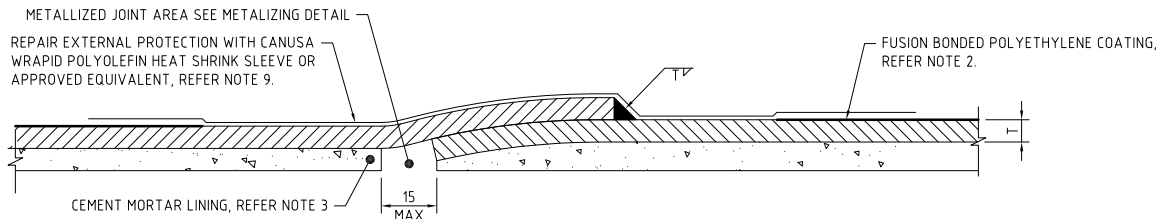
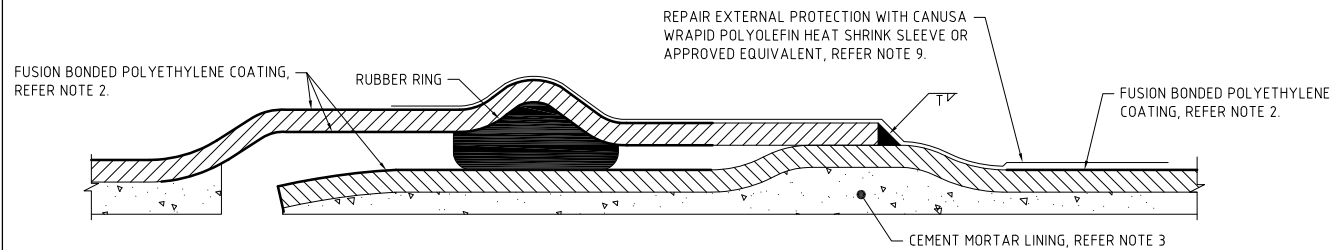


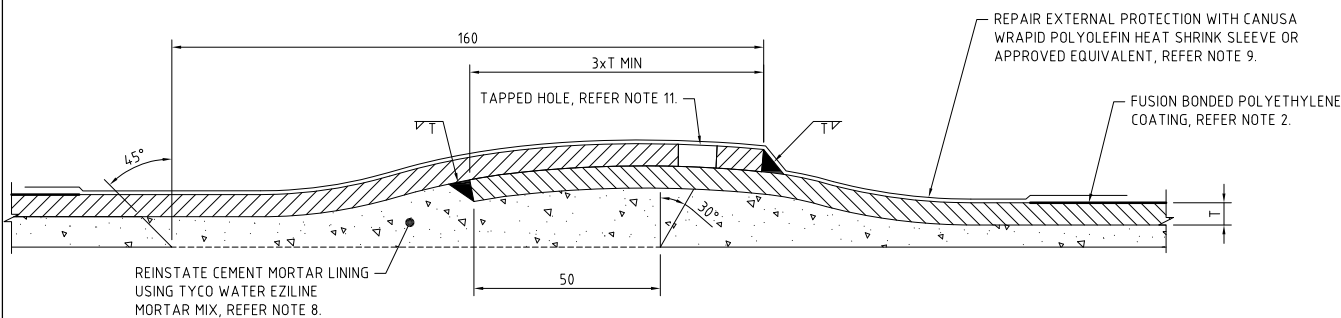
A1



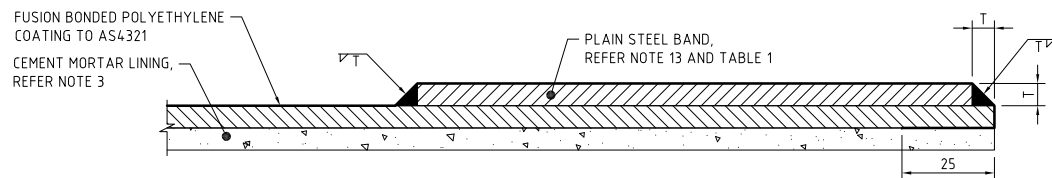
× MAXIMUM WALL THICKNESS OF 12mm  
**SPHERICAL SLIP IN WELDED JOINT DN300-DN750**  
SCALE 1:1



