

## **Installation Instructions**



 Mounting factory supplied weld rings: Mount the factory supplied weld ring on the pipe end using the Shurjoint ring clamp, C-clamp or other device to secure and position the ring in place. Prior to welding make sure that the "L" dimension (the distance between the pipe end and the ring) is as specified for the coupling / pipe size.



Ring Clamp





2. Step one welding: First weld the butt ends of the ring together. Next tack weld the ring to the pipe at several locations. Remove the ring clamps or other positioning devices.



3-1. Step two welding: Determine the type of weld required, full or partial, depending on the intended system working pressure. Refer to page 13 for working pressures and full and partial welding information. Weld the ring to the pipe using the proper weld(s) for the intended service.

**Full & Partial Ring Welding:** The **Shurjoint** Model R-88 Ring Joint Coupling is supplied with factory weld rings and is designed for a variety of service and pressure applications. For lower pressure applications weld rings need not be fully welded around the entire circumference of the pipe. The table shows the minimum required weld length in inches or mm and corresponding working pressures. Working pressures are based on the use of applicable pipe wall thickness for the service pressure intended.

## Welding conditions:

Method: SMAW (Shielded metal arc welding)\* Electrode: Flux-cored electrode 3/32" (2.4mm) to 1/8" (3.2mm) Welding speed: 12" (300mm) to 16" (400mm) per minute Current: 110A – 160A Rotate pipe so that you can keep your electrode holder at the same

position.

\*GTAW or FCAW is also acceptable.



Full welding means both sides of the weld ring are fully welded around the circumference of the pipe. One side shall be referred to as the "Main Weld" and the other side as "Back Weld". Either side of the weld ring can receive the Main Weld.





**PRODUCT SPECIFICATIONS** 

**RING JOINT PIPING SYSTEM**