

Pipe Connection

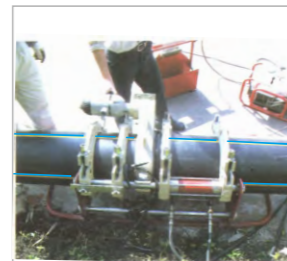
Kingbull supply injection butt welding, fabricated butt welding, electro-fusion welding and steel-plastic transition 4 series gas fittings and equipment, according to the industry standard of the People's Republic of China <<PE gas pipe engineering technique regulations >>(CJJ63-95) to provide user with professional pipeline design and after-sales service

Butt fusion welding

Thermo-fusion is to use thermo fusion machine to heat the ends of pipes and fittings (at temperature $210\pm 10^{\circ}\text{C}$), and then insert the heated pipe into fitting without rotation to reach connection



close tightly and clean the edges of ends



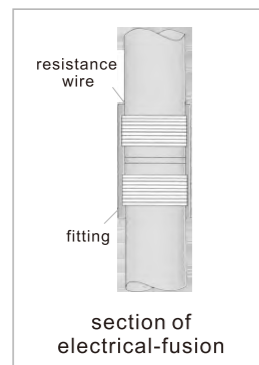
adjust and rubdown the ends



butt-welding

Electro-fusion welding

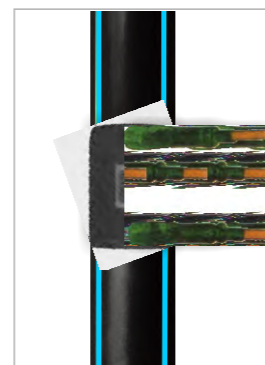
Electro-fusion is to use electro-fusion welding machine to heat the resistance wire under the surface of fittings, melt the surface of pipe and fittings, connect the fittings and pipes molecular



section of electrical-fusion



full-automatic welding machine



Electrical-fusion steps:

1. Check if pipe and fitting are in good condition and dry, clean up the connecting place
2. Mark inserting depth, peel the exterior surface of inserting pipe: measure the socket length and mark on the inserting end of pipe or socket inserting end, peeling length+ $_{10\text{mm}}$ (thickness of exterior surface 0.1-0.2mm)
3. Calibrating: PE Pipeline that $\text{dn}<90\text{mm}$ and the round degree affect the installation, calibrating tool shall be applied to the inserting end before installing.

4. Pipe insert into fitting: put the inserting end of pipe or socket fitting into the the socket end of thermo-socket fitting to the depth of marked place and check
5. Calibrating, fixing pipe and fitting: Before electrifying, calibrating the joints, make sure they are on the same axis and apply special tools to firm pipe and fitting
6. Electrifying and heating: electro welding machine should be connected with electro fitting correctly, when connecting, the electro-pressure and heating hour should be accordance with the regularities of manufacture of electro-welding machine and electro fitting
7. cooling: during the period of cooling process, don't move any joint or put any other force on the joint.

Butt welding with saddle shaped tee

PE gas pipeline in the application process often has the problem of main pipe parted connection based on the actual situation, traditional pipe will be cut a part of main pipe, using a tee to complete the connection with cumbersome installation. PE pipe can be connected by a saddle shaped tee with convenient installation.

Saddle shaped tee can be connected by butt welding, using saddle shaped butt welding machine, installing a saddle shaped tee directly on the main pipe, then we will cut the main pipe with the cutter to reach the divided connection of main pipe.

Steel-plastic flange connection

When PE gas pipe is needed to connect with steel pipe and valves, should use the way of steel-plastic flange connection: the end of PE pipe and corresponding plastic ring can be connected by the way of butt-fusion welding, the end of steel pipe will be connected with metal flange according to the Steel pipe welding regulations, then using flange plates connect the PE pipe and steel pipe.



Perfect service system to maximize customer needs.