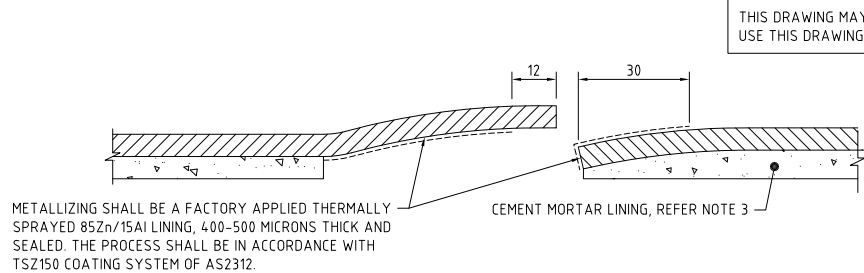
× MAXIMUM WALL THICKNESS OF 10mm (≤ 10mm)  
**SOCKET WELDED END**  
SCALE 1:1



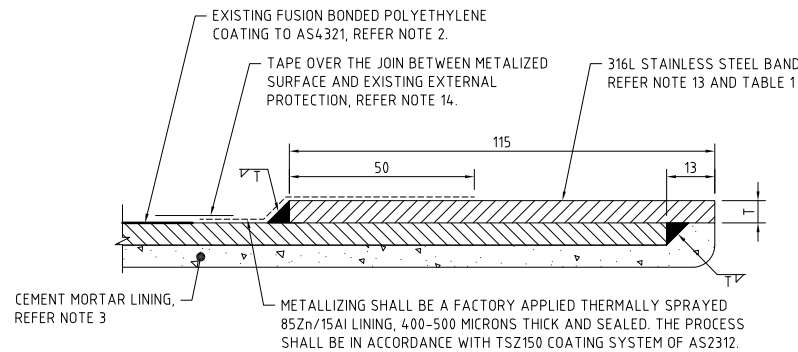
**BALL AND SOCKET JOINT DN900-DN1200**  
SCALE 1:1



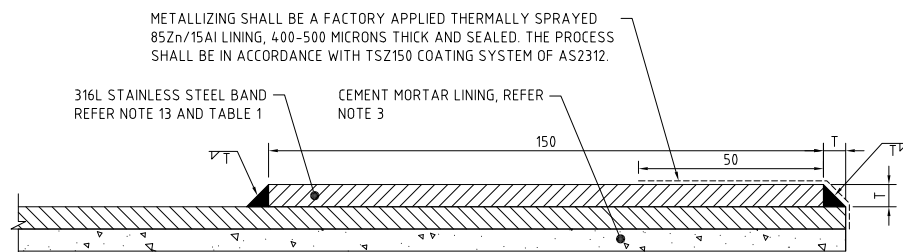
**STEEL SPIGOT BAND FOR CONNECTIONS TO DCL SOCKET (RUBBER RING JOINT)**  
SCALE 1:1



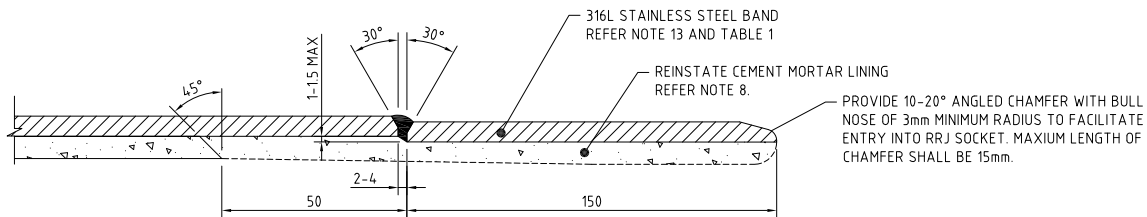
**METALLIZING DETAILS OF SLIP-IN JOINT TYPE**  
SCALE 1:1



**STAINLESS STEEL SPIGOT BANDS FOR DISMANTLING JOINTS**  
SCALE 1:1



**STAINLESS STEEL SPIGOT BAND FOR CONNECTIONS TO DCL SOCKET (RUBBER RING JOINT)**  
SCALE 1:1  
(SUITABLE ONLY WHERE USED IN CONCRETE ENCASEMENT)



**\*INLINE SPIGOT BAND FOR CONNECTION TO DCL RRJ SOCKET FOR DN450 DCL/DN508 SCL & DN500 DCL/DN559 SCL ONLY**  
SCALE 1:1  
(SUITABLE ONLY WHERE USED IN CONCRETE ENCASEMENT)

