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INSTALLATION PROCEDURE FOR CAMERON ALL-WELDED BALL VALVES

I. Handling of Valves

The valves should be lifted such that the body supports the load. The journal and the end connection necks are suitable places to attach lifting slings. Valves should not be lifted by the operator handwheel or the operator.

II. Position of Valve

The valve may be installed in any position and either end of the valve may be installed as the upstream end.

III. Protection of Plug During Installation of Valve

- A. The plug should be fully open during the installation of ball valves.
- B. If the plug must remain in the closed position during installation of ball valves the exposed surfaces of the plug should be coated with grease. This is to protect the plug from damage due to weld splatter.

IV. Welding Instructions

- A. When preheating, welding or stress relieving, body temperatures must not exceed 400°F at any point beyond 3" from the weld. Use tempil sticks to check temperature.
- B. Before Cameron ball valves are welded into final position in the pipeline, it is recommended that the valve seal areas (ball to seat area and seat to end connection area) be covered with 1" wide masking tape from the 3 o'clock to 9 o'clock position. This will help prevent any foreign material from becoming lodged in these areas. It is also suggested that the piping system be pigged before operation or pressure testing to remove any foreign material from the pipeline.

Reference Engineering Bulletins: EB-826B and EB-3016B