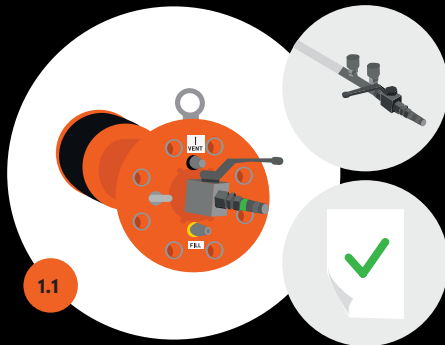


Flange weldtest tool (tyre type) instruction card



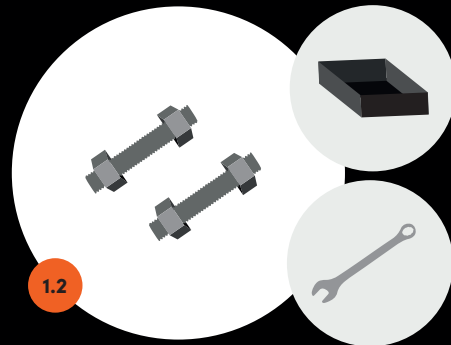
1. check that the set is complete before starting assembly



1.1

delivered as standard

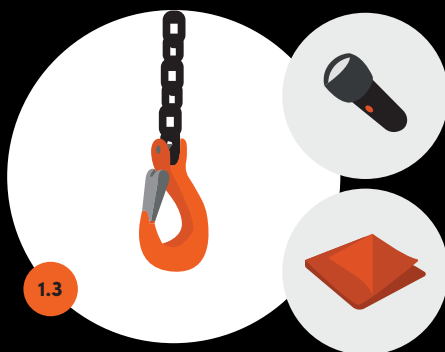
- 1x certificate
- 1x instruction card
- 1x flange weldtest tool
- 1x pump
- 1x connector hose including one or more pressure gauges



1.2

not delivered as standard

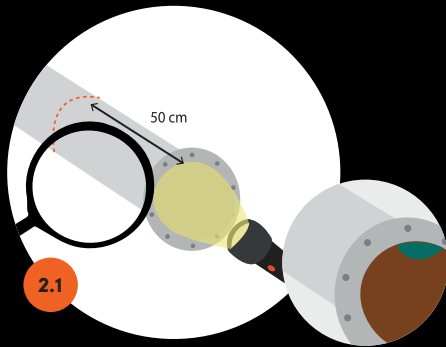
- 1x gasket
- 1x drip tray
- water
- 1x set of stud bolts
- 1x set of open-ended/ring spanners
- 1x degreasing agent



1.3

- 1x cloth
- 1x pocket torch
- 1x crane or block and tackle for hoisting (optional)
- adapters for additional measuring instruments (optional)

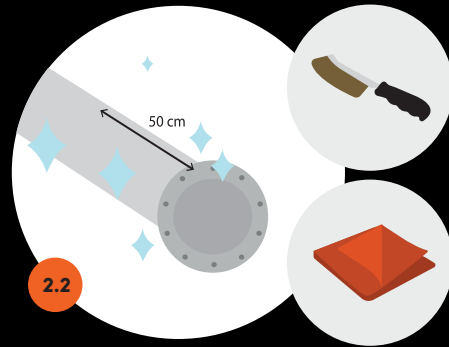
assembly keep out of the line of fire at all times



2.1

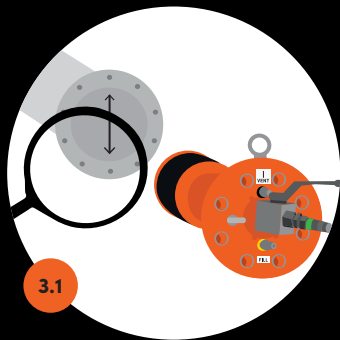
2. access the pipe

Check the inside of the pipe to see if corrosion or residues are present



2.2

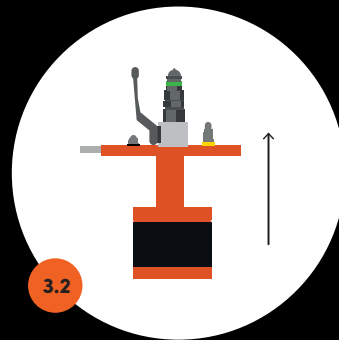
Clean and degrease the pipe if necessary



