

# 160/90mm and 160/110mm 45° Elbow

## Installation Instructions - ISSUE I

*Please read this document carefully*



		Parts Required
Part No. (90mm)	Part No. (110mm)	Description
001-090-006	001-110-006-FILL or 001-110-006	Pipe UPP 90mm or 110mm FILL/VENT L6M UPP Extra Pipe
000-160-006-SC	000-160-006-SC	Pipe UPP Secondary 160mm L=6M
02.90	02.110	Welding Coupler UPP 90mm or 110mm
02.160	02.160	Welding Coupler UPP 160mm
04-090-LS-3	04-110-LS-3	Elbow 45° UPP Extra 90mm or 110mm
04.160(SC)	04.160(SC)	Bend 45° UPP 160mm Secondary
EW8-PC 2mm	Welding lead	Required for use with 02.160 couplers

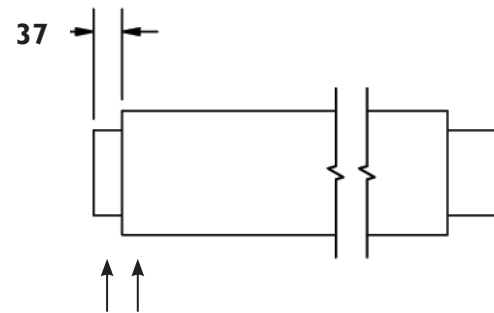
Please follow these instructions carefully.



All prepared welding surfaces must be cleaned with cleaning solvent (Acetone) before welding.

No stress should be exerted on any UPP joint during the entire weld cycle or for up to 20 minutes after welding is completed.

1. Cut back 160mm Secondary Contained Pipe to expose 37mm of the Primary Pipe.



Scrape ends of both pipes.

2. Scrape both ends of Primary Elbow.

Clean Primary Pipe and **short** leg of Primary Elbow.

Mark primary insertion depths **on both** (37mm for 90mm diameter and 42mm for 110mm diameter).

Clean bore of Coupler.

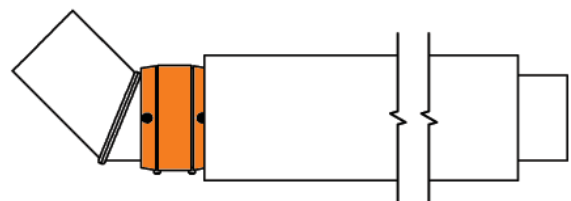
Insert cleaned Primary Pipe and Primary Elbow up to stops of primary coupler and clamp in position.

**Ensure Primary Coupler weld pins are orientated 90° from the inside of the bend.**

Connect Welder to Coupler (**highlighted**) and weld.

Mark time and check weld indicators are extended.

Allow 20 minutes cooling time.



### 3. Scrape both ends of Secondary Bend.

Clean end of 160mm Secondary Pipe and one end of Secondary Bend.

Mark 48mm insertion depths **on 160mm Secondary Pipe and Bend.**

Clean bore of 02.160 Primary Coupler.

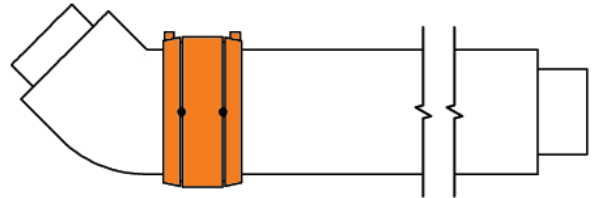
Insert cleaned Secondary Pipe and Secondary Bend up to stops of 160mm Coupler and clamp in position.

Connect Welder and Weld using 2mm 4amp lead.

Mark time and check weld indicators are extended.

Allow 20 minutes cooling time.

**IMPORTANT !**  
**ONLY 02.160 Primary**  
**Welding Sockets**  
should be used for 45°  
160 primary elbows.



### 4. Scrape and clean end of Primary Pipe.

Clean end of Primary Pipe and end of Primary Elbow.

Mark insertion depths (37mm for 90mm diameter and 42mm for 110mm diameter).

Clean bore of Coupler.

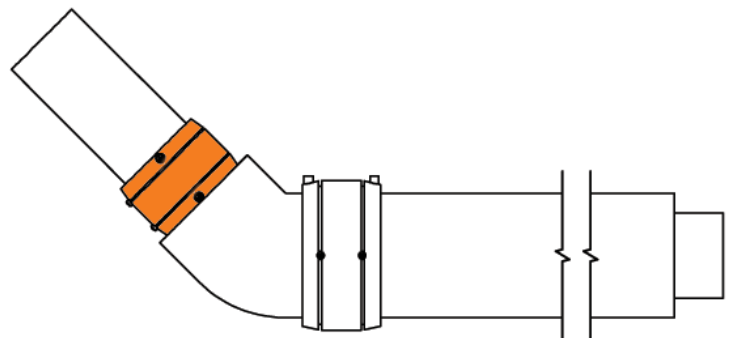
Insert cleaned Primary Pipe and Primary Elbow up to stops of Primary Coupler and clamp in position.

**Ensure Primary Coupler weld pins are orientated 90° from the inside of the bend.**

Connect Welder and Weld.

Mark time and check weld indicators are extended.

Allow 20 minutes cooling time.



### 5. Scrape and clean end of 160mm Secondary Pipe.

Mark 48mm insertion depths.

Clean bore of 160mm Coupler.

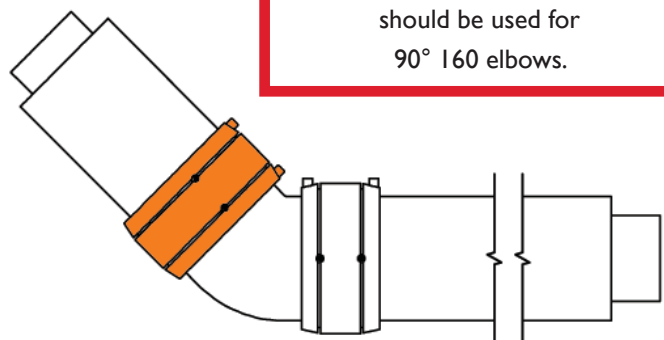
Insert cleaned Secondary Pipe and Secondary Bend up to stops of 02.160 Primary Coupler and clamp in position.

Connect Welder and Weld using 2mm 4amp lead.

Mark time and check weld indicators are extended.

Allow 20 minutes cooling time.

**IMPORTANT !**  
**ONLY 02.160 Primary**  
**Welding Sockets**  
should be used for  
90° 160 elbows.





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