

Selection table Girth weld coatings

Girth weld straight joints – Selection table for Heat Shrinkable Products

By checking the appropriate parameters, you can easily select the proper product

Selecting the proper sleeve

Project specifications and local standards must be considered when specifying a shrinkable sleeve.

Next to these the following parameters must be considered for selecting the proper shrinkable sleeve:


- **Pipe Coating Type:**
f.i. Bitumen, Coal Tar Enamel (CTE), Cold Applied Tapes (CAT), Fusion Bonded Epoxy (FBE), PolyEthylene (PE), PolyPropylene (PP),...
- **Pipe Operating Temperature:**
0 - 120°C (0-248°F)
- **Pipe Operating Pressure:**
f.i. 100 mbar = 1,42 psi, >4 bar = 56.88 psi,...
- **Pipe Medium:**
f.i. Gas, water, oil,...
- **Pipe Diameter:**
f.i. 1" or DN25 for steel pipe, 160 mm jacket diameter for insulated steel pipe,...
- **Pipe Preparation:**
surface cleaning: f.i. abrading, brushing, gritblasting
obtainable preheat temperature: very low (20-40°C) (68-104°F), low (60-70°C) (140-158°F), high (80-100°C) (176-212°F), very high (230°C) (446°F)
- **Adverse Soil Conditions:**
stable: low soil stresses
unstable: shifting soil conditions, significant pipe motion relative to soil
- **Mechanical Resistance Heat-shrinkable Coating:**
medium (B): moderate impact and penetration resistance
high (C): high impact and penetration resistance
- **Pipe Laying Method:**
f.i.. Open Trench, Directional Drilling, Off-Shore
- **Climate conditions (Ambient Temperature during Sleeve Application):**
sea climate: not very cold - not very warm
land climate: very cold - warm
desert climate: very cold - hot

All of the above parameters affect the type of coating which will provide the best performance, ease of installation and value. The following selection tables will help you to decide which sleeve is right for your application.

Girth weld straight joints – Selection table for Heat Shrinkable Products

By checking the appropriate parameters, you can easily select the proper product

GIRTH WELD COATING

Max Pipe Operating Temp. °C / °F	Compatible Pipe Line Coating Type	Recomm. Pipe Diameter	Soil Conditions	Pipelaying Method	Recommend. Pipe Preparation	Mechanical Resistance Class	Climate Conditions	Coating Layers	Product
TUBULAR PRODUCTS									
									
30 / 86	Bitumen, CTE, CAT, FBE, PE	2" – 12"	Stable	Open trench	Brushing Low Preheat	Medium (B)	SEA	2	TPS
30 / 86	Bitumen, CTE, CAT, FBE, PE	1" – 8"	Stable	Open trench	Brushing Low Preheat	High (C)	SEA	2	TPSM-C30
50 / 122	Bitumen, CTE, CAT, FBE, PE	1" – 8"	Stable	Open trench	Brushing Low Preheat	Medium (B)	SEA & LAND	2	TPSM/87

WRAPAROUND PRODUCTS



30 / 86	Bitumen, CTE, CAT, FBE, PE	3" – 20"	Stable	Open trench	Brushing Low Preheat	Medium (B)	SEA	2	WPCT WPC/B
30 / 86	Bitumen, CTE, CAT, FBE, PE	3" – 20"	Stable	Open trench	Brushing Low Preheat	Medium (B) & High (C)	SEA	2	WPC-C30
50/122	CTE, CAT FPE, PE	> 3"	Stable	Open trench	Brushing Very Low Preheat	Medium (B)	SEA & LAND	2	WATERWRAP
50 / 122	CTE, CAT, FBE, PE	> 3"	Stable & Unstable	Open trench	Gritblasting High Preheat	Medium (B) & High (C)	SEA & LAND	2	WPC-C50
65 / 149	CTE, CAT, FBE, PE, PP*	3" – 20"	Stable	Open trench	Brushing Low Preheat	Medium (B)	SEA & LAND	2	WPC65M
65 / 149	Bitumen, CTE, CAT, FBE, PE	> 3"	Stable & Unstable	Open trench	Gritblasting Low Preheat	Medium (B) & High (C)	SEA & LAND	3 (extra epoxy layer)	HTLP60
80 - 100 176 - 212 for offshore applications	Bitumen, CTE, CAT, FBE, PE, PP	> 3"	Stable & Unstable	Open trench / Offshore	Brushing High Preheat	Medium (B)	SEA & LAND	2	WPC100M
80 / 176	CTE, CAT, FBE, PE	> 3"	Stable & Unstable	Open trench / Offshore	Gritblasting Low Preheat	Medium (B) & High (C)	SEA & LAND & DESERT	3 (extra epoxy layer)	HTLP80
121 / 250	CTE, FBE, PE	> 3"	Stable & Unstable	Open trench	Gritblasting Very High Preheat	Medium (B)	SEA & LAND & DESERT	2	WPC120
121 / 250	PP	> 3"	Stable & Unstable	Open trench Offshore	Gritblasting Very High Preheat	Medium (B)	SEA & LAND & DESERT	2	PPS120
121 / 250	PP	> 3"	Stable & Unstable	Open trench Offshore	Gritblasting Induction Coil	High (C)	SEA & LAND & DESERT	3	HTLP-PP

SPECIAL APPLICATIONS

50 / 122	Bitumen, CTE, CAT, FBE, PE	> 3"	NA*** (offshore)	Offshore	Brushing Low Preheat	NA*** (extra outside coating)	NA (offshore)	2	WPCZ WPC/B
60 / 140	FBE, PE	> 3"	Stable & Unstable	Directional Drilling	Gritblasting Low Preheat	High (C)	SEA & LAND	3 (extra epoxy layer)	DIRAX ROCS60E

* For application on PolyPropylene line coating, only suitable for 30°C (86°F) operating temperature.
 ** No epoxy on PP coating.
 *** NA = not applicable

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