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TECHNICAL BULLETIN

Installing 8613-22 Valves

MVTB-03-001, Page 1 of 2

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This bulletin presents proper technique for installation of 8613-22 valves, particularly with respect to prevention of overheating of seats during soldering/brazing.

The recommended practice is to have the valve in the closed position (this limits convection in the internal flow passages, which can be significant, especially on vertical runs). The mating tubing is brought to the valve for make up. A saturated wet rag is placed around the connecting tubing, on the side of the joint AWAY from the valve, to act as a heat sink during soldering/brazing. It should be noted whether soldering or brazing that heat input can and should be minimized to the degree possible.

There is a common misperception in the industry (for both solder/braze and welded valves) that wrapping the valve itself with a wet rag will prevent seat damage. The fact is that this practice ensures maximum heat is brought to the valve, and makes the chance for seat damage greatest. While the wet rag on the valve will indeed keep the surface temperature of the body at 212 F or lower, by so doing it pulls the heat across the seats from the point of flame, and the temperature in the region of the seats can exceed the limits of the material.

Other standard considerations apply, most notably making sure that side or bending loads are not transmitted through the valve, packing is retightened prior to system start up, etc.

Questions regarding this communication can be directed to Hammond Valve engineering at 262-432-2702.

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