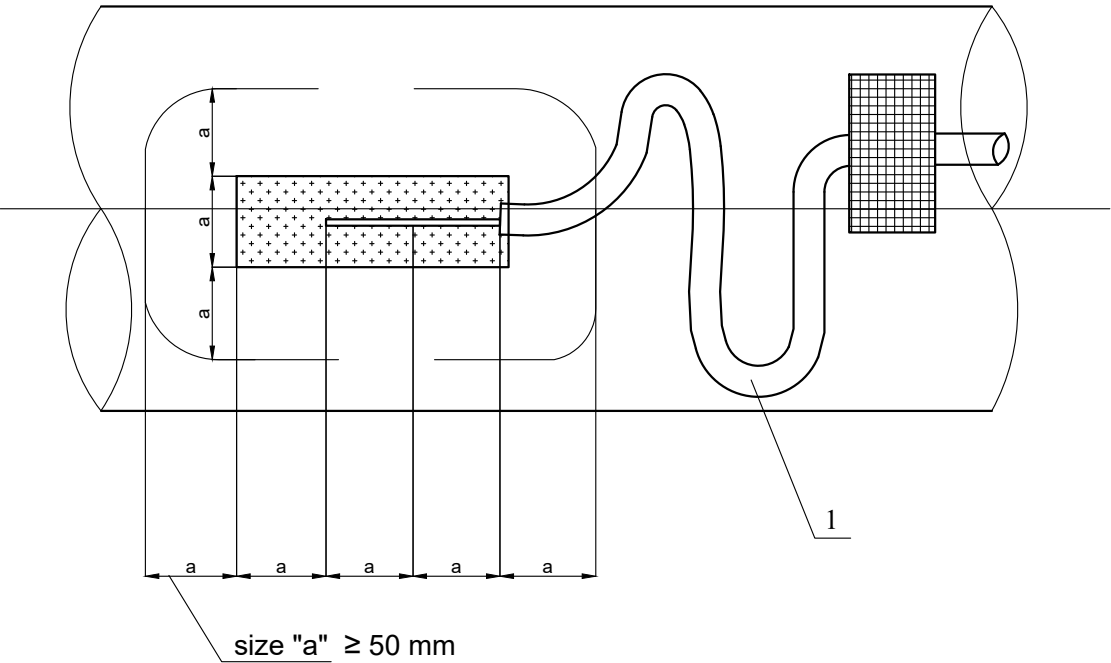
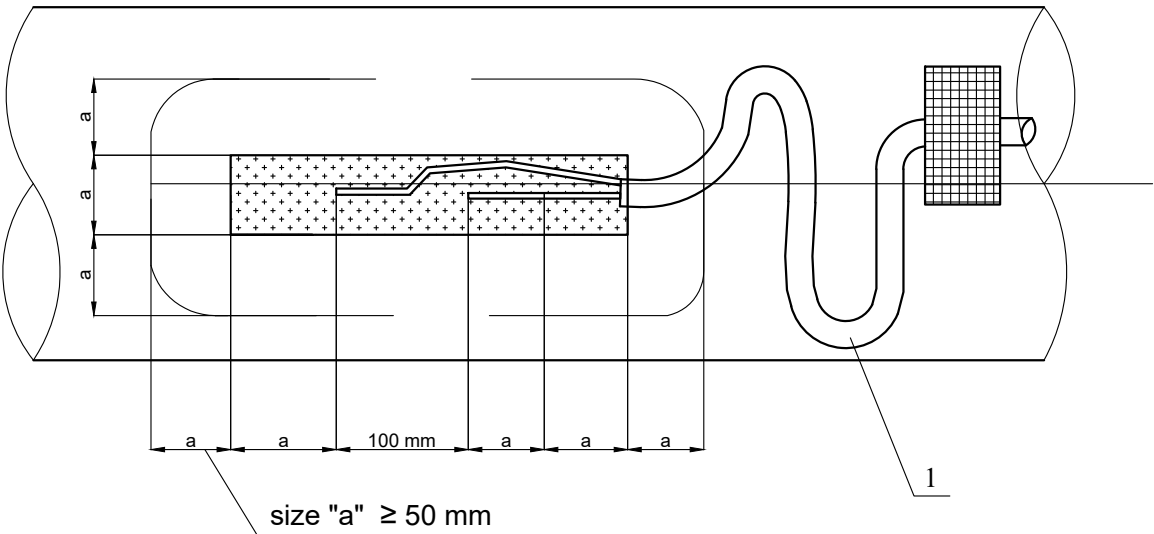


Single line cable connection to the pipeline with pin brazing




Dual line cable connection to the pipeline with pin brazing



#	Indication	Name	Qty.		Unit Mass, Kg	Note
			Single-wire	Two-wire		
1	ГОСТ 16442-80 *	Cable ББГ, cut per project				
2	ТУ У 24.6-32154127-001:2005 class Б (5053913)	Polyurathane cover ЦЕЛ-600	0,18	0,35		kg
3	ТУ 1793-001-36235411-96	Copper pin brazing mixture	0,054	0,108		kg
4	ТУ 1793-001-36235411-96	Pin brazing match	2	4		pcs

1. Connection of copper cable to the pipeline is carried out using copper pin brazing mixture (position 3). Pin brazing location shall be located no less than 100 mm from the pipe welded joints.
2. Cable welding sections shall be stripped from coating, cleaned till metal is shiny and benzine or acetone .
3. To the length of welding , from the ends of cable (no less than 6 meters of cable) coating will be removed and will be cleaned using benzine or acetone. Cable will be delivered to the connection point with the loop and attached to the pipe with coating tape.
4. Form will be located on the point of welding, manufactured from grafite and with magnet cable connectors to be attached to the pipe during welding. On the bottom of the combustion chamber of the form, copper membrane will be put with the thickness of 0.3mm in accordance with the diameter of the chamber. Bore ends of the cable shall be put in the form and pin brazing mixture shall be applied. Mixture will be lit using pin brazing match.
5. Following the completion of welding residues shall be removed and connection point shall be coated ЦЕЛ-600 (position 2) or similar type other coating lacquer ЦЕЛ-600 shall be put on МБ primer. Thickness of lacquer layer 2.5-3mm.

Approved by	A. Dekanosidze		East - West Gas Main Pipeline Kobuleti Branch		
Checked by	T. Javakhishvili		Cable to connect the pipeline with thermal-welding		
Completed by	S. Tsintsadze		DCC NUMBER: K0BU60-GW05-PL-CPR-00012		
Drawn by	A. Farii		SHEET No. 1(1)		
REV.	C01		No:		
01/05/2016 / DATE	30/05/16		SCALE:		