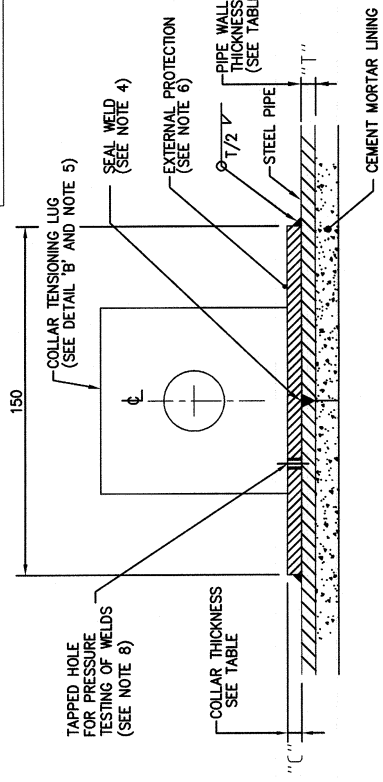
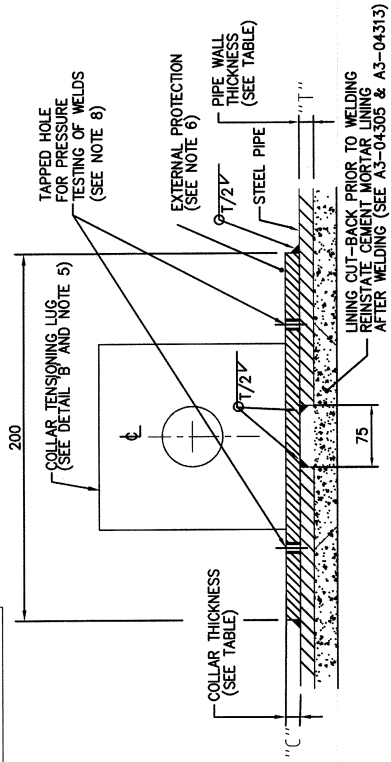


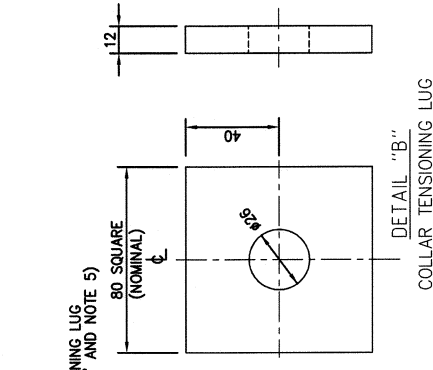
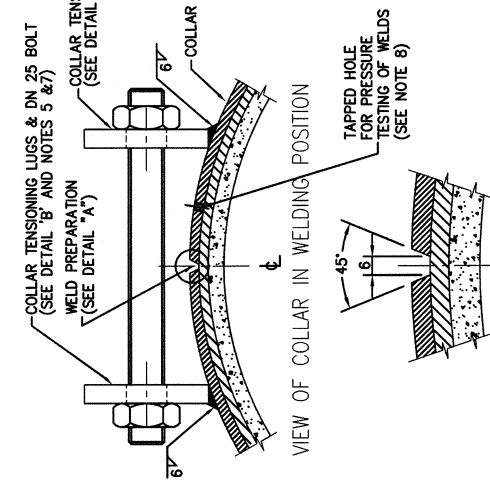
CAUTION AXIAL DEFLECTION OF PIPES TO BE JOINED IS NOT PERMITTED.



COLLAR FOR PIPES < DN 750



COLLAR FOR PIPES ≥ DN 750 TO 1200



PIPE SIZE		PIPE WALL THICKNESS	COLLAR THICKNESS
DN	TO	"T"	"C"
100	TO 225	5	6
250	TO 350	5	6
400	TO 750	5	6
800	& OVER	8	10
		10	12
		6	8
		8	10
		10	12
		12	16
		16	20
		20	25
		25	32

NOTES

- ALL DIMENSIONS IN MILLIMETRES.
- STEEL USED FOR COLLARS TO BE IN ACCORDANCE WITH AS/NZS 3678.
- WELDING TO BE IN ACCORDANCE WITH AS/NZS 1554.1 CATEGORY 'SP'.
- SEAL WELD TO CONSIST OF A SINGLE CONTINUOUS WELD BEAD AROUND PIPE AND TO BE GROUND FLUSH WITH PIPE OD PRIOR TO FITTING COLLAR.
- REMOVE BOLTS & WELDING LUGS AFTER COLLAR HAS BEEN WELDED. GRIND FINISHED SURFACES FLUSH.
- WRAP EXTERNAL SURFACE USING A BITUMEN IMPREGNATED TAPE WRAP SYSTEM.
- WRAP AROUND CHAIN TENSIONERS MAY BE USED AS AN ALTERNATIVE TO COLLAR TENSIONING LUGS.
- PROVIDE A TAPPED HOLE TO ALLOW THE GAP UNDER THE COLLAR TO BE PRESSURISED TO COMPLY COMPLETE WELDING INTEGRITY. HOLE TO BE PLUGGED ON COMPLETION OF TEST.
- WHERE SAFETY REASONS PREVENT ENTRY TO PIPE, ONE SIDED WELDING MAY BE AUTHORISED FOR PIPE >DN750 PROVIDED WELD SIZE IS INCREASED TO "T".

TYPICAL WELD PREPARATION

<b>Mackay REGIONAL COUNCIL</b>		DRAWING No. <b>A3-04307</b>	
STANDARD DRAWING TYPICAL STEEL PIPE JOINTING WELDED PIPE COLLARS		AMEND. <b>C</b>	
<b>COMMERCIAL SERVICES</b>		SHEET 1 OF 1	
EXECUTIVE MANAGER MACKAY WATER & WASTE RPEQ 7606		DATE <b>27</b> MAY 09	
JASON DEVITT		DATE	
DRAWING FILE NAME M:\Engineering Services\Technical Services\Design\Projects\Standard drawings\Mackay Water\WSAA MRC\WAT CODE\A3-04307B		WSAA NO. <b>WAT-1402</b>	
SURVEY FILE No N/A		DATE OF LAST EDIT May 21, 2009	
LEVEL DATUM A.H.D.		JOB No	
APPVD. MERIDIAN MGA-65		WATER SERVICES ASSOCIATION of Australia	
<b>C</b> S/S AMEND MCR 5491	SLR	SURVEY N/A	
B MAY08 MODIFIED TO MRC STD	SLR	DATE OF LAST EDIT May 21, 2009	
A OCT07 T'SFER TO MRC TBLOCK	SLR	JOB No	
0 WSAA ORIG.	APPVD. MERIDIAN MGA-65	WATER SERVICES ASSOCIATION of Australia	
NO DATE DESCRIPTION	APPVD. MERIDIAN MGA-65	WATER SERVICES ASSOCIATION of Australia	