



Installation, Operating and Maintenance Instructions

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Specialists In Liquid Level Indication

Welding Pad Gages

INSPECTION AND DELIVERY

Upon receiving gage check all components carefully for damage incurred in shipping. Confirm that gage model number meets application specifications. Also confirm that the material is compatible with both process fluid and surrounding atmosphere for your application.

CAUTION: Jerguson gages are not to be used for gaging lethal substances as defined by ASME Section VIII.

WELDING INSTRUCTIONS

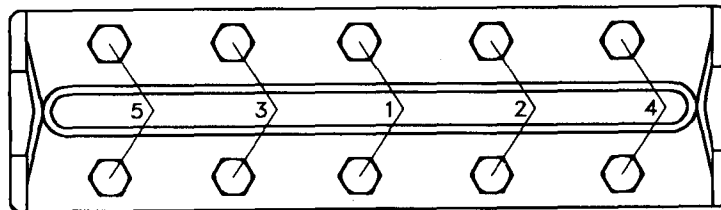
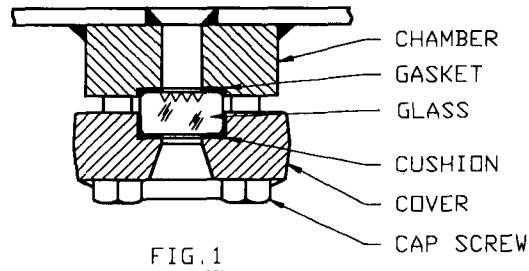
Welding pad gages are shipped loosely assembled and should first be entirely dismantled. The pad may then be used as a template for laying out the vision slot which is to be cut through the wall of the tank. If internal welding is to be performed, the width and length of the slot can be increased by chalking a second cutout line 1/4" away from the scribed line obtained in tracing the vision slot. This will provide a suitable shelf in which to lay the bead as shown in Figure 1.

To avoid buckling, the pad should be tack welded at intervals, both internally and externally, in accordance with recognized welding procedure before placing the continuous welds.

As an added precaution against distortion, the welding pad gage can be assembled without gaskets, using a steel spacer instead of the glass inserts. This spacer can be cut from bar stock 1" x 1/2" for the series 12 gages and 1-1/4" x 3/4" for the series 20 gages. Its length will be determined by the length of the gasket recess. This procedure will increase the rigidity of the pad and minimize the possibilities of distorting the glass seating surface during welding.

CAUTION: Pressure Loads: Where it is necessary to slot the tank because of the nature of the liquid or there is need to observe the color or interface of the liquid, the following facts must be considered: Standard welding pad gages will withstand loadings due to the pressure within the gage itself, but they are not designed to replace the tank strength lost when the tank wall is cut. The gage manufacturer has no control over the loading which the pressure vessel will impose on the pad. It is therefore impossible to rate welding pad gages. The tank fabricator must provide suitable tank wall reinforcement to prevent the pad from being distorted during welding or while under operating conditions.

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ASSEMBLY INSTRUCTIONS

Assemble gage in accordance with the section view, Figure 1. Tighten center bolts to 5 foot pounds and then, working toward alternate ends as indicated by consecutive numbers shown in Figure 2, tighten the remaining bolts. Repeat this procedure, still using 5 foot pounds torque until all bolts are uniformly tightened to this value.

The torque wrench can then be set to 10 foot pounds and the same procedure followed.

A final setting of 15 foot pounds is generally sufficient to prevent leakage at the maximum pressure to which the vessel will be subjected.



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