



INCOLOY 800HT

Reformer Pigtail Welding

In December of 2012, Langfields were contacted to discuss the possibility for the supply of Welding personnel to carry out manual and Orbital welding operations on Incoloy 800HT reformers.



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BACKGROUND

Langfields had manual Weld Procedures to ASME IX. Orbital procedures needed to be developed. Langfields produced weld procedures for Butt welds and pipe to socket welds.

SCOPES

Five new pigtails were welded into the plant (5 butts & 5 Socket welds). In April of 2015, Langfields were contacted to carry out the Site welding of 14 off new pigtails at the same existing plant. Issues were found once NDE had been completed. Due to these issues, Langfields and the client purchased welding equipment to allow 160 off butt welds and 160 off socket joints to be completed. As this was considered to be a repair, twelve months later, we carried out a further 160 off butts & 160 off sockets.

To complete the above work scope Langfields qualified Weld Procedures 764 (ASTM B407 N08811, 48.3mm dia x 7.94mm thk, joints welded in ASME IX 2G position). Thirteen weld passes were required to complete one butt weld. Langfields Weld Procedure 765 was used for the socket welds eighteen off weld passes required. Langfields trained eight welders qualified to ASME IX to complete the above.

In October 2018 Langfields attended the same Site again to carry out 160 off butt & 160 off socket welds. Due to down time of the plant. Langfields modified the weld preparation to reduce the weld passes from 13 to 8, which had a large time saving. The main issue was the Interpass temperature for the welding operations, however due to the weld pass reduction, significant reductions in time was made. The number of welders was also increased from 4 Orbital welders per shift to 8. All welders were trained at Langfields Salford facility.

KEY FACTS

▶ LANGFIELDS ACCREDITATIONS

ISO 9001-2015

PED

ISO 3834-2

EN1090-1

ISO 14001/45001.

Langfields has a long-established history in the welding of Stainless Steels, Duplex Steels, High Nickel Alloys and Reactive materials. Langfields now have a large work force that can mobilise as required for large Welding contracts in the UK & overseas. In 2017 Langfields qualified and mobilised thirty-eight welders to the middle East for a project. From our facilities in Salford and Dunfermline, Langfields have an extensive team of specialists that are there to support our clients to deliver complex welding solutions in some of world's most challenging environments.

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