3.1

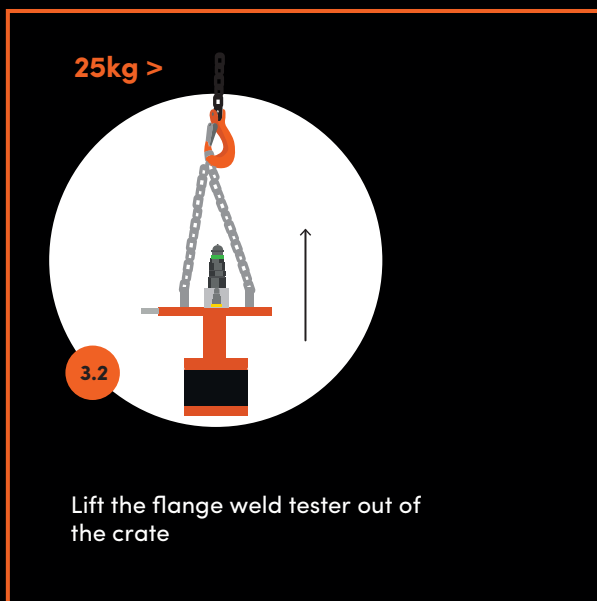
3. place the flange weld tester in the pipe

Check that the stated dimensions of the pipe match the flange weld tester's specifications



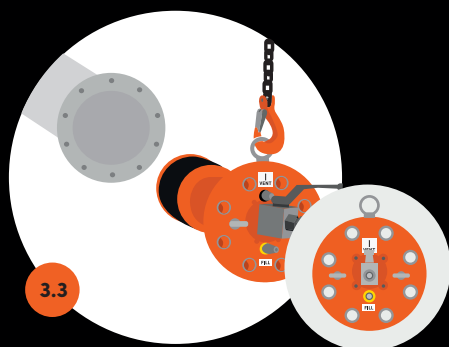
3.2

Lift or hoist the flange weld tester out of the crate



3.2

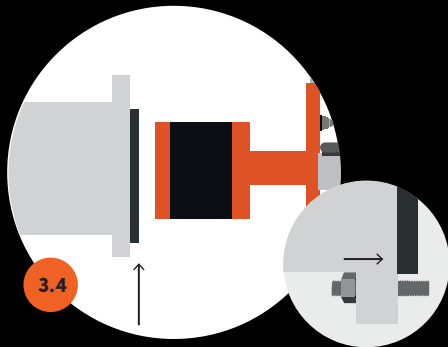
Lift the flange weld tester out of the crate



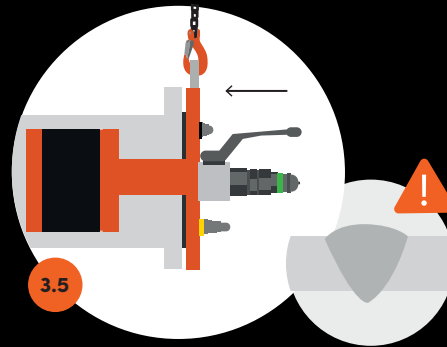
3.3

Position the flange weld tester in front of the pipe with the "vent" marker pointing upwards

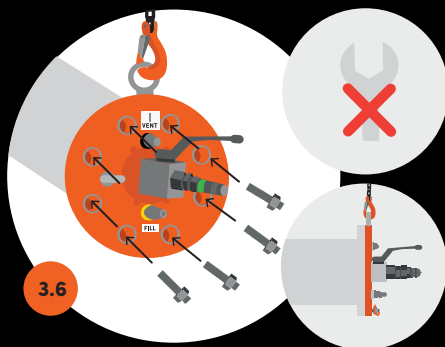
assembly



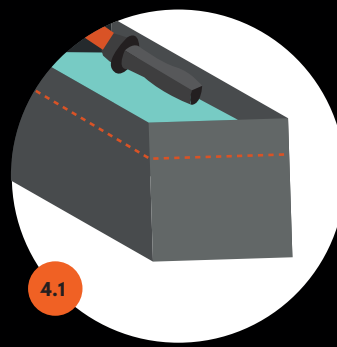
3.4 Place the gasket between the flange weld tester and the flange face. Use two stud bolts to support the gasket if necessary



