



Handling and Installation of ALFA Monolithic Isolation Joints

Isolation Joints are designed for direct welding into the pipeline by qualified welders using approved procedures, please review the following notes before installation:

1. Handling

- 1.1 The isolation joints should be treated carefully during handling and transportation to prevent any mechanical damage or deformation
- 1.2 Extra care should be taken not to damage the internal and external coating
- 1.3 Any protective material or foreign material must be removed a distance of 1" to 1 ¼" from the weld ends, both internally and externally before welding. This includes any oil or other contaminating material that could affect welding
- 1.4 Inspect bore for any foreign materials and clean if necessary
- 1.5 Be mindful when lifting or moving the isolation joint to support the joint well with strapping on both sides of the hub

2. Overheating

- 2.1 Do not preheat the isolation joint central body for any reason
- 2.2 During welding of the joint's end to the pipeline's end, do not allow the temperature of the body to rise above 212 F° (100 C°)
- 2.2 In case stress relieving of the welding is required do not allow the temperature of the body to rise above 212 F° (100 C°)

3. Indications

- 3.1 Use a thermal crayon or adequate thermocouple to verify the temperature on the body or the temperature near to the pipe stub
- 3.2 If the temperature approaches 212 F° (100 C°) cool the body using damp rags or compressed air
- 3.3 Stop welding or stress relieving until temperature is below 212 F° (100 C°)

4. Important Notes

- 4.1 The joint's body is an isolator, so the welding earth connection must be located on the joint pup where welding is performed. When switching sides make sure to move earthing electrical terminal to the same side the weld is made. This avoids damage to dielectric materials in the joint
- 4.2 The temperature limits on the body of the joint are required to protect the seal gaskets, isolating rings, epoxy cured resin and the coatings
- 4.3 Be careful not to hit joint, the resin and gaskets are sensitive to hard impacts and could break

4.4 Make sure that there are no stresses on the joint (both longitudinally and transversally)

4.5 There is no preferential installation direction in regards to the fluid direction. Joint can be installed horizontally or vertically

a. When installing in the vertical orientation, care should be taken to position the joint so that the side with the "silicone filler" face downward

b. When installing in the horizontal orientation, care should be taken to support the isolation joint

4.6 If post weld heat treatment (PWHT) must be carried out after installation please contact us for instructions

4.7 Each joint is coated with a non-conductive epoxy coating and lining. The coating should remain on the joint to insure the insulating capability of the joint

4.8 Joints should be stored in a clean and dry environment

4.9 Joints may be shipped, wrapped in VCI (Volatile Corrosion Inhibitors), and/or coated with a corrosion inhibitor such as "RUST VETO 377". Care should be taken to remove wrapping and coating carefully before joints are used.

