WELDING & BRAZING INSTRUCTIONS

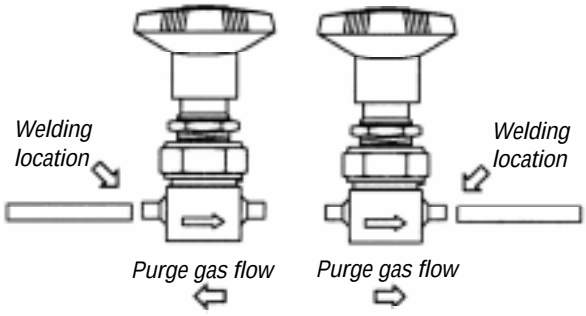
Welding should be done by qualified personnel as outlined in Section IX of the ASME Boiler Code.
Weld filler material should be the same as the base material.

Disassembly of the valve is **not** required for inline welding if proper precautions are taken. If valve disassembly is necessary, cover the sealing surfaces to protect them from nicks and weld spatter. Refer to product literature for maximum valve body temperature.

If the valve is to be welded **without disassembly:**

1. Use a heat sink, if necessary to prevent excessive heating of internal components. *With good orbital heat welding practices, the use of a heat sink may not be required.*
2. Make sure **valve is in the OPEN position** so a continuous flow of purge gas is maintained during welding. *Use a high quality purge gas to maintain cleanliness and reduce discoloration from welding.*
3. Connect purge gas to **exit out** of the valve port being welded. *It is important that heat from the weld is carried away from the valve, not into the valve.* (Fig. 1)
4. Perform the welding procedure.
5. After welding, purge the valve and system of scale, contamination, and dirt while still in the OPEN position and before cycling.
6. Test valve for leak-tight integrity and proper operation.

(Fig. 1)



PRECAUTIONS
High purity products should not be disassembled, if at all possible. If valve disassembly is necessary, all procedures should be performed in a clean environment to preserve product cleanliness.

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These instructions are also available in French, Italian, German and Spanish.