



**AMERICA TRADE**

*Bringing Solutions To Your Hands*



# IN-LINE WELDING HOT TAP & LINE STOP SERVICES

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*2022*

## IN-LINE WELDING

### SCOPE

- Provide any In-Line Welding service under codes: **B31.3 – B31.4 – B31.8** according with **API1104 & ASME Section IX**

### SOURCE

- Trained and certified in-house crew to execute any In-Line Welding Service.
- Senior Welding Engineer – Certified by:
  - ✓ API
  - ✓ AWS
  - ✓ ASME

### TRAINING PROGRAM

- Program has been certified by SGS
- Welders and supervisors have been trained in:
  - ✓ API 1104
  - ✓ ASME Section IX
  - ✓ API 577
  - ✓ API 2201





## HOT TAPPING SERVICE

### SCOPE

- Provide any scheduled or emergency Hot Tap service from 3/8" to 48"

### MAX. OPERATING CONDITIONS

Max. Working Pressure	1480PSI @ 100°F
Max. Working Temperature	700°F @ 700 PSI
Max. Flow	Posy-Latch Pilot Drills ✓ Gas: 30.4 m/sec ✓ Liquid: 15.2 m/sec

### APPLICABLE

PIPE MATERIAL	FLUID
Stainless Steel	Natural Gas
Carbon Steel	Nitrogen
Cast Iron	Steam
Concrete	Crude
Copper	Water
PVC	Fuel
	PGL
	Oil



## HOT TAPPING SERVICE

### SOURCE

- Complete set of equipment up to 24" at Jubail - KSA
- Equipment made 100% in US
- International Master Technician – 30 years of experience
- Trained and certified local crew

### TECHNICAL SUPPORT

- Hot Tapping engineering department provide:
  - ✓ Hot Tap Assessment
  - ✓ Hot Tap Customized Procedure
  - ✓ Equipment Data Sheet
  - ✓ Hot Tap Calculations
  - ✓ Execution Report



## HOT TAPPING SERVICE

### EQUIPMENT FLEET – JUBAIL KSA

#### HOT TAPPING MACHINES - ANSI 600 - 1480PSI - 102 Bar

REF	RANGE	TRAVEL BAR	DIAMETER BAR
E4	3/8" - 4"	18" & 30"	1.125"
E320	3" - 20"	66"	2.500"
E1448	14" - 48"	120"	4.000"

### HOT TAP EQUIPMENT – E4 600#

Made 100% in USA

Boring Bar Travel: 18" & 24"

Tapping Range: 3/8" – 4"

Max. Working Press: 1480 psi @ 100° F

Max. Working Temp: 700° F @ 700 psi




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**HOT TAPPING MACHINE E4**

**SPECIFICATIONS**

Boring Bar Travel	12", 18", 24", 30"
Tapping Size Range	3/8" thru 4"
MAOP	1480 psig @ 100° F
Max. Operating Temperature	Standard Packing: 300° F @ 700 psig
	Severe Packing: 700° F @ 700 psig
Power Options	Manually/Air

**MODELS**

PART NUMBER	DESCRIPTION	UNIT WEIGHT LB.	UNIT WEIGHT KG.	LENGTH INCHES
E4-11	MODEL E4-11 TAPPING MACHINE	26.5	12	39
E4-18	MODEL E4-18 TAPPING MACHINE	37	17	48
E4-24	MODEL E4-24 TAPPING MACHINE	49	23	61
E4-30	MODEL E4-30 TAPPING MACHINE	61	28	72

**ACCESSORIES INCLUDED**

PART NUMBER	DESCRIPTION	WEIGHT LB.	WEIGHT KG.
E4-CH	CRANK HANDLE	2	1
E4-BV	BLEEDER VALVE	<1	<1
E4-VN	VALVE NIPPLE	<1	<1
E4-PW	PACKING WRENCH	<1	<1
E4-OC	TOP RETAINER CLIP	<1	<1
E4-SP	STANDARD PACKING	<1	<1
E4-OM	OPERATIONS MANUAL	-	-
E4-AB	ACCESSORY BOX	1	0.5

## HOT TAPPING SERVICE

### HOT TAP EQUIPMENT – E320 600#

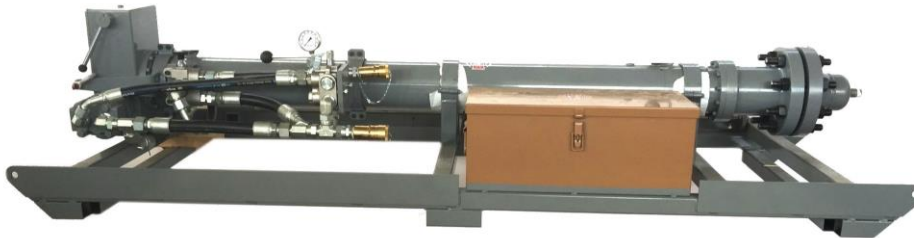
Made 100% in USA

Boring Bar Travel: 66"