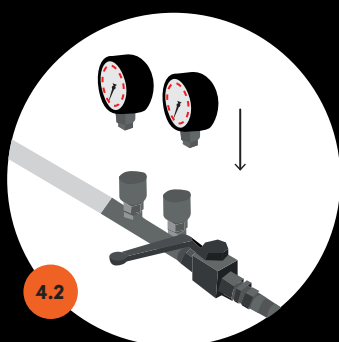
3.5 Hoist or slide the flange weld tester into the pipe up against the flange. Allow for any weld penetration that may be present



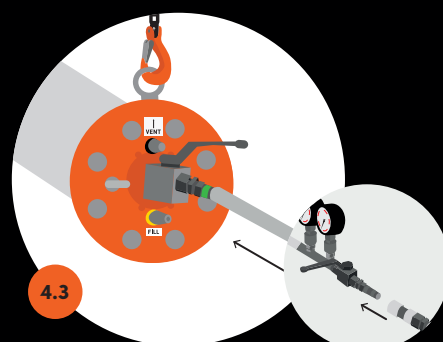
3.6 Centre the flange weld tester in front of the flange face by putting stud bolts in place and tightening them manually



4.1 **4. connect up the accessories**
Fill the pump with water

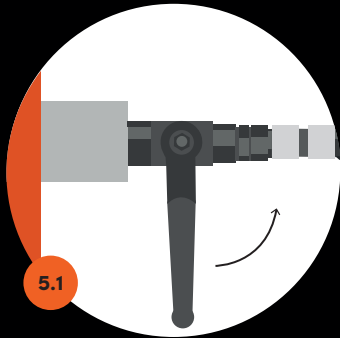


4.2 Attach the pressure gauge (or gauges) to the connecting hose



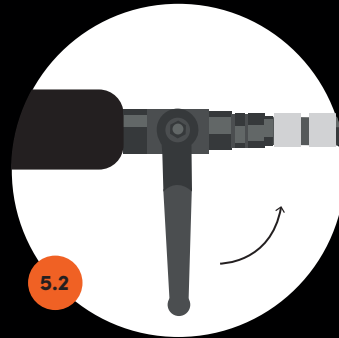
4.3 Connect the connecting hose to the pump and to the tyre connection. Close the pump's return valve

