar.

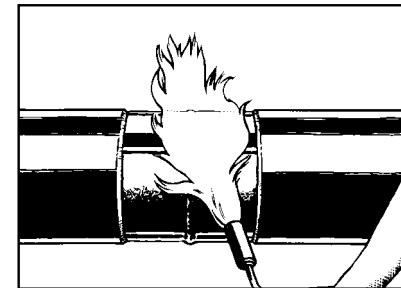
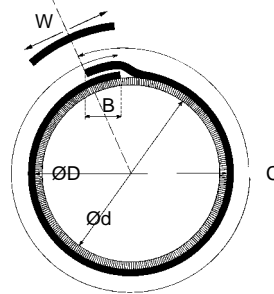
Painted coatings - remove whitewash paint on the surface of coating to be covered by WPC sleeve.



2. Cut the sleeve to the appropriate length according to below table.



3. Cut the corners of the underlying end of the sleeve to approximately 1/2" x 2" (15 mm x 50 mm).

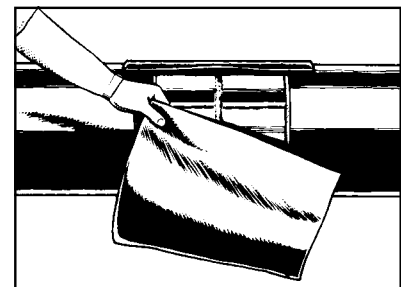


4. Preheat joint area until hot to the hand, approximately 140°F (60°C) minimum. Preheating reduces installation time and ensures proper bonding.

Note:

Two people working on opposite sides of the pipe are recommended for installing sleeves on pipe 16" (400 mm) in diameter and larger.

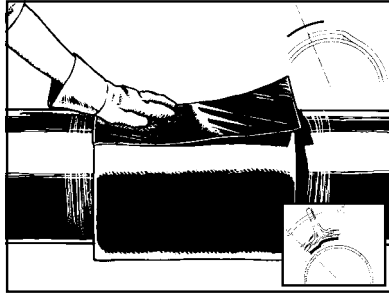
				W	
Ø D mils	Ø d	C	B	WPC/CXX	WPC/BXX
inches (0,001)	mm	in./mm	in./mm	in./mm	in./mm
3500	80	15/380	2/50	5/125	4/100
4500	100	18/460	2/50	5/125	4/100
5563	125	21,5/550	2/50	5/125	4/100
6625	150	25/640	2/50	5/125	4/100
8625	200	31,5/800	2/50	5/125	4/100
10750	250	38,5/980	2/50	5/125	4/100
12750	300	45,5/1150	2/50	6/150	4/100
14000	350	49,5/1260	2/50	6/150	4/100
16000	400	56/1420	2/50	6/150	4/100
18000	450	62,5/1590	2/50	8/200	6/150
20000	500	69,5/1770	2/50	8/200	6/150
22000	550	77/1950	2/50	8/200	6/150
24000	600	83/2110	2/50	8/200	6/150
26000	650	89,5/2270	2/50	8/200	6/150
28000	700	95,5/2430	2/50	8/200	6/150
30000	750	102,5/2600	2/50	8/200	6/150
32000	800	108,5/2760	2/50	8/200	6/150
34000	850	115,5/2930	2/50	8/200	6/150
36000	900	122/3100	2/50	8/200	6/150
38000	950	128,5/3260	2/50	8/200	6/150



5. Remove the protective release plastic from the coated sleeve. Center sleeve over the weld so it is evenly overlapping adjacent pipe coating. Wrap loosely around pipe so that the Raychem logo runs circumferentially around the pipe.

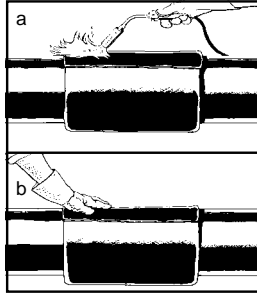
Note:

- 1) Clean overlap area of the sleeve to remove dirt and other foreign materials.
- 2) Edges of sleeve should extend 2" or more onto adjacent pipe coating.
- 3) Overlapping ends of sleeve should align evenly.
- 4) Position overlap to permit easy access for installing closure.