Tapping Range: 3" – 20"

Max. Working Press: 1480 psi @ 100° F

Max. Working Temp: 700° F @ 700 psi




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**ENR**  
PIPE LINE PRODUCTS

### HOT TAPPING MACHINE E320

**SPECIFICATIONS**

Boring Bar:	66"
Tapping Range:	3" - 20"
Max. Operating Pressure:	1480PSI @ 100°F
Max. Operating Temperature:	
Standard Packing:	400°F @ 700PSI
Severe Packing:	700°F @ 700PSI

The model E320 Tapping Machine is the most powerful of the "300 series" machines, providing a tapping Size Range of 3 inch thru' 20 inch, with a Boring Bar Travel of 66".

The machine is hydraulically powered, via a dedicated Diesel Hydraulic Power Unit. As all the ENR Tapping Machines, the E320 is capable of operating up to 1480 psig, so allowing safe operations on lines up to full ANSI 600 operating pressure

The Machine is operated via dual HI-Power Hydraulic Motors, providing Speed Control Features at the machine, for ease of use

## HOT TAPPING SERVICE

### HOT TAP EQUIPMENT – E1448 600#

Made 100% in USA

Boring Bar Travel: 120"

Tapping Range: 14" – 48"

Max. Working Press: 1480 psi @ 100° F

Max. Working Temp: 700° F @ 700 psi




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**HOT TAPPING MACHINE E1448**



**SPECIFICATIONS**

- Boring Bar: ..... 80", 110" & 120"
- Tapping Range: ..... 14" – 48"
- Max. Operating Pressure: ..... 1480PSI @ 100°F
- Max. Operating Temperature:
  - o Standard Packing: ..... 300°F @ 700PSI
  - o Severe Packing: ..... 700°F @ 700PSI
- Auto Feed Rate: ..... 0.004"/Rev.

The Model E1448 Tapping Machine providing a tapping Size Range of 14" to 48", with a Boring Bar Travel of 80, 110 and 120 inches

The machine is hydraulically powered, via Diesel Hydraulic Power Unit.

ENR E1448 Tapping Machines is capable of operating up to 1480 psig, so allowing safe operations on lines up to full ANSI 600 Operating Pressures

The Machine is operated via Tandem Hydraulic Motor with two speed operation on constant flow input, providing Speed Control Features for Cutter Rotation, while a separate Hydraulic Motor provides Power Extension and Retraction of the Boring Bar.



## LINE STOP SERVICE

### SCOPE

- Provide any Line Stop service from 3" to 48"

### MAX. OPERATING CONDITIONS

Max. Working Pressure	1480PSI
Max. Working Temperature	250°C
Max. Flow	Posy-Latch Pilot Drills ✓ Gas: 28 m/sec ✓ Liquid: 15 m/sec

### APPLICABLE

PIPE MATERIAL	FLUID
Stainless Steel	Natural Gas
Carbon Steel	Nitrogen
Cast Iron	Steam
Concrete	Crude
Copper	Water
PVC	Fuel
	PGL
	Oil



## LINE STOP SERVICE

### SOURCE

- Complete set of equipment up to 20" at Jubail – KSA
- Equipment made 100% in US
- International Master Technician – 30 years of experience
- Trained and certified local crew

### TECHNICAL SUPPORT

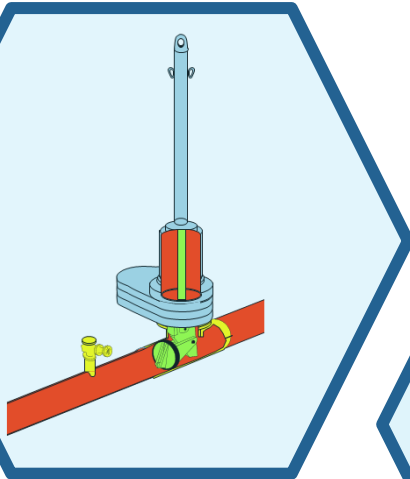
- Hot Tapping engineering department provide:
  - ✓ Line Stop Assessment
  - ✓ Line Stop Customized Procedure
  - ✓ Equipment Data Sheet
  - ✓ Line Stop Calculations
  - ✓ Execution Report