assembly



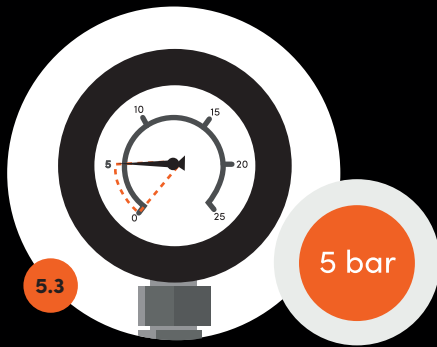
5.1

5. centre the flange weld tester
Open the stop valve of the **tyre** connection



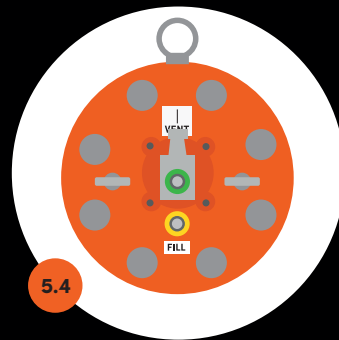
5.2

Open the stop valve of the connecting hose



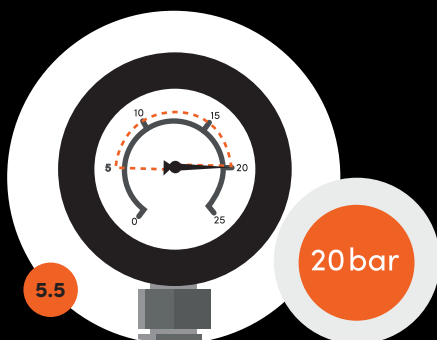
5.3

Pump the **tyre** up to **5 bar** water pressure



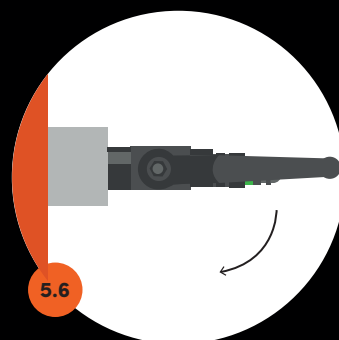
5.4

Tighten the stud bolts in a diagonal



5.5

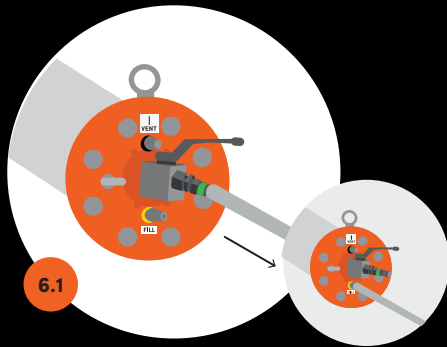
Pump the **tyre** up to **20 bar** water pressure



5.6

Open the stop valve of the **tyre** connection and open the pump's return valve

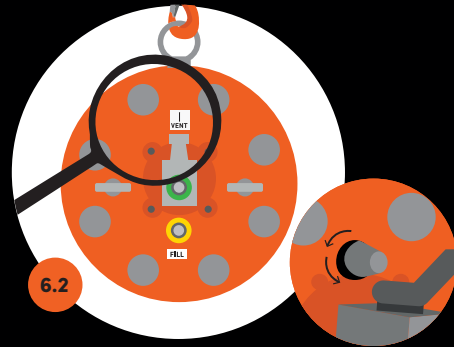
assembly



6.1

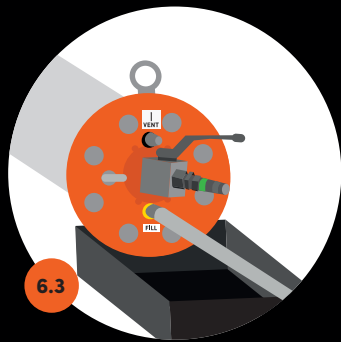
6. bleed the test chamber

Disconnect the connecting hose from the **tyre** connection and attach it to the **fill** connector. Close the pump's return valve



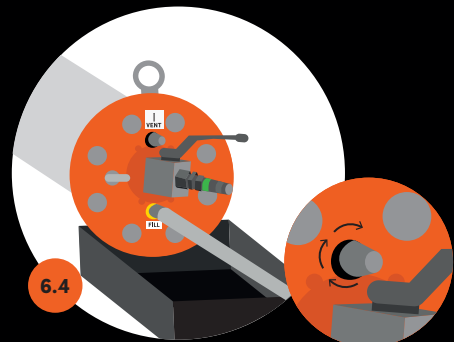
6.2

Open the **vent** connection by two turns



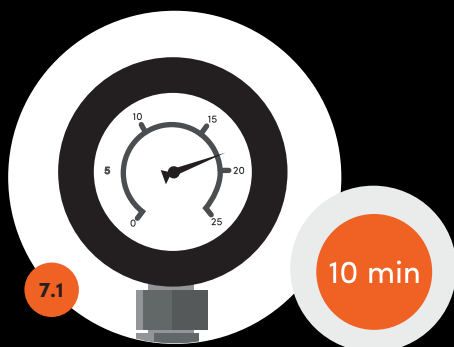
6.3

If water has to be collected, put the drip tray under the pipe



6.4

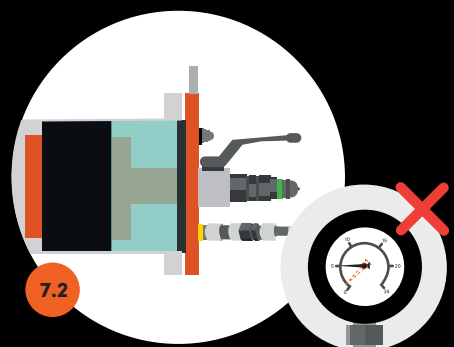
Pump until water comes out of the **vent** connection. Keep pumping until you get a second person to close the **vent** connection gradually in the meantime



