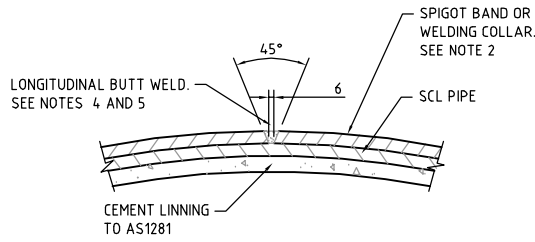
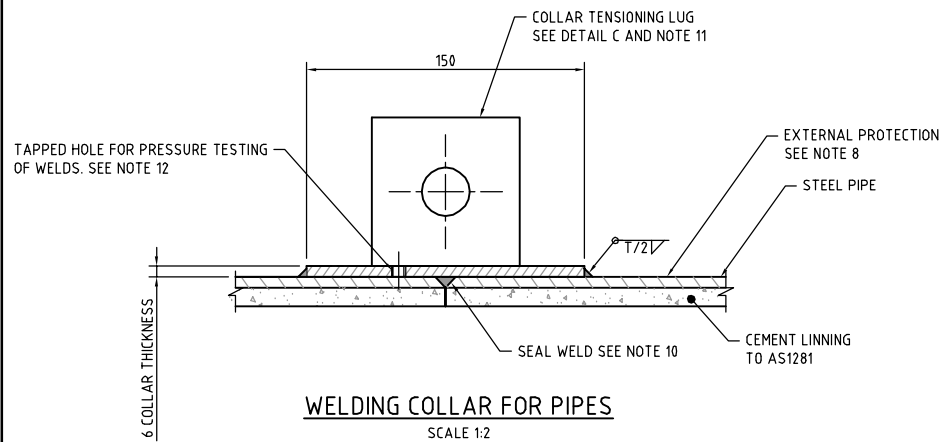


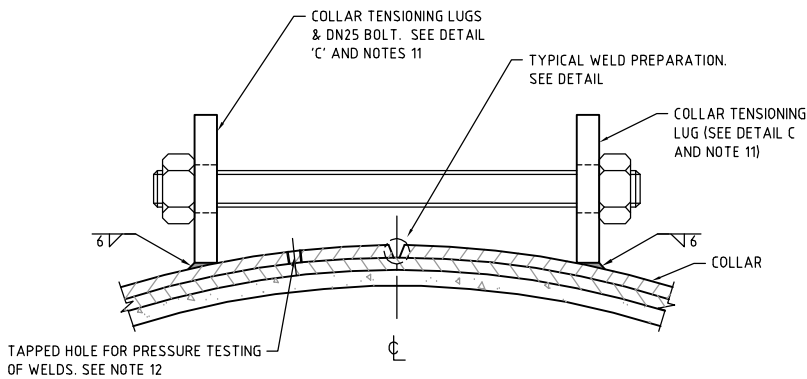
STAINLESS STEEL SPIGOT BAND  
SCALE 1:2



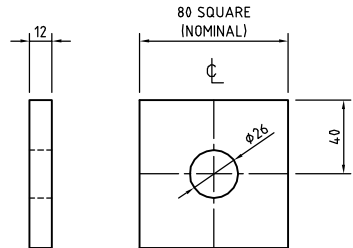
TYPICAL WELD PREPERATION  
SCALE 1:2



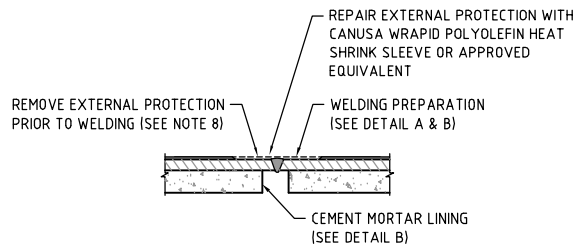
WELDING COLLAR FOR PIPES  
SCALE 1:2



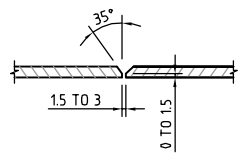
VIEW OF WELDING COLLAR IN WELDING POSITION  
SCALE 1:2



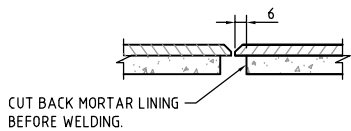
DETAIL C  
COLLAR TENSIONING LUG  
SCALE 1:2



BUTT WELD FOR PIPES  
(WELDED FROM OUTSIDE ONLY)  
SCALE 1"2



DETAIL A  
BUTT WELD PREPARATION FOR PIPES  
SCALE 1:2



DETAIL B  
CEMENT LINING PREPARATION  
SCALE 1:2

STAINLESS STEEL SPIGOT BAND DIMENSIONS FOR CONNECTION TO DICL SOCKET TO AS2280 (SEE NOTES 3 & 6)				
DICL	DICL	STEEL PIPE	SPIGOT BAND	SPIGOT BAND
PIPE SIZE DN	OUTSIDE DIAMETER OD	OUTSIDE DIAMETER Do	OUTSIDE DIAMETER SO	PLATE THICKNESS T
100	122	114	122	4
150	177	168	178	4
200	232	219	232	6
250	286	273	286	6
300	345	324	345	10

NOTES:

1. ALL DIMENSIONS IN MILLIMETRES UNLESS NOTED OTHERWISE.
2. STAINLESS STEEL SPIGOT BANDS SHALL BE GRADE 316L IN ACCORDANCE WITH AS 3678.
3. WELDING COLLARS SHALL BE GRADE 250 TO AS3678.
4. BANDS TO BE WELDED TO PIPE WITH CONTINUOUS FILLET WELDS. MINIMUM LEG LENGTH 5.
5. GRIND ALL WELDS FLUSH WITH EXTERNAL SURFACE AND REMOVE ANY SHARP CORNERS TO PREVENT ANY DAMAGE TO RUBBER RING.
6. WELDING TO BE IN ACCORDANCE WITH AS/NZS 1554.1 CATEGORY SP AND AS/NZS 1554.6 FOR WELDING OF STAINLESS STEEL TO STEEL.
7. NO JOINT DEFLECTION ALLOWED WHERE BUTT WELDING AND WELDING COLLARS ARE USED.
8. CUT BACK COATINGS AT LEAST 100 FROM NEAREST ASSEMBLY WELD.
9. ALL WELDING TO BE FULL PENETRATION BUTT WELDS CARRIED OUT AND TESTED IN ACCORDANCE WITH AS/NZS 1554.1 CATEGORY SP.
10. SEAL WELD TO CONSIST OF A SINGLE CONTINUOUS WELD BEAD AROUND PIPE AND TO BE GROUND FLUSH WITH PIPE OD PRIOR TO FITTING COLLAR.
11. REMOVE BOLTS & WELDING LUGS AFTER COLLAR HAS BEEN WELDED. GRIND FINISHED SURFACES FLUSH.
12. PROVIDE A TAPPED HOLE TO ALLOW THE GAP UNDER THE COLLAR TO BE PRESSURISED TO CONFIRM COMPLETE WELDING INTEGRITY.