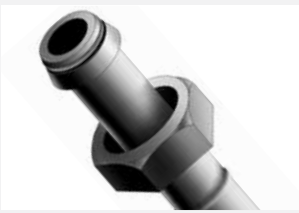


Weld fitting



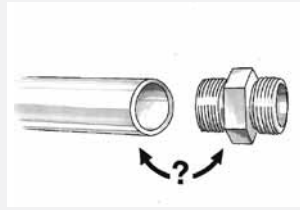
Weld fitting assembly

- EO weld nipple and weld fitting
- ⚠ Use weldable material
- ⚠ Depending on application or project specification, special requirements may apply for: Tube preparation, welding process, operator qualification, inspection of welding connection and surface finish



Tube preparation

- Cut and deburr thoroughly
- Do not assemble under tension
- Clamp onto rigid fixtures

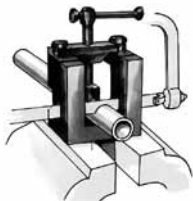


Material combinations

- Select suitable tube material

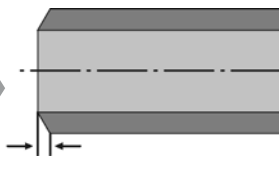
Fitting material	Tube specification
Steel	Weldable Steel
Stainless Steel	Weldable Stainless Steel

1



- Cut tube squarely
- max $\pm 1^\circ$ deviation
- ⚠ Do not use pipe cutters
- EO tube-cutting tool (AV) for manual cutting

2



- Bevel tube-end similar to weld nipple bevel

Assembly

3



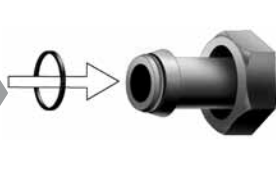
- Slide nut onto tube-end
- Weld fitting onto tube-end
- Fitting and tube must be aligned
- ⚠ Remove all elastomeric seals before welding

4



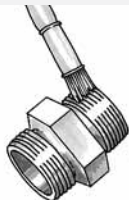
- Clean weld
- Calibrate inner diameter
- Check welding quality
- Surface protection if necessary

5



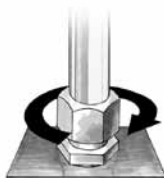
- Assemble O-ring
- Lubricate O-ring for easy assembly
- Avoid damage or twisting of O-ring

6



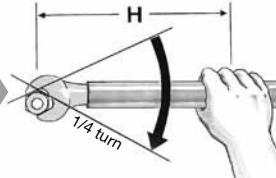
- ⚠ Threads of stainless steel fittings must be lubricated
- ⚠ Use EO-NIROMONT special high-performance lubricant for stainless steel fittings

7



- Assemble fitting until wrench-tight (without spanner extension)

8



- ⚠ Then tighten fitting firmly by $\frac{1}{4}$ turn ($1\frac{1}{2}$ flats)
- ⚠ The body must be held rigid