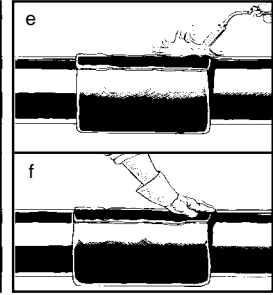
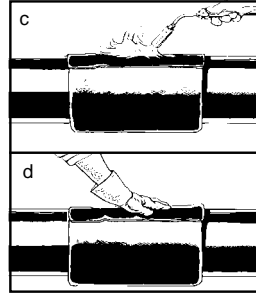


WPCP IV closure application

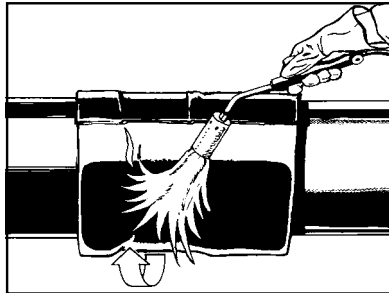
1. Press WPCP IV closure in position, centering over the exposed sheet end. (For UNI-sleeve products, the closure is preattached and already centered in position.) The sheet should overlap the sheet (excluding closure) by 2" (50mm) minimum.



2. Using a Raychem torch (or equivalent), adjust flame length to approximately 20" (500 mm) to produce a yellow flame. Using the yellow portion of the flame, heat the closure evenly until the pattern of the fabric reinforcement is visible.

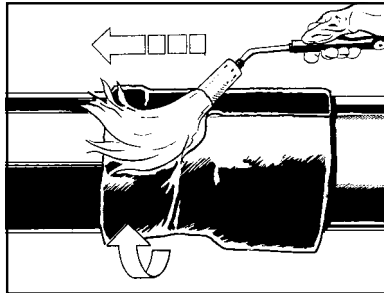


With gloved hand, pat down the closure and smooth any wrinkles by gently working them outward from the center of the closure.



Sleeve recovery

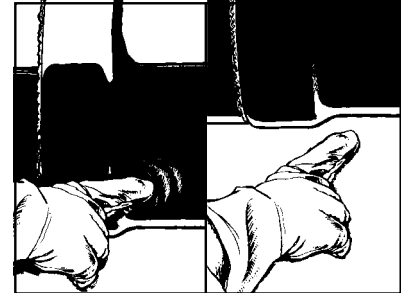
1. Using the Raychem torch (or equivalent), begin at the center of the sleeve and heat circumferentially around the pipe, using a constant paintbrush motion.



2. Continue heating toward one end of the sleeve, followed by the other.

Note:

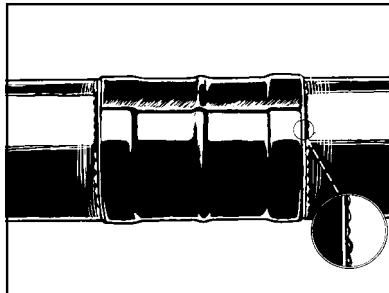
Sleeve may be recovered starting at one end and proceeding toward the opposite end, depending on conditions (i.e., wind).



3. During shrinkdown, occasionally check adhesive flow with finger. Wrinkles should disappear automatically.

Note:

While sleeve is hot, press or roll overlap and closure area to remove any air voids.



4. Sleeve is fully recovered when all of the following have occurred:

- 1) There are no cold spots or dimples on the sleeve surface.
- 2) Weld bead profile can be seen through the sleeve.
- 3) After sleeve is cool, mastic flow is evident on both edges.
- 4) The sleeve has fully conformed to the pipe and adjacent coating.

* WPC is a trademark of Tyco.

Tyco
Adhesives
Corrosion Protection Group
www.TycoAdhesives.com

Headquarters:
Tyco Adhesives
1400 Providence Hwy
Norwood, MA 02062 USA
Int'l Tel: +1 781 440-6161
US Toll Free: +1 800 248-0149
Fax: +1 781 440-6271
E-mail: CPG@TycoAdhesives.com

In Europe, Middle East, Africa,
Asia & Pacific:
Tyco Adhesives B.V.B.A.
Nieuwlandlaan B15
B-3200 Aarschot, Belgium
Tel: +32 16 55 36 00
Fax: +32 16 55 36 74
E-mail: CPG@TycoAdhesives.com

In the Americas:
Tyco Adhesives L.P.
1675 Suite C Brandywine Avenue
Chula Vista, CA 91911 USA
Tel Mexico: +52 (66) 23-34-33
Tel US: +1 (619) 4 24 42 59
Fax Mexico: +52 (66) 23-64-63
Fax US: +1 (619) 4 24 42 58
E-mail: CPGTJ@TycoAdhesives.com