



Reliable Connections™

3"-12"
Welded
Line
Stopper
Fittings

Installation Instructions

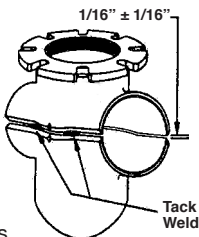
Detailed instructions are provided in form 11909, available from Mueller Co. This tag is only intended as a general guide. Welders should be qualified using low hydrogen electrodes in accordance with company approved procedures meeting requirements of API 1107 or API 1104. Fittings are not to be installed directly over pipe weld joints. Use of low hydrogen electrodes is recommended. Adjust gas flow rate in carrier pipe to assure rapid cooling of circumferential welds and corresponding heat-affected zones (HAZ) does not occur.

Step 1 - Thoroughly clean pipe and fitting.

Step 2 - Inspect pipe for defects and sufficient wall thickness.

Step 3 - Remove completion cap and completion plug.

Step 4 - Place fitting halves in installation position; aligned EXACTLY using alignment marks as guides; space between longitudinal weld lands on either side should be equal. Tack weld halves as illustrated.



(continued)

Installation Instructions (*continued*)

Step 5 - Weld longitudinal seams; no more than two passes on a seam without an equal number on the opposite seam to balance weld shrinkage.

Step 6 - Power brush and clean fitting ends.

Step 7 - Weld ends with a minimum of three passes on each. For Side-Out and Bottom-Out fittings, also weld piping to appropriate openings.

Step 8 - Inspect welds and pressure test fitting.

- a. Bolt completion cap to fitting, making sure gasket is in good condition and in place. Remove test plug and attach air line.
- b. Apply air pressure and test for leaks using soap solution (add glycerin in freezing weather), or bubble type leak detection fluid. Welds must be air tight with no leakage. Repair any leaks prior to cutting pipe.
- c. Remove air line and replace test plug. Remove completion cap.

Step 9 - Before operating drilling and stopping equipment, read and understand the available Operating Instruction Manual covering the equipment to be used.

Phone: (800) 798-3131

By deviating from the above listed instructions, you will void any product warranty and release Mueller Co. and its affiliated entities from any and all liability associated with the installation or use of this product. For details on the product's warranty, terms, and conditions, please visit www.muellergas.com.

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