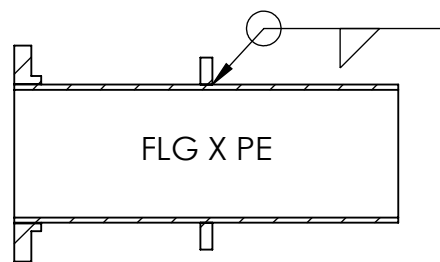
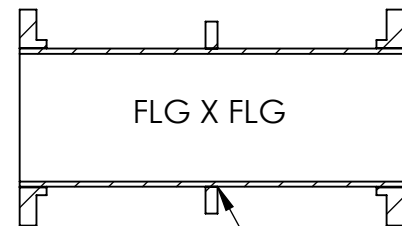


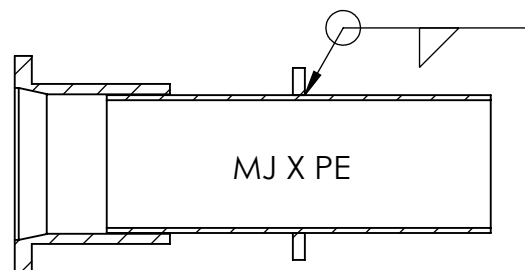
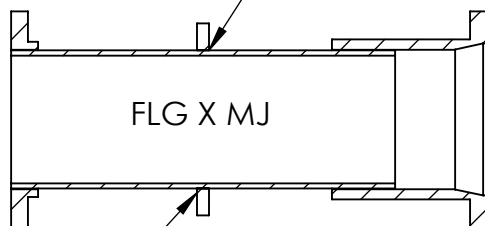
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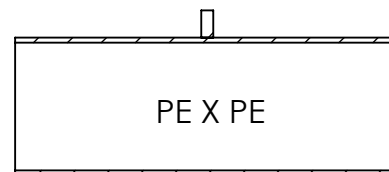
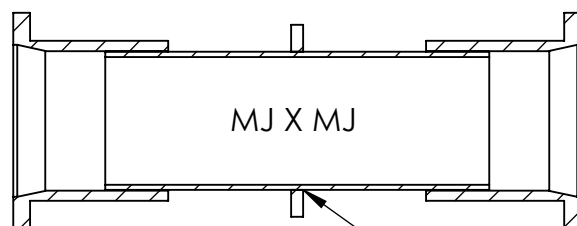
B



WELD ON SHORT
END IF NOT
CENTERED



IF THE RING IS CENTERED PLACE WELD ON FLG SIDE



WELD ON SHORT END
IF NOT CENTERED

SEE PROCEDURE QAL-A029
FOR DETAILED INSTRUCTIONS

COMMENTS:

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:

ANGLES ± 0.060
X.X ± 0.060
X.XX ± 0.030
X.XXX ± 0.010

PROPRIETARY AND CONFIDENTIAL

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SIZE **A**

NAME

DATE

DRAWN

SL

11/21/2025

CHECKED

MACHINED SURFACE FINISH
(UNLESS OTHERWISE NOTED)

125/

MATERIAL

CS



CUSTOM PIPE
FABRICATION

TITLE: DUCTILE WALL RINGS

COMPANY: CUSTOM PIPE AND FABRICATION

DRWG#: D-00003

REV 7

SHEET 1 OF 2

NOMINAL PIPE SIZE	MINIMUM COLLAR OD	MINIMUM RING THICKNESS
(IN)	(IN)	(IN)
3	6.50	0.25
4	7.40	0.25
6	9.50	0.25
8	12.00	0.25
10	14.05	0.25
12	16.25	0.25
14	18.35	0.25
16	20.95	0.25
18	23.05	0.38
20	25.50	0.38
24	29.85	0.38
30	36.50	0.38
36	43.00	0.38
42	49.50	0.50
48	55.90	0.50
54	62.65	0.50
60	66.70	0.50
64	72.75	0.50

Note: Ring to be attached by a fillet weld 360 degrees around the pipe and ring to create a watertight seal on one side only. For Flange x Plain end or MJ x Plain end the weld shall be on the plain end side.