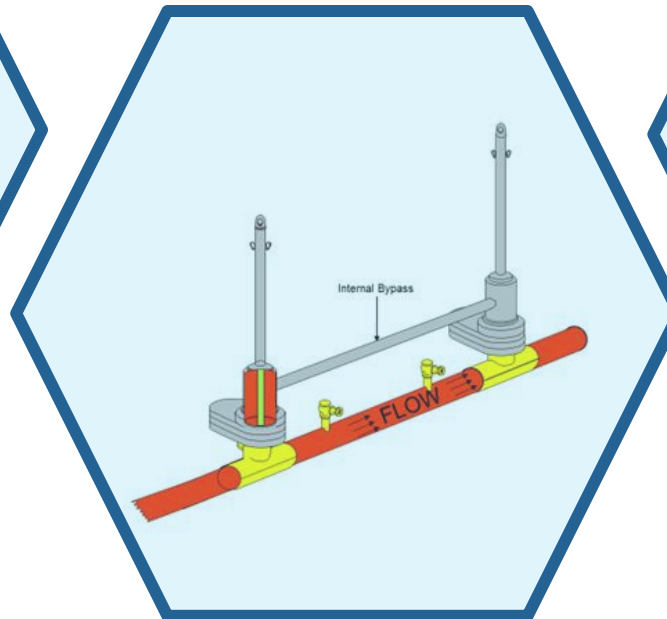
## LINE STOP SERVICE

### LINE STOP TYPES

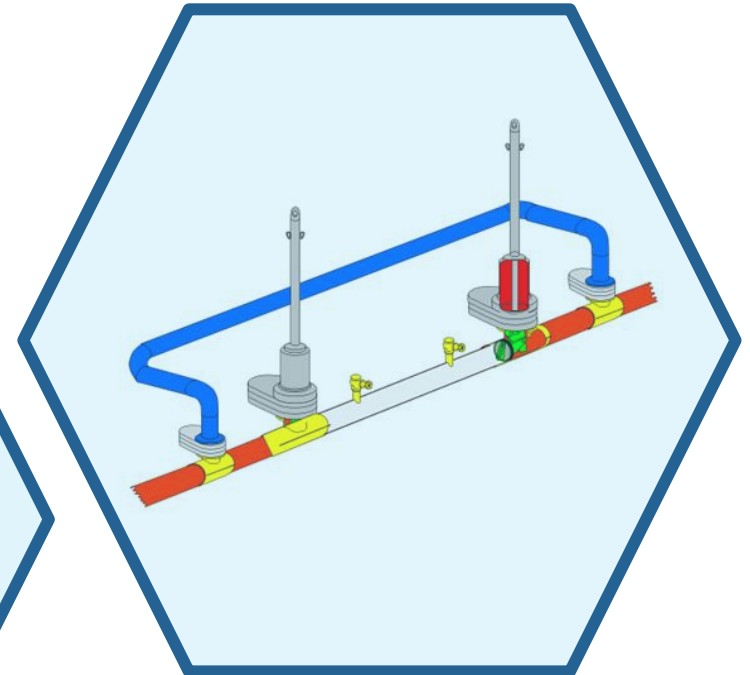
#### SINGLE



#### INTERNAL BYPASS



#### EXTERNAL BYPASS

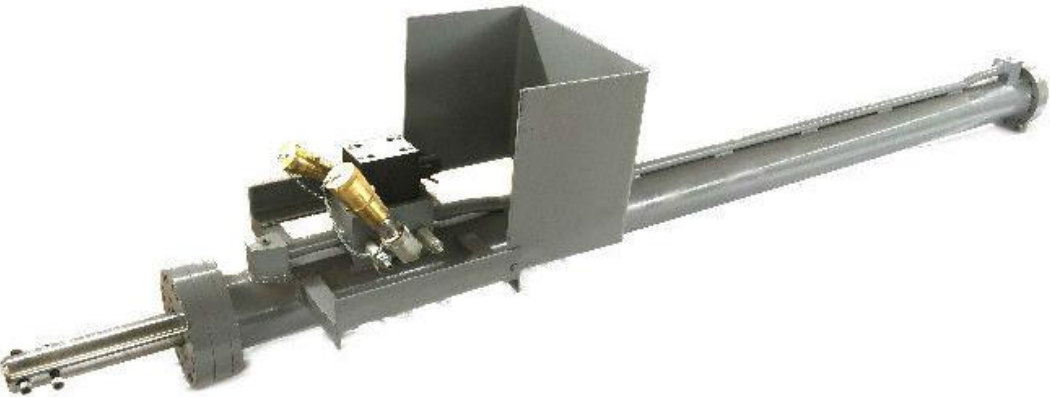


# LINE STOP SERVICE

## EQUIPMENT FLEET – JUBAIL KSA

### HYDRAULIC ACTUATORS - 1480PSI - 102 Bar

REF	RANGE	TRAVEL BAR	DIAMETER BAR	MOP
LSA-312	3" - 12"	72"	2.000"	1480 PSI
LSA-1420	14" - 20"	140"	3.500"	1480 PSI




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**ENR PRODUCTS**

### LINE STOP ACTUATORS



ENR Linestop Actuators are available in a range of sizes to suit corresponding size and rating plugging systems. Hydraulic Actuators are available for all size ranges 3" thru 48". These Actuators have correspondingly longer Control Bar Travel to allow insertion of the Plugging System through the larger Valves and Fitting Branches and higher pressure up to 1480 PSI.

