

### Material

Code	AISI	EN	Sheet	Bolts
R	304	1.4301	Cold-rolled, pickled, surface 2B	A2
A	316L	1.4404	Cold-rolled, pickled, surface 2B	A4

### General

Weldings are made according to DS/EN ISO 5817 level C.

The sheet material is covered by plastic film as protection against scratches etc. during the manufacturing.

Round flange connections are made cf. fig. 1 or 2.

Square and rectangular flanges are made cf. fig. 2.

Flange connections are sealed with silicone filler.

Doors, hatches etc. are sealed with silicone cell rubber.

	Method 1	Method 1.1	Method 2
<b>Flange connections:</b>	<p>Dia. ≤ ø3200 mm are made cf. to fig. 1 or 2.</p> <p>Dia. &gt; ø3200 mm are made cf. fig. 2.</p>	<p>Dia. ≤ ø3200 mm are made cf. to fig. 1 or 2.</p> <p>Dia. &gt; ø3200 mm are made cf. fig. 2.</p>	<p>If possible flange connections are avoided. If not they will be made as follows:</p> <p>Dia. ≤ ø3200 mm are made cf. to fig. 1 or 2.</p> <p>Dia. &gt; ø3200 mm are made cf. fig. 2.</p>
<b>Connection to the tube sheet:</b>	-	-	Cf. fig 3
<b>Welding method inside:</b>	MIG and/or TIG. <sup>2)</sup>	TIG. <sup>3)</sup>	TIG.
<b>Finish inside:</b>	Weld spatter is removed. Dip pickling or weldings are pickled or ground to Ra 2.	Dip pickling or pickling of weldings.	Weld seams are ground to Ra 0,8 in belts.
<b>Welding method outside:</b>	MIG and/or TIG. <sup>2)</sup>	Butt welds: TIG. Fillet welds: MIG.	MIG and/or TIG. <sup>2)</sup>
<b>Finish outside:</b>	Weld spatter is removed. Dip pickling or weldings are pickled or ground to Ra 2.	Weld spatter is removed. Dip pickling or weldings are pickled.	Weld spatter is removed. Weldings are ground in belts.
<b>Inlet design:</b>	Please see fig. 4	Please see fig. 4	Please see fig. 5

<sup>1)</sup> AESTEX ePTFE - Gasket Sealing Tape can be provided at an extra charge.

<sup>2)</sup> Simatek choose the method.

<sup>3)</sup> Welded outside with back purge gas and full penetration or welded inside.

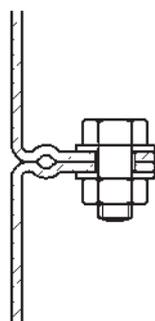


Fig. 1. Flange connection with beaded flanges.

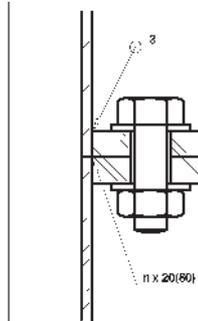


Fig. 2. Flange connection with welded flanges.

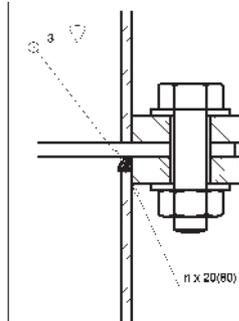


Fig. 3. Connection to the tube sheet method 2.

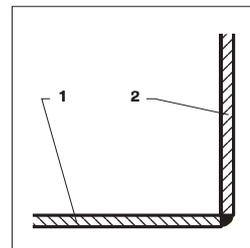


Fig. 4. Detail of inlet based on method 1 and 1.1.  
1: Bottom/top plate.  
2: Curved back plate.

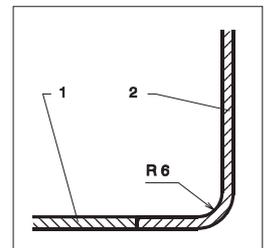


Fig. 5. Detail of inlet based on method 2.  
1: Bottom/top plate.  
2: Curved back plate.