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YOUR REF

OUR REF ET/BB

DATE April 3, 1985

PIPE COLLAR MACHINE

We refer to your letter dated 29th June 1984.

The flanging method may be accepted for the low pressure auxiliary systems up to 16 bar in ships and mobile offshore units. This includes pipes as

Material	Dimension	Standard
Carbon steel	NS 40 ... NS 400	DIN 1629
Austenitic stainless steel	NS 40 ... NS 400	SS 2333, SS 2343
Al brass	NS 40 ... NS 400	BS 2871
Copper - nickel	NS 40 ... NS 400	DIN 17671, DIN 17664

Loose flanges acc. to DIN 2642, DIN 2576 AS, 1984.

Regarding thickness of the pipes reference is made to our Rules for the materials involved; steel, austenitic steel, copper-alloys for the different application categories.

We have no Rules as regards pipes with flare, However the NVI-4 groupes may be cold bend with bending radius $2.5 \times D$ without subsequent heat treatment, corresponding to 20% cold deformation. The cold deformation, with thickness referred to in DIN 2642 with max 10PN gives deformation in excess of 20% in the radius. For small diameters for ex. DN 40 the cold deformations in d4 position will be almost 70%. Consequently we will not accept cold flaring of tubes in grades NV 1 to NV 4, which have to be hot flared in the normalizing range for the material.

Austenitic stainless steel tubes may be coldformed, except dimension less than DN 50, which may be hotformed at 350°C as proposed by the manufacturer. Aluminium brass tubes must be stressrelieved after coldforming according to DnV rules, or hotformed.

The acceptance for the end product, pipe with flare, for conformance to specified standards can be given to the company operating with the machine and producing the laps.

We are also enclosing our invoice no. 3637 amounting to FIM 1.025.--.

Yours faithfully,
FOR DET NORSKE VERITAS
Bill Mikender
Bill Mikender
Station manager

E. Tuokka
E. Tuokka

encl.
Det Norske Veritas has no liability for loss or damage caused by its tacit, official, employees or others who are under assignment by the Foundation, whether or not such person has acted intentionally or negligently and whether or not the loss or damage has affected the owner of a ship, facility or system, or a shipyard or other who have requested the Foundation's assistance, or any third party who entered having any contractual relationship with the Foundation has acted or made arrangements in reliance on decisions made or instructions given by it in the name of the Foundation. Nor, in cases as mentioned in the preceding paragraph, can the individual or individuals who have intentionally caused the loss or damage be held liable.



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YOUR REF.

OUR REF. AD/BB

HELSINGFORS, 16th January, 1984

Dear Sirs,

Re. Pipe Collar Machine

We refer to your letter dated 29th April 1983 with enclosures and the survey carried out at your Works on the 4th January 1984 concerning your pipe collar machine.

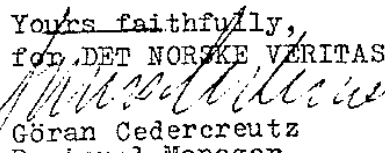
The flanging method may be accepted for low pressure auxiliary systems up to 16 bar in ships and on offshore installations but not for gas or other process fluid systems on offshore.

This includes for pipes as,

Material	Dimension	Standard
Carbon steel	NS 50 to NS 400 S = 1 to 10 mm	DIN 1629
Stainless steel	NS 50 to NS 400 S = 1 to 6 mm	SIS 2333 SIS 2343
Al-brass	NS 50 to NS 400 S = 1 to 10 mm	BS 2871
Copper nickel	NS 50 to NS 400 S = 1 to 10 mm	DIN 17671 DIN 17664

and the loose flanges with the yards standards WT-stand. no. 628.9.4 and TES 8164.

The end product may be accepted for conformance to given standards. This acceptance may be given to the company operating the machine and producing the laps.

Yours faithfully,
for DET NORSKE VERITAS

Göran Cedercreutz
Regional Manager