B

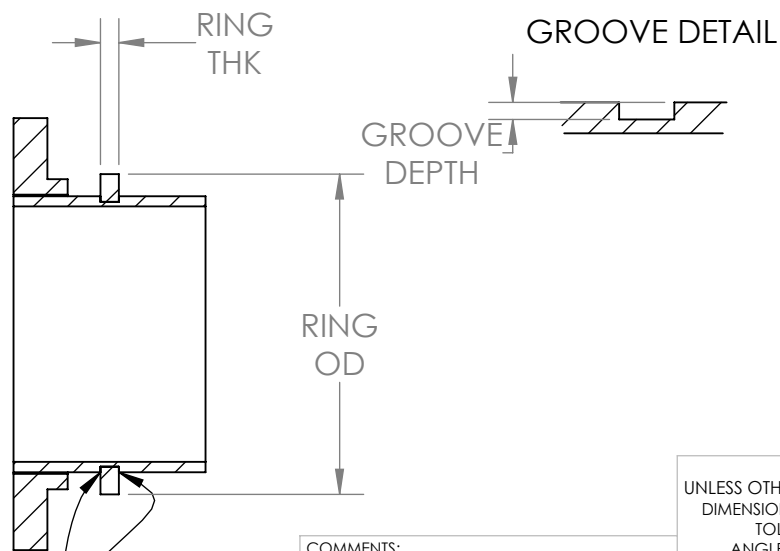
A

2

1

PRECISION SEATING METHOD FOR SPOOLS WITH HEAT SENSITIVE SPECIALTY LINING

1. A groove shall be machined at the location specified for the wall ring. This groove must not exceed the maximum depth listed in the table.
2. The ring is to be split into two pieces and placed in the groove, both halves are to be welded together with a full penetration weld. Then tack weld the ring to the body of the pipe in four places 90 degrees apart.
3. Place a bead of epoxy sealant on both sides of the ring and form a water tight seal 360 degrees around the pipe.
4. See Procedure QAL-A029 for detailed instructions.



PUT EPOXY SEALANT
ON BOTH SIDES

COMMENTS:

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UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 0.060
X.X ± 0.060
X.XX ± 0.030
X.XXX ± 0.010

SIZE	A	NAME	DATE
DRAWN	SL	11/21/2025	
CHECKED			

MACHINED SURFACE FINISH (UNLESS OTHERWISE NOTED)	MATERIAL
125/	CS



TITLE: DUCTILE WALL RINGS

COMPANY: CUSTOM PIPE AND FABRICATION

DRWG#: D-00003

REV 7

SHEET 2 OF 2

NOMINAL PIPE SIZE	ACTUAL NOMINAL OD	MAXIMUM GROOVE DEPTH	MINIMUM RING OD	MINIMUM RING THICKNESS
(IN)	(IN)	(IN)	(IN)	(IN)
3	3.96	0.096	6.50	0.25
4	4.80	0.096	7.40	0.25
6	6.90	0.100	9.50	0.25
8	9.05	0.100	12.00	0.25
10	11.10	0.114	14.05	0.25
12	13.20	0.117	16.25	0.25
14	15.30	0.126	18.35	0.25
16	17.40	0.128	20.95	0.25
18	19.50	0.148	23.05	0.38
20	21.60	0.150	25.50	0.38
24	25.80	0.157	29.85	0.38
30	32.00	0.187	36.50	0.38
36	38.30	0.187	43.00	0.38
42	44.50	0.187	49.50	0.50
48	50.80	0.187	55.90	0.50
54	57.56	0.187	62.65	0.50
60	61.61	0.187	66.70	0.50
64	65.67	0.187	72.75	0.50