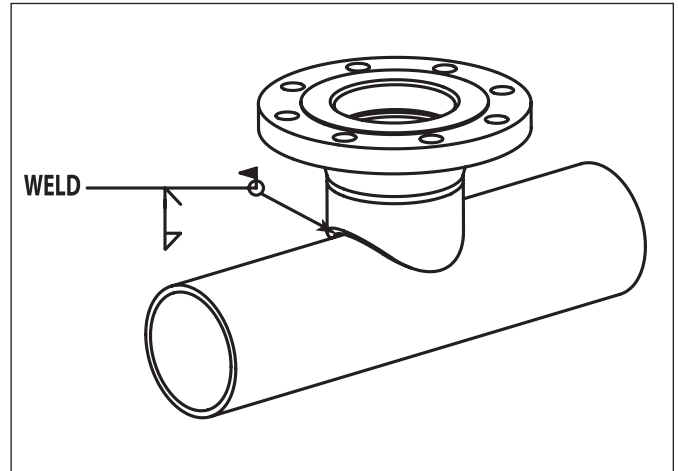


Dresser Blackhawk

Pressure Control Nipple Type Fittings

1. Check the installation location for roundness.
2. Clean the pipe thoroughly. The installation area should be free of all dirt, oil, rust, paint, or other contaminants.
3. Remove plug from fitting. The NPT threaded cap or blind flange may be reinstalled on the fitting to prevent weld spatter from damaging threads and/or O-ring sealing surface. If reinstalling the NPT threaded cap for this purpose, the cap should only be threaded on to the fitting hand tight.
4. Center and level fitting. Maintain gap for proper weld penetration. Do not weld inside fitting.
5. Welding should be done in accordance with the applicable sections of ASME B31. Preheat may not be possible or practical on a flowing pipeline. Blackhawk's standard fitting design and materials do not require preheat under normal pipeline conditions.
6. After welding is completed, allow sufficient time for cooling. Inspect and clean threads and/or sealing surfaces of fitting as required, both internally and externally.
7. Visually inspect for cracks, lack of fusion, undercuts, etc. Additional non-destructive examination may be required as part of the pipeline operator's standards or other regulatory requirements.
8. Pressure test fitting installation before hot tapping. Care must be taken not to exceed collapse pressure of pipe.



NOTE: USE QUALIFIED TAPPING OPERATOR AND WELL MAINTAINED EQUIPMENT TO ASSURE TAP IS MADE IN GOOD ALIGNMENT WITH FITTING



Dresser™ Pipeline Solutions

41 Fisher Avenue
Bradford, PA 16701
P: 814.362.9200
F: 814.362.9344
www.dresserngs.com

© 2018 Natural Gas Solutions North America, LLC. The Dresser Logo and all Trademarks containing the term "Dresser" are the property Dresser, LLC, a subsidiary of Baker Hughes, a GE Company.