

PRESSURE TESTING

FLANGES AND SCREW PLUGS

LEAD SHEATH AND SLEEVES

NOTES CONCERNING THIS ADDENDUM

This addendum supplements Section G73.105.2 with additional instruction for placing F valves and screw plugs in C flanges and modifies instructions covering installation of B Screw Plugs. It is being reissued to conform to Issue 2 of the main section.

The following paragraphs should be marked "See Addendum" and treated as indicated.

- Paragraph 3.04 (14) - Added
- Paragraph 4.02 - Replaced

3. FLANGES

- 3.04 (14) In order to avoid cracking the flange or solder joint, the flange should be permitted to cool and the valve or screw plug turned down only to a reasonable snug fit.

4. B SCREW PLUG

- 4.02 To install the B Screw Plug proceed as follows:

- (1) As soon as the testing operations have been completed, remove the pressure testing clamp and allow gas to escape for approximately one minute. Place a B Screw Plug in the drilled hole so that all of the pressure in the sleeve is not allowed to escape. This may be done by screwing the plug slightly below the surface of the sleeve and peening the edge of the hole over with a small hammer.

- (2) Clean the area approximately one inch around the plug and apply stearine. Cut a 1/2 to 3/4 inch round or square hole in a 2 inch square of cable paster and center it over the B screw plug.
- (3) Tin the exposed area with solder and a soldering copper of medium heat. Add a small amount of solder and float a smooth patch over the tinned area. Remove the paster and soap the soldered area to test the tightness of the solder seal.
- (4) Care should be taken during soldering operations to prevent unnecessary contact between the heated soldering copper and the B screw plug as overheating may melt the threads in the sleeve allowing the plug to drop, or if the pressure is great enough, gas may escape through the molten solder causing small leaks that are difficult to seal.