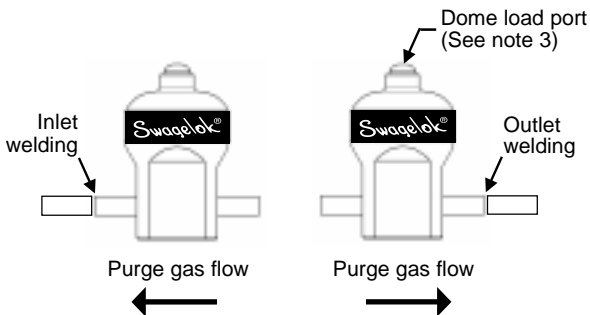


Welding Instructions

Welding should be done by qualified personnel as outlined in Section IX of the ASME Boiler and Pressure Vessel Code.

1. Use a heat sink, as necessary, to prevent excessive heating of internal components. ***With good orbital heat welding practices, the use of a heat sink may not be required.***
2. Use a high-quality purge gas to maintain cleanliness and reduce discoloration from welding.
3. If the regulator is preset from the factory, proceed to step 4. **If the regulator is not preset from the factory**, apply a minimum of 10 psig to the dome load port in the top of the regulator to keep the regulator in the open position during welding.
4. Connect the purge gas to exit out of the port being welded. *It is important that heat from the weld is carried away from the regulator, not into the regulator.*



⚠ Caution: Purge gas pressure must not exceed regulator set outlet pressure marked on the label ring.

5. Perform the welding procedure.
6. After welding, purge the regulator and system of scale, contamination, and dirt.
7. Test the regulator for leaktight integrity and operation.

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These instructions are also available in French, Italian, German and Spanish.

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Printed in U. S. A.

MS-CRD-0085

Rev. 0