7.1

7. carry out the pressure test

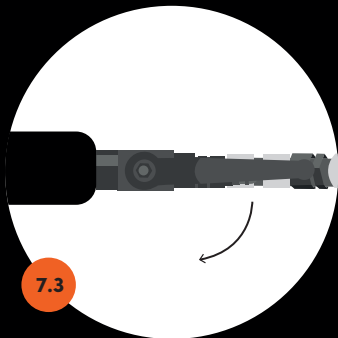
Pump the test chamber up to the required test pressure and wait for about 10 minutes



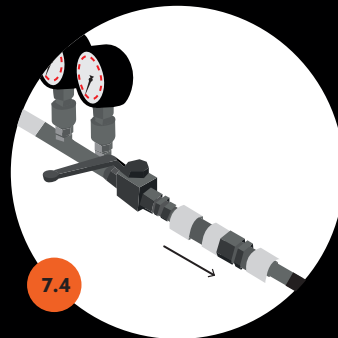
7.2

Pump extra water into the test chamber if the stabilization pressure turns out to be less than the desired test pressure

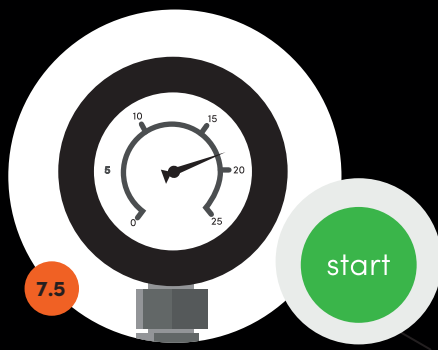
assembly



7.3 Close the stop valve of the connecting hose

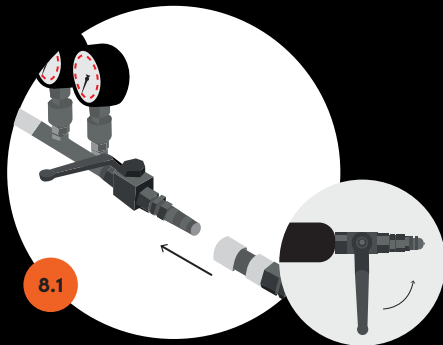


7.4 Open the pump's return valve and remove the pump



7.5 Start the pressure measurement

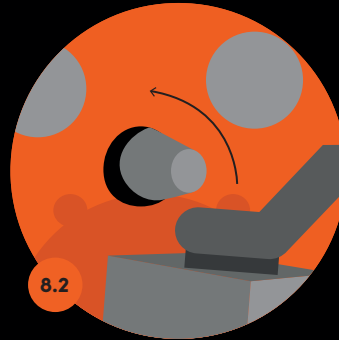
disassembly



8.1

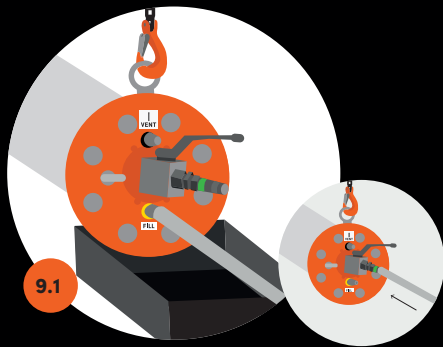
8. release the water pressure from the test chamber

Connect the pump to the connecting hose. Open the stop valve of the connection hose and open the pump's return valve



