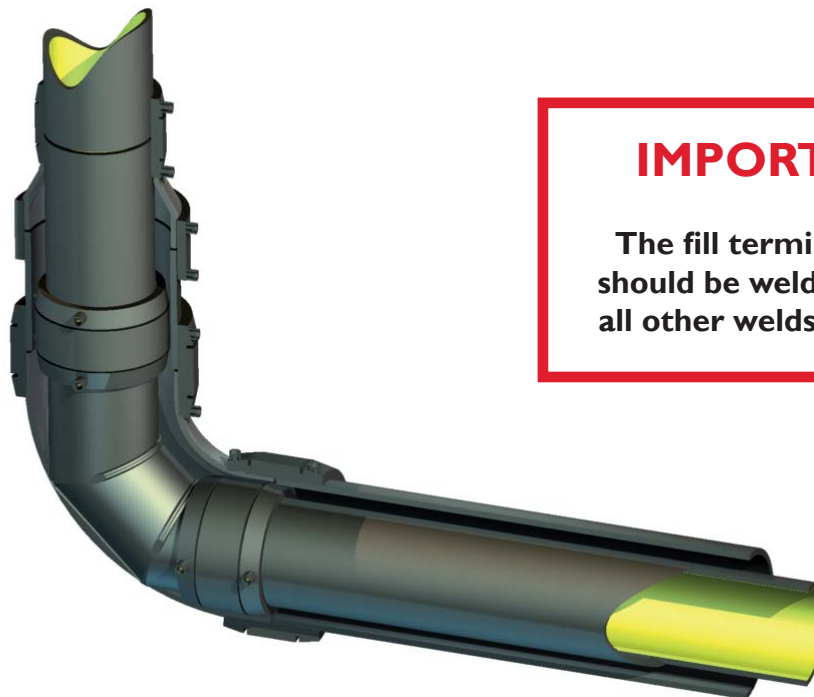


# 160/90mm and 160/110mm 90° Elbow Including Termination Options

## Installation Instructions - ISSUE 1

*Please read this document carefully*



### **IMPORTANT !**

The fill termination joint should be welded last; after all other welds have cooled

		Parts Required	
Part No. (90mm)	Part No. (110mm)	Description	Quantity
001-090-006	001-110-006-(FILL) or 001-110-006	Pipe UPP (FILL/VENT) L6M UPP Extra Pipe	n/a
000-160-006-SC	000-160-006-SC	Pipe UPP Secondary 160mm L=6M	n/a
02.90	02.110	Welding Coupler UPP	2
02.160	02.160	Welding Coupler UPP 160mm	2
02.160(SC)	02.160(SC)	Welding Coupler UPP 160mm (SC)	1
03-090-LS-3	03-110-LS-3	Elbow 90° UPP Extra	1
03.160(SC)	03.160(SC)	Bend 90° UPP 160mm Secondary	1
13.160.90	13.160.110	Reducer UPP 160/110mm or 160/90mm SC	1
EW8-PC 2mm	Welding lead	Required for use with 02.160 couplers	1
		<b>Termination Options</b>	
81.090.BSPT	81.110.BSPT	Term UPP BSPT Male	n/a
82.090.BSPT	82.110.BSPT	Term UPP BSPT Female	n/a
110mm Spigot	110mm Spigot	PE Pipe Spigot	n/a
05, 06, 07	05, 06, 07	Stub, Flange, Gasket	n/a

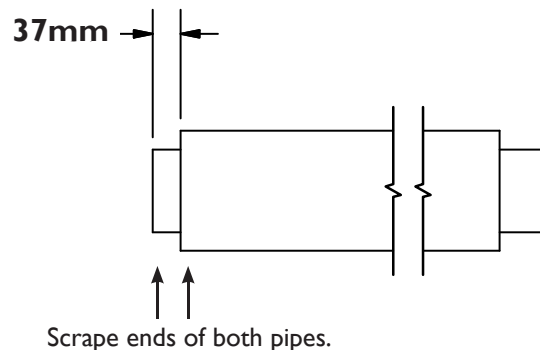
## 160 / 110mm 90° Elbow including termination options

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.