HYDRAULIC ACTUATORS MODELS				
PART NUMBER	DESCRIPTION	CONTROL BAR TRAVEL	MAOP	CONTROL BAR DIAMETER
LSA-0312-FX	3" - 12" HYDRAULIC ACTUATOR	72"	1480 PSI	2"
LSA-1420-FX	14" - 20" HYDRAULIC ACTUATOR	103"/140"	1480 PSI	3.5"
LSA-2234-FX	22" - 34" HYDRAULIC ACTUATOR	140"	1480 PSI	4"
LSA-3648-FX	36" - 48" HYDRAULIC ACTUATOR	140"	1480 PSI	5.5"

Hydraulic Hydraulic Actuators are supplied with Aeroquip style quick release connectors to the hydraulic system as standard. This style connector matches the connectors as supplied with the Hydraulic Power Units necessary to operate the hydraulically powered Tapping Machines and Sandwich Valves.

We are able to modify the connector type to meet the customer's individual specification if required.

PLEASE CONSULT THE FACTORY REGARDING YOUR INDIVIDUAL REQUIREMENTS

Hydraulic Actuators are fitted with Control Bar clamps to minimize Hydraulic creep due to thermal expansion.

## LINE STOP SERVICE

### EQUIPMENT FLEET – JUBAIL KSA

#### SANDWICH VALVES

Range: 4" – 20"

Pressure: ANSI 600# - 1480PSI

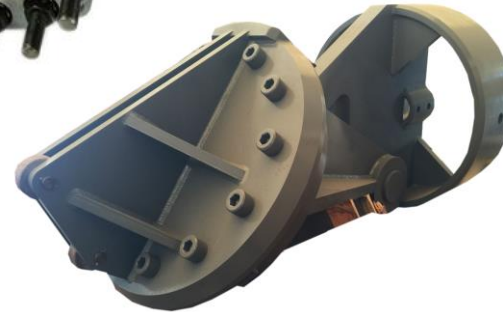
Made 100% in USA



#### PIVOTING PLUGGING HEAD

Range: 3" – 20"

Pressure: 1500PSI



#### LINE STOP HOUSINGS

Range: 4" – 20"

Pressure: ANSI 600# - 1480PSI

Available: 3 Way



## FITTING

### FITTINGS

Type: Hot Tap - Line Stop - Threaded

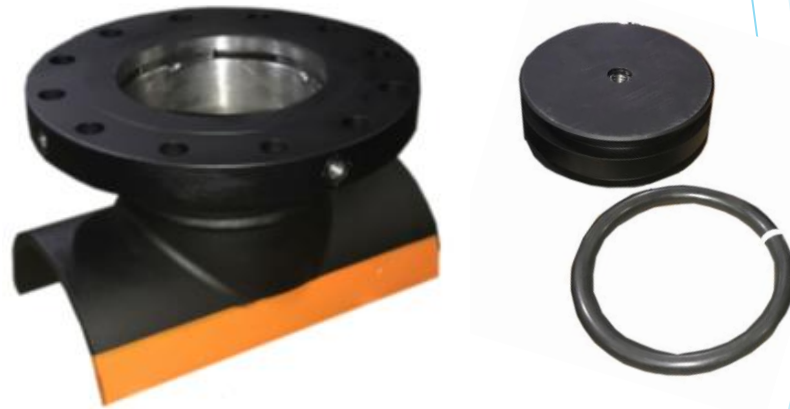
Size: 4" – 48"


Available: ANSI150/300/600/900

Design Codes: B31.1/B31.3/B31.4/B31.8

Lock O-Ring: Buna N, Viton, Aflax, EPDM

NDE Test: X-Ray Report



HOT TAP FITTING	LINE STOP FITTING	THREADED FITTING	
Standard	Standard	Threadlock / Weldolet	
3Way	3Way	Threadlock 3Way / Weldolet 3Way	
Nozzle	Spherical	TOR 2"	
Spherical	Completion	* Bronze	
45° Inclination	* Standard	* Cust	
	* Scarfed Nipple	* Steel	

## FITTING

### SOURCE

- ✓ Design 100% in USA
- ✓ Fabrication in-house – Jubail – KSA
- ✓ Customized Fittings – Made 100% in our plant in USA

### TECHNICAL SUPPORT

- ✓ Design Package
- ✓ Calculation Package
- ✓ MTR's
- ✓ Xray - Report
- ✓ Hydrotest – Available

