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HDPE LINED STEEL PIPE SPECIFICATIONS [BRIEF SUMMARY]

Steel Pipes are to conform to SANS 719

Pipe spools are to be of standard 6 m, 9 m or 12 m lengths and flange jointed on site. The specifying engineer is to define the exact face to face dimensions.

HDPE Liners are to be extruded pipe to SDR 41 conforming to SANS 4427.

HDPE material shall be PE 100 and certified 100 % virgin material.

HDPE Material shall be subjected to CPT tests prescribed by the customer, i.e. MFR, OIT & Tensile tests.

HDPE stubs are to be made of the same material as the liners and the MFR to be 0,2 to 0,25

Pipe liner ends are to be stub flanged, allowing jointing by sandwiching stubs between steel flanges.

HDPE stubs shall be made to accommodate **sealing O-rings and retainer steel rings** to prevent compaction of stub ends, usually 23mm thick, or the thinner **GRAMOPHONE** finish HDPE stub end. Usually, 15mm thick. The latter are also used with recess flanges.

Stubs are to be butt welded to liner pipes to the DVS 2207T1 or ISO 21307-2011 procedure.

Both internal and external weld beads are to be removed, not reducing liner wall thickness.

Liners are to be fitted with suitable circumferential interference to be approved by the specifying engineer and recorded during manufacturing process.

Longitudinal pre- stretch must be introduced, sufficient to overcome thermal expansion according to maximum and minimum temperatures. Such pre-stress must not exceed material yield corresponding to a tensile stress value acceptable to the specifying engineer.

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The liners in lined pipes must be fully retracted, i.e. the rear face of the stub abutting snugly to the steel pipe flange. At no time prior to installation must a liner stub face show signs of expanding causing a gap between these faces.

HDPE stubs must be prevented from expanding radially when under compression created by tightening of steel flanges, by making use of an outer steel ring.

The jointing system must be such that it would not require continuous re-torquing of flange bolts.

Regards

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