2. Scrape both ends of Primary Elbow.

Clean Primary Pipe and short leg of Primary Elbow.

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

Clean bore of Primary Coupler.

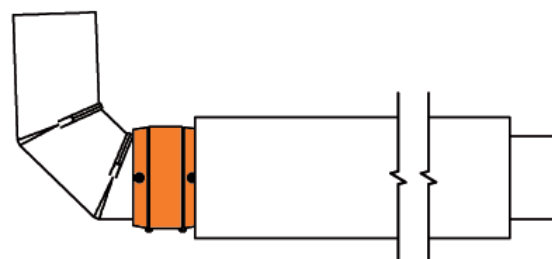
Insert cleaned Primary Pipe and Primary Elbow up to stops of Primary Coupler and clamp in position.

**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 depth **on 160mm Secondary Pipe and Bend.**

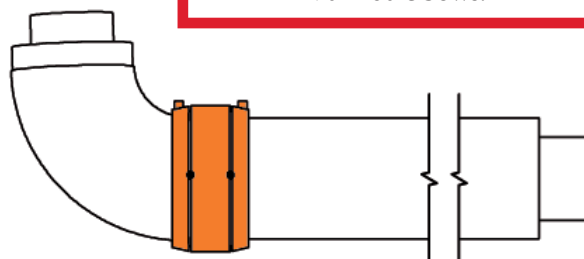
Clean bore of 02.160 Primary Coupler.

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  
90° 160 elbows.

- 4. For fill point terminations** the recommended minimum length of Termination Riser is 205mm of Primary Pipe.

Scrape and clean both ends of Primary Pipe.

**For continued pipe run** scrape and clean end of Primary Pipe.

**For both options**

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

Clean bore of Primary Coupler.

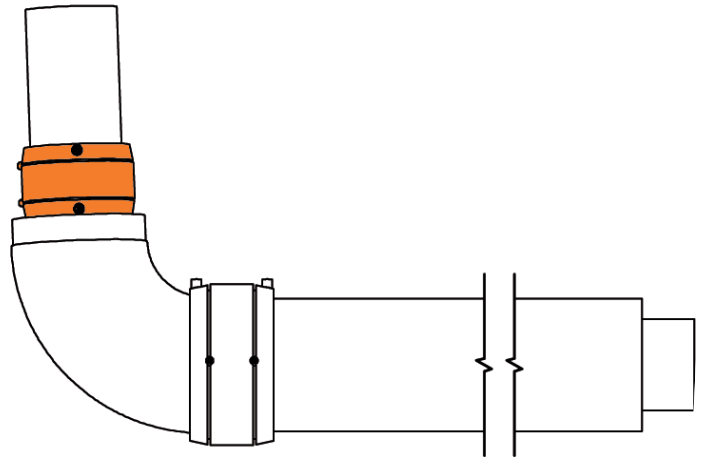
Insert cleaned Primary Pipe and Primary Elbow up to stops of Primary Coupler and clamp in position.

**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. For fill point terminations** using recommended minimum length of Primary Riser a 130mm length of Secondary pipe is required.

Scrape and clean both ends of Secondary Pipe.

**For continued pipe run** scrape and clean end of 160mm Secondary Pipe.

**For both options**

Mark 48mm insertion depths.

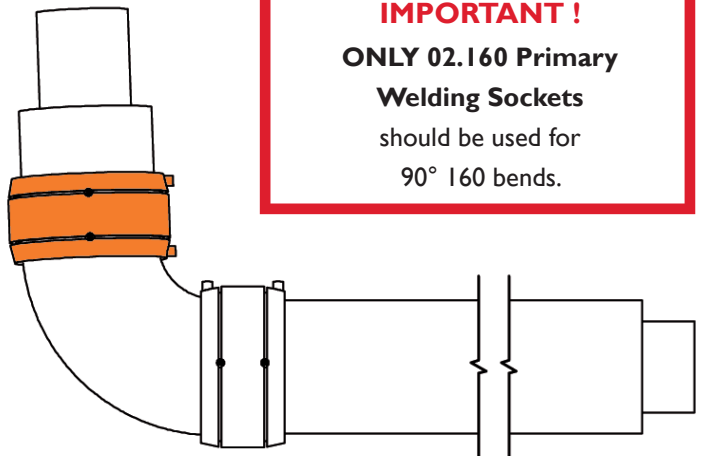
Clean bore of new 160mm Primary Coupler.

