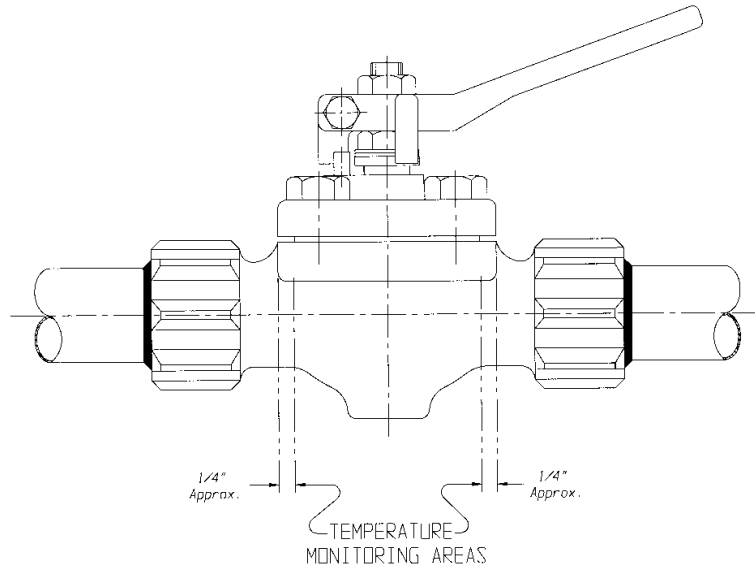


Welding Without Disassembly



Cam-Tite Ball Valves can be welded into the pipeline without disassembly provided certain procedures and precautions are followed. The valve must be in the open position during welding and should remain open until it cools to ambient temperature. Welding procedures in accordance with Section IX of the ASME Boiler and Pressure Vessel Code should be utilized. In addition, a Tempilstik (350 degrees F for PTFE and RTFE seats and seals or 200 degrees F for UHMWP seats and seals) must be used to monitor the temperature at the seat/gasket area. This

is the area in line with the body/cover flange as shown above. Welding should be controlled such that the maximum temperature in this area remains below that of the rated Tempilstik. A tremendous amount of time and trouble associated with the dismantling and reassembly of welded valves is avoided, but more importantly, the integrity of the factory hydrostatic and seat testing is maintained when following these procedures.

See page 42 for weld end machining standards.

Drilled, Tapped And Plugged Drain Bosses

All Cam-Tite Ball Valves have an integrally cast drain boss on the bottom side of the body. This drain boss can be drilled, tapped, and plugged if draining of the valve cavity is required. The standard drilling is 1/4" NPT on 1/2" through 2" sizes and 1/2" NPT on 3" through 6" sizes. Carbon steel valves are furnished with ASTM A193 GR

B7 plugs while stainless steel valves are furnished with ASTM A193 GR B8 plugs. (Consult the factory for specifications of drain plugs supplied on other body materials.) Specify valves "Prepared with Tapped and Plugged Drain Port" using code "D" in the configuration number when ordering.

Stem Extensions

The Cam-Tite Ball Valve can be supplied with a variety of designs to support applications which require extended stems. Stem extensions can be provided in carbon steel and stainless steel

materials of construction and can be specified in a wide range of lengths for complete versatility.

See pages 43-45 for information on ordering stem extensions for Cam-Tite valves.