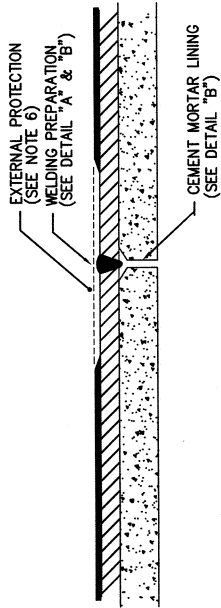
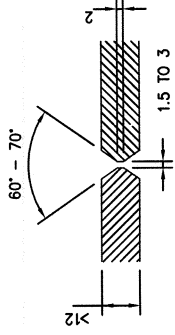


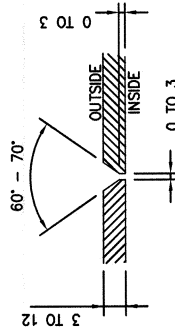
**BUTT WELD FOR PIPES  $\geq$ DN 750 TO DN 1200**  
(WELDED FROM BOTH SIDES)



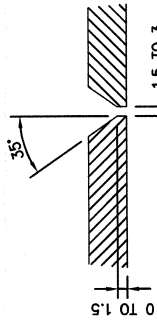
**BUTT WELD FOR PIPES < DN 750**  
(WELDED FROM OUTSIDE ONLY)



**DETAIL "C2"**  
(FOR BARREL THICKNESS > 12)  
(SEE NOTE 4)

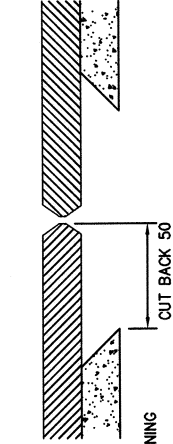


**DETAIL "C1"**  
(FOR BARREL THICKNESS < 12)  
(SEE NOTES 4 & 5)



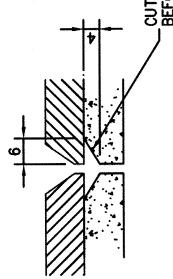
**DETAIL "A"**

WELD PREPARATION FOR PIPES < DN 750



**DETAIL "D"**

MORTAR PREPARATION  
CEMENT LINED PIPES  $\geq$ DN 750 TO DN 1200  
(WELD PREPARATION SHOWN FOR THICKNESS >12)



**DETAIL "B"**

MORTAR PREPARATION  
CEMENT LINED PIPES < DN 750

**NOTES**

1. ALL DIMENSIONS IN MILLIMETRES.
2. NO JOINT DEFLECTION ALLOWED WHERE BUTT WELDING IS CARRIED OUT.
3. CUT BACK COATINGS AT LEAST 100 FROM NEAREST ASSEMBLY WELD.
4. ALL WELDING TO BE FULL PENETRATION BUTT WELDS CARRIED OUT AND TESTED IN ACCORDANCE WITH AS/NZS 1554.1 CATEGORY SP.
5. IN DETAIL "C1", FOR THICKNESS <12, WELD OUTSIDE FIRST, THEN BACK GOUGE TO SOUND METAL BEFORE WELDING INSIDE.
6. REINSTATE EXTERNAL PROTECTION IN ACCORDANCE WITH MANUFACTURERS SPECIFICATIONS.
7. COMEIN SPACES TRAINING AND SAFETY MANAGEMENT PLAN ESSENTIAL BEFORE ENTERING PIPE.
8. WHERE SAFETY REASONS PREVENT ENTRY TO PIPE, ONE SIDED WELDING MAY BE AUTHORISED FOR PIPES <750.

**CAUTION**  
AXIAL DEFLECTION OF PIPES TO BE JOINED IS NOT PERMITTED.

MRC STANDARD DRAWINGS SUPERCEDES WSAA STANDARD DRAWINGS

<b>C 5/9 AMEND MGR SYN.</b>		DRAWING FILE NAME M:\Engineering Services\Technical Services\Design\Projects\Standard drawings\Mackay Water\WSAA MRC\WAT CODE\A3-04305B		<b>COMMERCIAL SERVICES</b>		<b>Mackay REGIONAL COUNCIL</b>	
B	MAY08	MODIFIED TO MRC STD	SLR	SURVEY N/A		DRAWING No. A3-04305	
A	OCT07	TSEER TO MRC TBLOCK	SLR	SURVEY FILE No N/A		STANDARD DRAWING TYPICAL STEEL PIPE JOINTING	
0		WSAA ORIG.		LEVEL DATUM A.H.D.		AMEND. <b>C</b>	
NO.	DATE	DESCRIPTION	APPVD.	MERIDIAN	MGA-55	JOB No	SHEET 1 OF 1
						27 MAY 09	
						JASON DEVITT	DATE
						EXECUTIVE MANAGER MACKAY WATER & WASTE RPEQ 7506	
						WSAA NO. WAT-1400	
						WATER SERVICES ASSOCIATION of Australia	