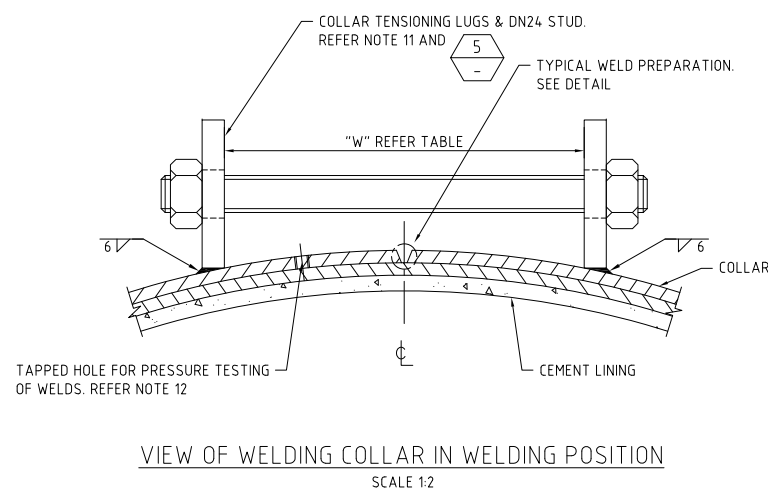
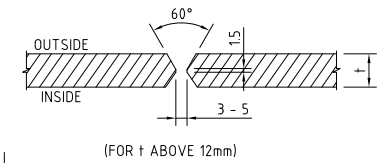
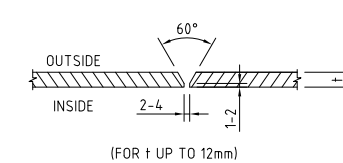
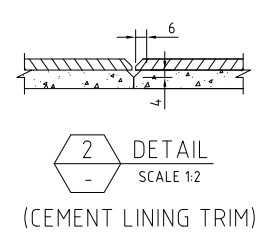
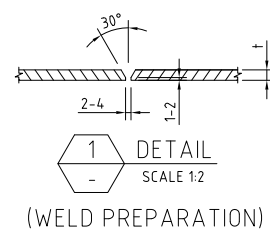
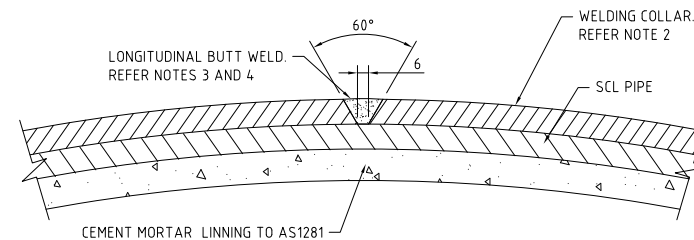
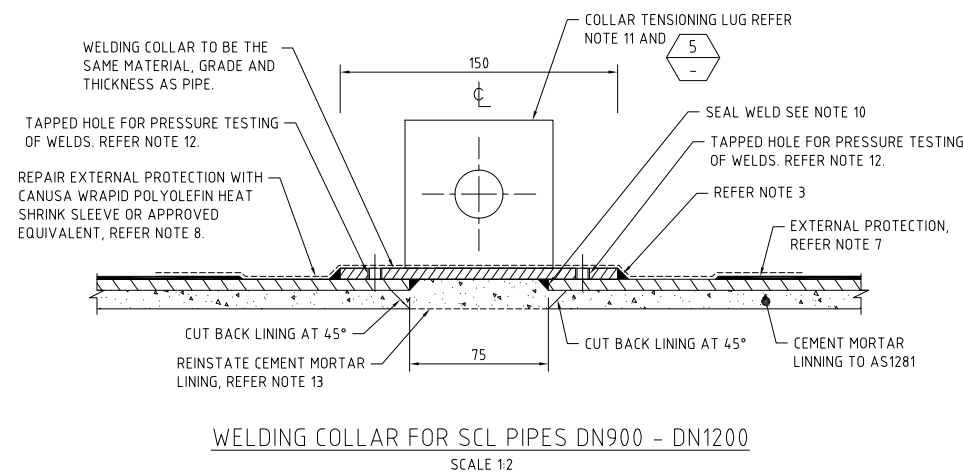
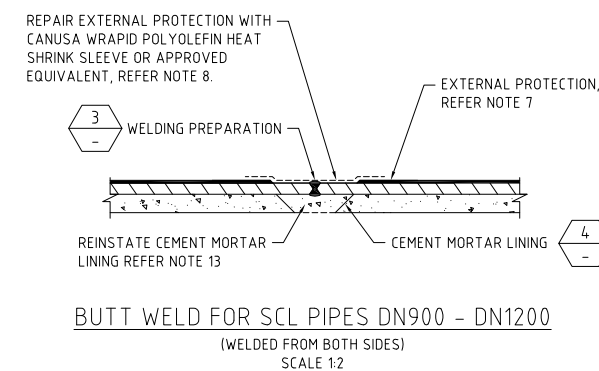
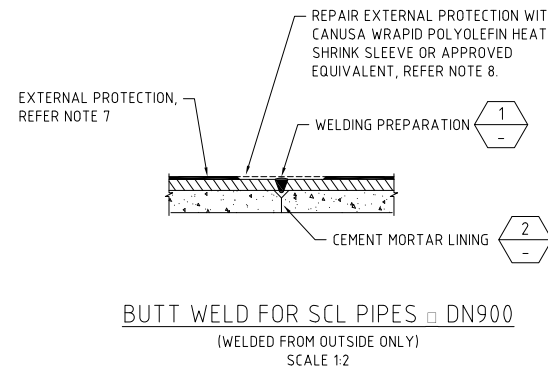
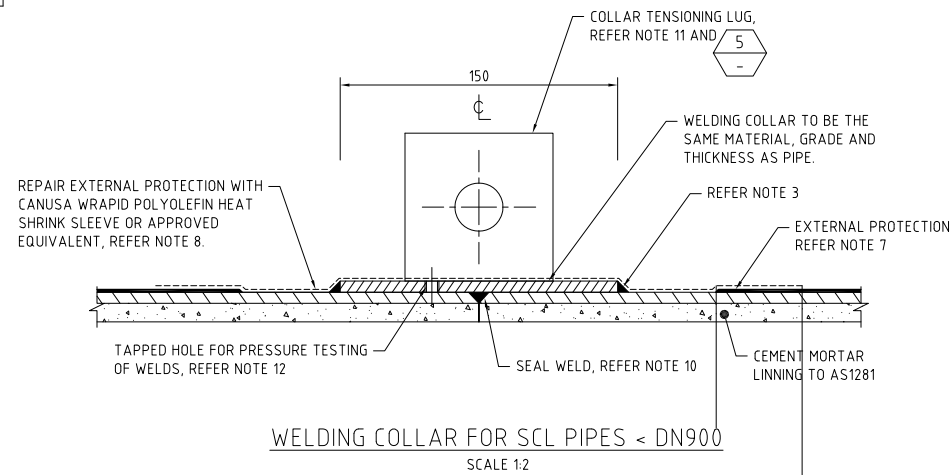
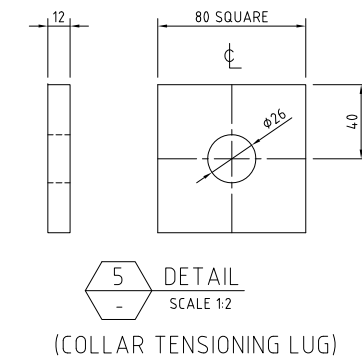
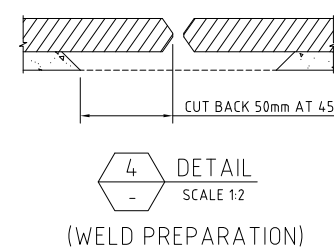