8.2

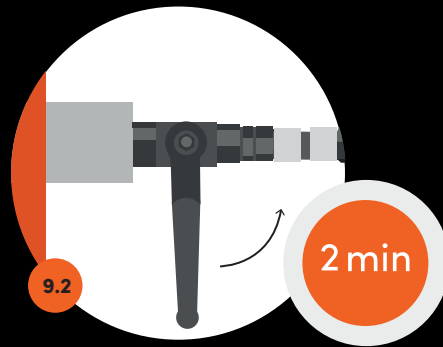
Open the vent connection



9.1

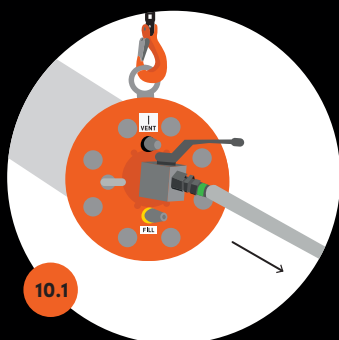
9. release the water pressure from the tyre

Place the drip tray under the pipe and connect the connecting hose to the tyre connection



9.2

Open the stop valve of the tyre connection and wait for at least 2 minutes



10.1

10. remove the flange weld tester

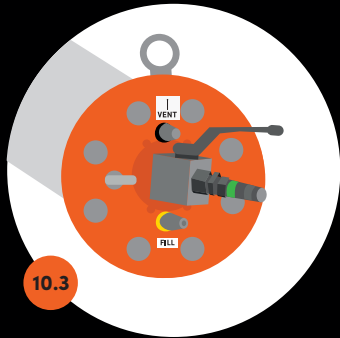
Remove the connecting hose from the tyre connection



10.2

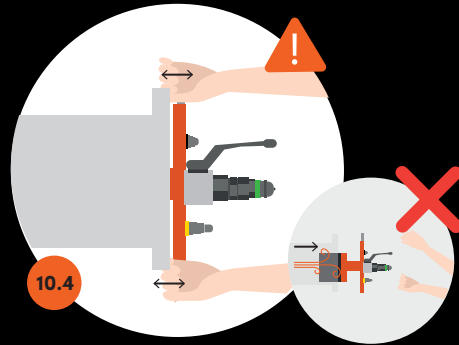
Remove the connecting hose from the pump and disconnect the pressure gauge (or gauges)

disassembly



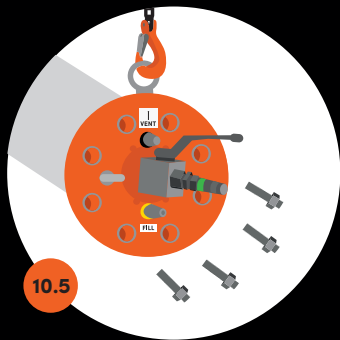
10.3

Loosen the stud bolts several turns



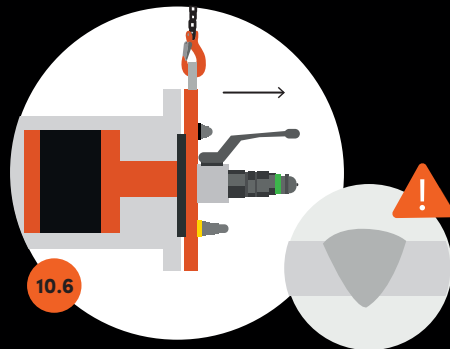
10.4

Check that the flange weld tester can be moved. Note: there is a risk of back pressure here!



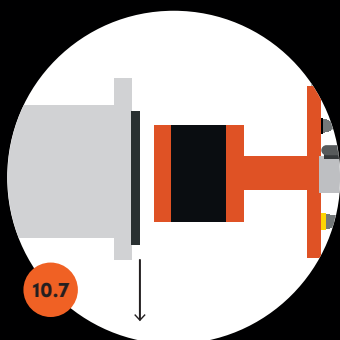
10.5

Remove the stud bolts



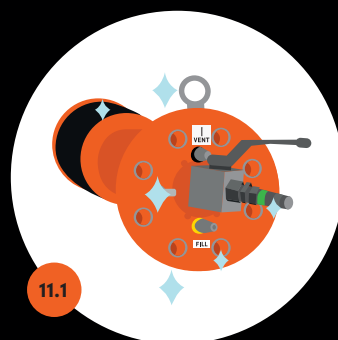
10.6

Hoist or lift the flange weld tester out of the pipe. Watch out for any weld penetration



10.7

Remove the gasket



11.1

11. clean the flange weld tester
Clean the flange weld tester