

BUREAU VERITAS

SERVICES MARITIMES  
MARINE DEPARTMENTS

DIVISION CONSTRUCTIONS NEUVES  
NEW BUILDINGS DIVISION

Coupe  
Section

Paris, July 19th, 1984

N° 7134 CN.2 JCO/CS

BUREAU VERITAS

TURKU

PJ }  
Encl. }

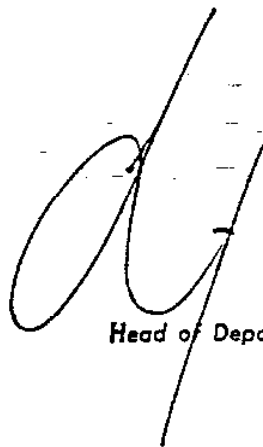
SUBJECT - Collars manufactured by press lathing of WARTSILA

REF. - Y/Letter n° 84381 TRK dated 04.07.84

---

Further to your letter in reference, please note that no objection is found to the manufacturing procedure of pipe collars by press lathing as described in Messrs WARTSILA STANDARD 010 -REV.1 Appendix 1 dated 21.06.84.

Yours faithfully,



Head of Department

# BUREAU VERITAS

REGISTRE INTERNATIONAL DE CLASSIFICATION DE NAVIRES ET DES AERONEFS  
INTERNATIONAL REGISTER FOR THE CLASSIFICATION OF SHIPPING AND AIRCRAFT

ADMINISTRATION: 31, Rue Henri-Rochefort, P A R I S (XVIIe)

Bureau Veritas

CN2

31 rue Henri-Rochefort

75821 Paris Cedex 17

Turku, 04.07. 1984

C/O VUORI & CO TURKU

YRJXNX VUORI

EXPERT EN CHEF POUR LA FINLANDE  
CHIEF SURVEYOR FOR FINLAND

RISTO KAJATSALO, surveyor

HEIKKI KOIVUNEN, surveyor

Itäinenkatu 78 B 39, 20810 Turku 81

☎ 355 500, 355 511

VUORICO Turku

Telex: 62597 VUOCO SF

BRANCH SURVEYORS

HELSINKI, VAASA, RAAHE

No 84381-TRK

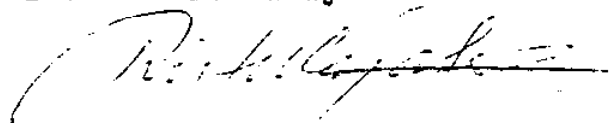
RE: Application for approval concerning press lathed pipe  
end collars from Wärtsilä, Ylivieska Works

---

We enclose the selfexplanatory application for approval  
from Wärtsilä Ylivieska Works.

Enclosure : letter 25.06.1984 from Wärtsilä

Yours faithfully



RVM/pmr

25th June, 1984

1 (2)

Bureau Veritas  
Vinberg  
Itäinen katu 76 B 39

20810 TURKU 81

Your approval 14th March, 1984 concerning  
press lathed pipe end collars

Dear Sirs,

We apply for your approval to pipe end collars made of carbon steels, austenitic stainless steels and copper alloys to be used to the pipes according to BV Class II.

This approval is needed for using our own products and also for marketing the collar machine developed by us.

**Procedure/materials**

Manufacturing procedure of pipe end collars is the same as with copper alloys - press lathing.

The materials used are in addition to already approved materials now also carbon steels and austenitic stainless steels.

Manufacturing procedure of carbon steel collars is press lathing with hot forming. Heat treatment is not carried out (the rules of BV require heat treatment after hot forming only for alloys).

The another way to manufacture carbon steel pipe end collars is cold press lathing. We would ask your opinion of this question, in which cased and on which conditions heat treatment could be gave up.

When manufacturing austenitic stainless pipe end collars preheating 350°C is used up to NS 50. Bigger dimensions are cold collared. Heat treatment is not used.

010

Dimension standard

The dimensions of all materials are determined by the enclosed standard No 010 of Wärtsilä Ylivieska Works.

DN 40...DN 400

Carbon steel pipes PN 16

Austenitic stainless steel pipes PN 10

Copper alloys PN 10

Max temperature +200°C

Our dimension standard comes up to the requirements of DIN 2642.

The loose flanges used are according to DIN 2642 and DIN 2576 AS.

Yours faithfully,

OY WÄRTSILÄ AB  
Ylivieska Works

*Risto Merikallio*  
Risto Merikallio

Encl.