**NOTES:**

- ALL DIMENSIONS IN MILLIMETRES UNLESS NOTED OTHERWISE.
- EXISTING FUSION BONDED POLYETHYLENE SHALL BE CUT BACK 100 TO 125 mm FROM INTENDED WELD SITE. POLYETHYLENE COATING TO COMPLY WITH AS4321.
- INTERNAL CEMENT MORTAR LINING SHALL BE IN ACCORDANCE WITH AS 1281 AND SHALL FINISH AS CLOSE AS POSSIBLE TO THE END OF THE PIPE WHILE MAINTAINING THE ALLOWANCE FOR MAXIMUM DEFLECTION OF THE JOINT AS SPECIFIED BY THE MANUFACTURER. MAXIMUM GAP BETWEEN CEMENT MORTAR LINING TO BE 15mm.
- CARE IS TO BE TAKEN WHEN INSTALLING PIPE, DAMAGE TO THE PIPE COATING IS TO BE REPAIRED AS PER MANUFACTURERS GUIDELINES.
- ALL SPIGOT BANDS TO BE FACTORY MANUFACTURED.
- ALL WELDS SHALL BE GROUND FLUSH WITH EXTERNAL SURFACE AND SHARP EDGES TO BE REMOVED.
- FILLET WELDS SHALL BE CONTINUOUS. MINIMUM LEG LENGTH SHALL BE 5mm.
- CEMENT MORTAR LINING TO BE REINSTATED IN ACCORDANCE WITH AS1281, OR WITH PENTAIR EZILINE MORTAR MIX STRICTLY IN ACCORDANCE WITH MANUFACTURERS REQUIREMENTS, OR APPROVED EQUIVALENT. AT THE TIME OF APPLICATION OF THE MORTAR, THE SURFACE OF THE PIPE OR FITTING SHALL BE FREE OF LOOSE RUST, LOOSE MILL SCALE, DIRT, DEBRIS, OIL, GREASE AND OTHER DETRIMENTAL MATERIAL.
- HEAT SHRINK SLEEVE TO EXTEND A MINIMUM OF 100mm EITHER SIDE OF EXPOSED PIPE SURFACE, AND TO BE INSTALLED IN ACCORDANCE WITH MANUFACTURERS SPECIFICATIONS.
- WELDING PROCEDURE SPECIFICATION AND WELDERS SHALL BE QUALIFIED IN ACCORDANCE WITH AS4041.
- PROVIDE A 5mm TAPPED HOLE TO RELEASE GASES DURING WELDING AND FOR PRESSURE TESTING. PLUG HOLE WITH 5mm GRUB SCREW AND GROUND FLUSH AFTER PRESSURE TESTING.
- PLAIN STEEL SPIGOT BAND SHALL BE GRADE 250 TO AS3678.
- DESIGNED FOR MAXIMUM:
  - 120m HEAD OPERATING PRESSURE
  - 150m HEAD TEST PRESSURE
- WHERE METALLIZING MEETS EXISTING FUSION BONDED POLYETHYLENE COATING, TAPE ALONG THE JOIN USING DENSO PETROLATUM TAPE SYSTEM OR APPROVED EQUIVALENT. EXTENDING 50mm MINIMUM EITHER SIDE OF JOIN.

TABLE 1 - SPIGOT BAND DIMENSIONS FOR CONNECTION TO DI SOCKET				
DICL DN	DICL OD	SCL OD	STEEL BAND T	FBPE COATED SCL T
(mm)	(mm)	(mm)	(mm)	(mm)
100	122	114	4	N/A
150	177	168	4	N/A
200	232	219	6	4
250	286	273	6	4
300	345	324	10	8
300	345	337	4	N/A
375	426	406	10	8
375	426	419	4	N/A
450	507	508	6*	N/A
500	560	559	6*	N/A
600	667	660	3	N/A
750	826	813	6	4

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**WATER**

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APPROVED

PETER GILLMAN  
MANAGER E & ES

ENGINEERING & ENVIRONMENTAL SERVICES

A

ORIGINAL ISSUE

LETTER

DETAILS OF ISSUE / AMENDMENT

PJG

01/03/13

APP'D

DATE

DEEMED TO COMPLY DRAWINGS

STEEL WATER MAINS 150 < DN ≤ 1200

STEEL PIPE JOINTING

**DTC**

**1150**

ISSUE

**A**

DATE

**01/03/13**