Insert cleaned Secondary Pipe and Secondary Elbow up to tops of new 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.



- 6. For Fill point Terminations ONLY**

Scrape 160mm diameter of SC Reducer.

Clean 160mm diameter of SC Reducer and end of 160mm Secondary Pipe.

Mark 32mm insertion depths on both.

Clean bore of Primary Coupler on SC Reducer and Primary Pipe.

Clean bore of 160mm Secondary Containment Coupler.

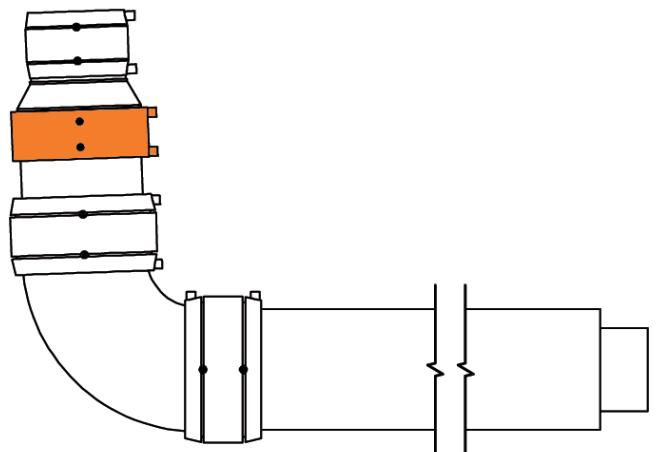
Insert 160mm Secondary Pipe and SC Reducer up to stops of 160mm Secondary Coupler, this will also engage Primary Pipe in Primary Coupler on SC Reducer.

Check if Primary Pipe is up to stops in Primary Coupler of SC Reducer and clamp in position.

Connect Welder to 160mm Secondary Coupler only and Weld.

Mark time and check weld indicators are extended.

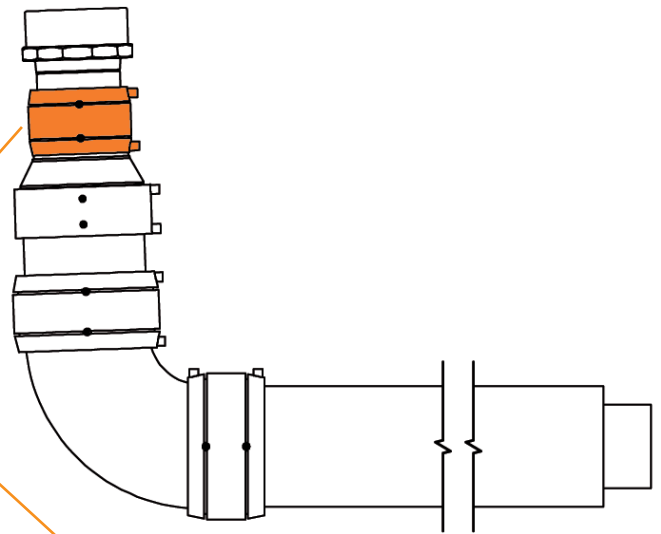
Allow 20 minutes cooling time.



### 6a. 80 series UPP Termination - Male or Female

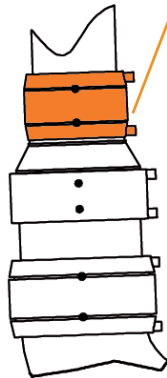
- Scrape end of 80 Series Termination Fitting.
- Clean bore of Primary Coupler on SC reducer and Termination Fitting.
- Mark insertion depth on Termination Fitting.
- Insert Termination Fitting up to stops of Primary Coupler on SC Reducer and clamp in position.
- Connect Welder and Weld.
- Mark time and check weld indicators are extended.
- Allow 20 minutes cooling time.

