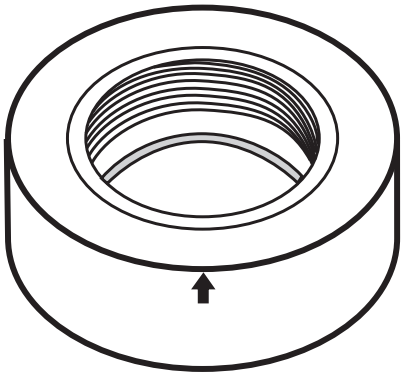
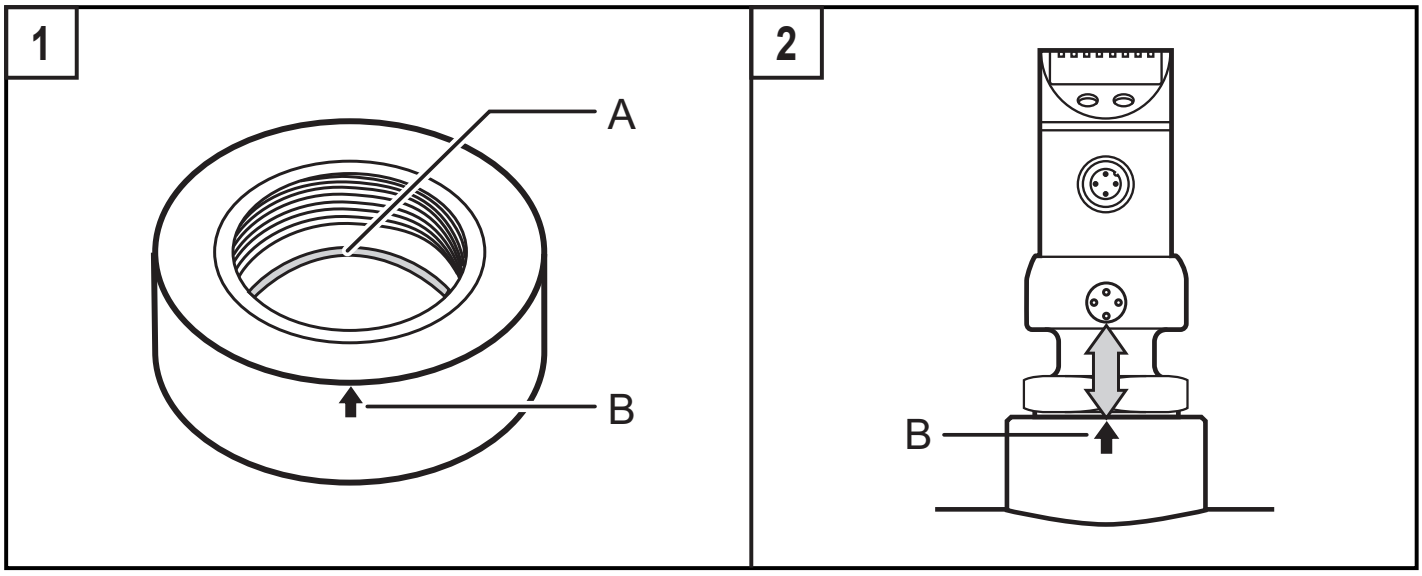
Installation Instructions
Welding adapter

UK

G1 / G¾

706013/02 08/2017





A: Groove for the O-ring (E30072 only); B: Marking for alignment

Order no.	Type	Material	Pressure rating *
E30009	G¾ - Ø 50mm	stainless steel (316S12)	25 bar
E30013	G1 - Ø 50mm	stainless steel (316S12)	150 bar
E30060	G1 - Ø 50mm	steel (1.0570)	50 bar
E30072	G1 - Ø 50mm	stainless steel (316S12)	150 bar

* for the connection sensor - adapter
E30072 is supplied with a Viton O-ring and an EPDM O-ring

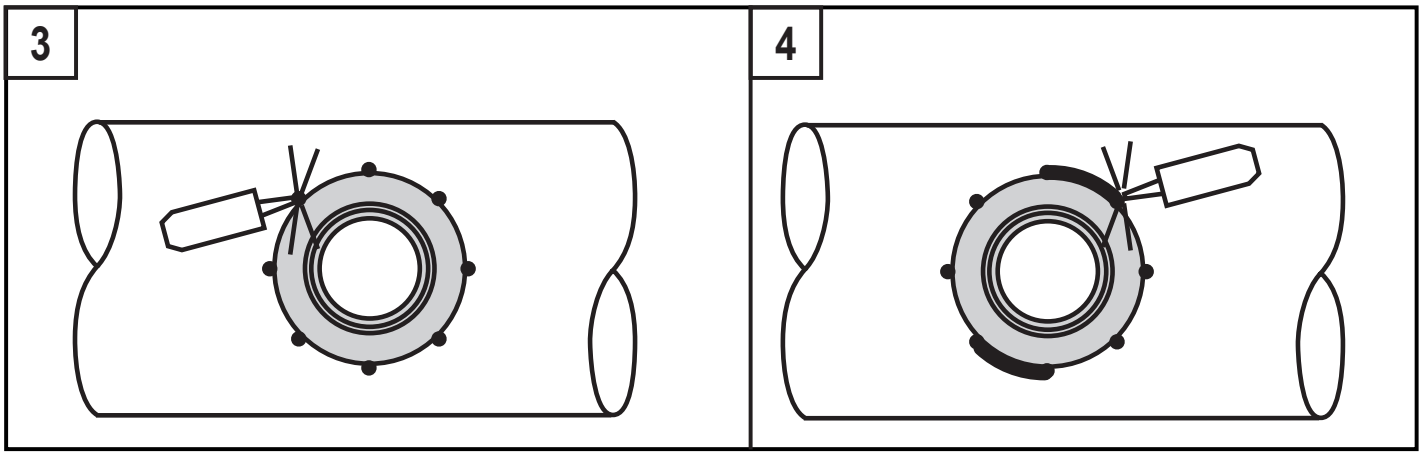
Note

- The welding operation must be carried out by authorised personnel.
- It must be carried out carefully and according to state-of-the-art technology.
- During welding and the following cooling phase, neither sensor nor O-ring must be in place.
- The surfaces must be free from soiling of any kind.
- Welding tools must be suitable for the adapter and wall material.

Preparations

- Bore a hole in the pipe or housing wall with the outside diameter of the adapter (max. oversize: 0.2 mm).
- If possible, screw a welding mandrel into the adapter (order no. E30435 for G1 thread, order no. E30071 for G3/4 thread).

Welding operation



- ▶ Align the adapter: Turn the marking to the position provided for the connector / display of the screwed sensor (see figure 2).
- ▶ Fix the adapter at several points with sufficient holding force, apply the fixing points at equal distance opposite each other (see figure 3).
- ▶ Apply the welding seams between the fixing points opposite each other (see figure 4). Ensure sufficient intervals between the individual sections (cooling phases to avoid glowing through / warping of the adapter due to overheating).

The power of the welding device must be adapted to the thickness of the wall.

After welding

- ▶ Let the adapter cool down.
- ▶ Clean the thread from welding residues.
- ▶ Grease the thread with lubricating paste.

  The paste must be suitable and approved for the application and compatible with the elastomers used.
- ▶ For the adapter E30072, place one of the supplied O-rings in the groove of the adapter (Viton or EPDM O-ring, depending on the fluid). It must snap flush into the groove over its whole circumference (see figure 1).

Note: If the sensor can only be screwed into the thread with great resistance, apply no force.

If it is not possible to rectify the thread, remove the adapter and weld in a new one.