NOTES:

1. ALL DIMENSIONS IN MILLIMETRES UNLESS NOTED OTHERWISE.
2. WELDING COLLARS SHALL BE THE SAME GRADE AS PIPE MATERIAL.
3. WELDING COLLARS TO BE WELDED TO PIPE WITH CONTINUOUS FILLET WELDS. WELD TO BE EQUAL TO FULL THICKNESS OF COLLAR.
4. GRIND ALL WELDS FLUSH WITH EXTERNAL SURFACE AND REMOVE ANY SHARP CORNERS TO PREVENT ANY DAMAGE TO HEAT SHRINK SLEEVE PRIOR TO REINSTATING EXTERNAL PROTECTION.
5. WELDING PROCEDURE SPECIFICATIONS AND WELDERS SHALL BE QUALIFIED IN ACCORDANCE WITH AS4041.
6. NO JOINT DEFLECTION ALLOWED WHERE BUTT WELDING AND WELDING COLLARS ARE USED.
7. PRIOR TO WELDING CUT BACK COATINGS 50mm FROM NEAREST ASSEMBLY WELD.
8. SLEEVE TO EXTEND A MINIMUM OF 100mm EITHER SIDE OF EXPOSED PIPE SURFACE. TO BE INSTALLED IN ACCORDANCE WITH MANUFACTURERS SPECIFICATIONS.
9. ALL BUTT WELDS TO BE FULL PENETRATION CARRIED OUT AND TESTED IN ACCORDANCE WITH AS/NZS 1554.1 CATEGORY SP.
10. SEAL WELD TO CONSIST OF A SINGLE CONTINUOUS WELD BEAD AROUND PIPE AND TO BE GROUND FLUSH WITH PIPE OD PRIOR TO FITTING COLLAR.
11. PRIOR TO REINSTATING EXTERNAL PROTECTION AND AFTER COLLAR HAS BEEN WELDED REMOVE BOLTS & WELDING LUGS. GRIND FINISHED SURFACES FLUSH.
12. PROVIDE 5mm TAPPED HOLE FOR PRESSURE TESTING. 5mm MILD STEEL GRUB SCREW TO BE PLACED IN HOLE AND GROUND FLUSH AFTER TESTING.
13. CEMENT MORTAR LINING TO BE REINSTATED IN ACCORDANCE WITH AS1281, OR WITH PENTAIR EZILINE MORTAR MIX STRICTLY IN ACCORDANCE WITH MANUFACTURERS REQUIREMENTS, OR APPROVED EQUIVALENT. AT THE TIME OF APPLICATION OF THE MORTAR, THE SURFACE OF THE PIPE OR FITTING SHALL BE FREE OF LOOSE RUST, LOOSE MILL SCALE, DIRT, DEBRIS, OIL, GREASE AND OTHER DETRIMENTAL MATERIAL.
14. DESIGNED FOR MAXIMUM:
 - 120m HEAD OPERATING PRESSURE
 - 150m HEAD TEST PRESSURE



'W'	LENGTH
100	70
150	85
200	100
250	100
300	100
375	120
450	130
500	140
600	150
700	150



Sydney
WATER

APPROVED

PETER GILLMAN
MANAGER E & ES

ENGINEERING & ENVIRONMENTAL SERVICES

A
LETTER

ORIGINAL ISSUE

DETAILS OF ISSUE / AMENDMENT

PJG

01/03/13

DEEMED TO COMPLY DRAWINGS

STEEL WATER MAINS DN150 ≤ DN1200

STEEL PIPE JOINTING
WELDED - PLAIN ENDS

DTC

1151

ISSUE DATE

A 01/03/13