**IMPORTANT !**  
This joint should be welded last; after all other welds have cooled



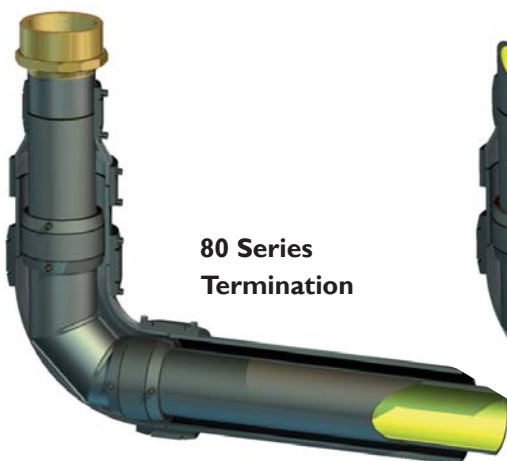
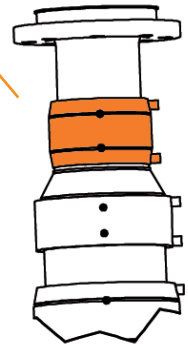
### 6b. PE Spigot

- Scrape end of Spigot .
- Clean bore of Primary Coupler on SC Reducer and Spigot, mark insertion depth on Spigot.
- Insert Spigot up to stops of Primary Coupler on SC Reducer and clamp in position.
- Connect Welder and Weld.
- Mark time and check weld indicators are extended.
- Allow 20 minutes cooling time.

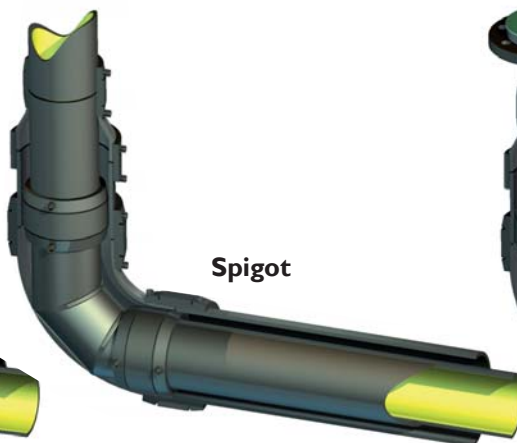


### 6c. UPP Stub Flange

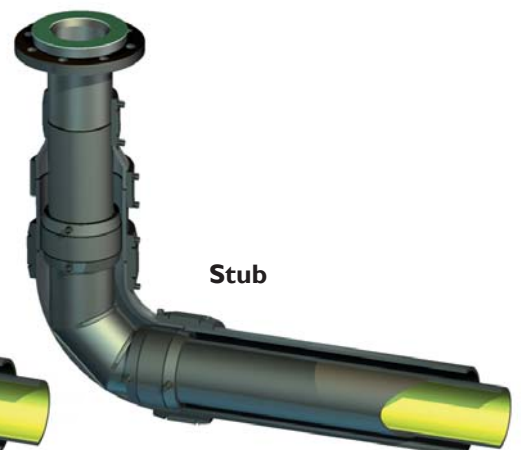
- Scrape end of Stub.
- Clean bore of Primary Coupler on SC Reducer and Stub, mark insertion depth on Stub.
- Thread over Flange Ring.
- Insert Stub up to stops of Primary Coupler on SC Reducer and clamp in position.
- Connect Welder and Weld.
- Mark time and check weld indicators are extended.
- Allow 20 minutes cooling time.



80 Series Termination



Spigot



Stub


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 PetroTechnik France  
 PetroTechnik AB  
 PetroTechnik Inc.  
 P&D Japan  
 PetroTechnik China

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