
WELDING INSTRUCTION

KLINGER valves with welding ends

Type KHS-OE, KHSU-OE

Material: 1.0254 (St37-0) DIN 1629

All Klinger ball valves with welding ends can be basically welded by autogenous, electro or arc welding method into the piping.

The autogenous welding is recommended for nominal sizes up to 125, larger ball valves should be welded into the piping system by electrowelding.

(Welding instruction should clearly appear on the sticker of the ball valve.)

The overall length is in such a way selected that during professional weld, the ball valves can be welded into the pipeline as a complete valve fitting.

If the valve ends are to be shortened, damages can appear on the sealing system due to the overheating.

Proceeding:

- Switch valve to OPEN setting
- Tack weld the valve with the pipe
- Welding operation – control of the temperature
During preheating and welding, the temperature should not exceed 200°C in the body edge area. If necessary, cool this area.
- After cooling off - functional test

Start-up:

Solids of any kind, which are not a component of the medium, must be removed from the piping before start-up of the ball valve. We point out that damages caused by these foreign solids are not warranted.

Standard reference:

“Quality requirements for welding”

EN 729-2	Fusion welding of metallic materials
EN 719	Welding coordination, tasks and responsibilities
EN 288-1,-2,-3,-5	Welding procedures for metallic materials
	Fusion welding, arc welding
EN 1258	Measurement of preheat maintenance temperature
EN 499	Welding consumables

Edition: 05/2005



Fluid Control GmbH
Am Kanal 8-10
A-2352 Gumpoldskirchen/AUSTRIA

Telefon: ++43(0) 2252 / 600 0
Telefax: ++43(0) 2252 / 63336
 ++43(0) 2252 / 600 - 242
e-mail: office@klinger.kfc.at
WEB: www.klinger.kfc.at
