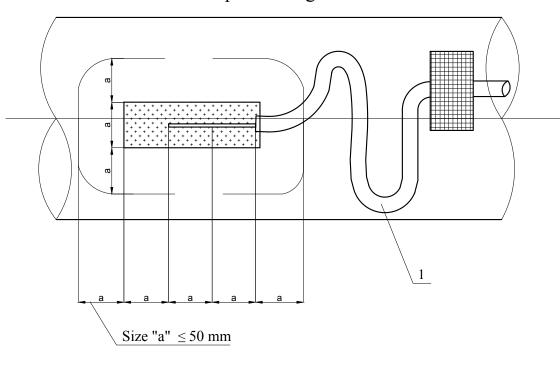
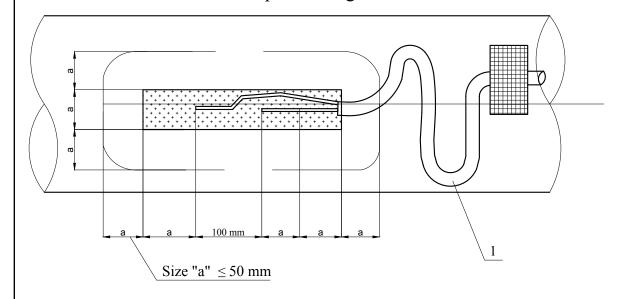
Single line cable connection to the pipeline with pin brazing



Pos.	Indication (Code)	Name	Quantity		Unit	Note
	indication (code)	ivame	Single-wire	Two-wire	mass, kg	Note
1	ГОСТ 16442-80 *	Cable ВВГ, cut per project				
2	ТУ У 24.6-32154127-001:2005 klasi 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

Dual line cable connection to the pipeline with pin brazing



- 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.

Note: The contractor shall ensure purchase and installation of all materials and equipment envisaged by the project and which will not be handovered to contractor by GOGC

	Approved by Head of Eng.Unit Designed by Drawn by	of Eng.Unit K. Teliashvili ened by L. Mamulashvili			 	
	REV.	C01	C02		Georgian Oil & Gas Corporation	
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Adigeni - Goderdzi Gas Main Pipeline
Construction Project

Connecting the cable to the pipeline using thermal-welding

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