



SPIRALFLUSH[®]

Welding instructions – casing systems



Welding the casing shoe

Integrated Large ID, all diameters

Forepoling, all diameters

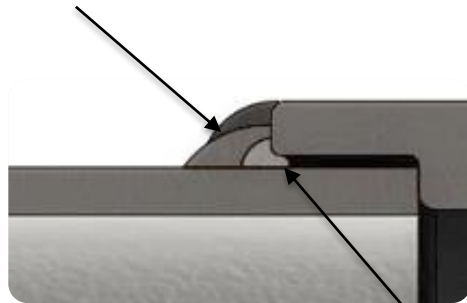
Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

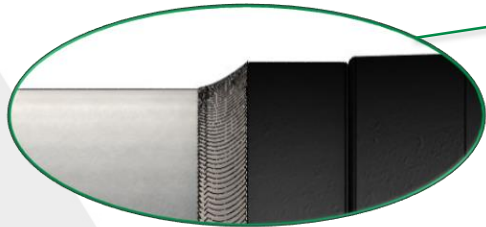
Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Weld root weld and grind it clean
3. Weld final welding/s to required dimensions
4. Make sure connection is fully welded as presented below

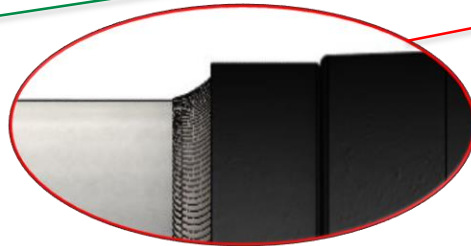
Final weldings



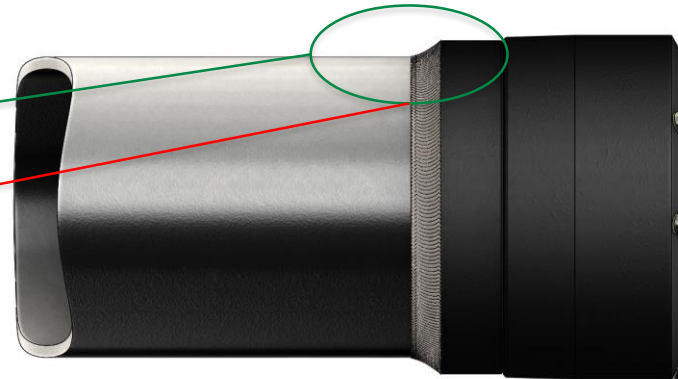
Root weld



Correct



Wrong





Welding the casing shoe OLD MODEL

Integrated thick wall, diameters < 323mm

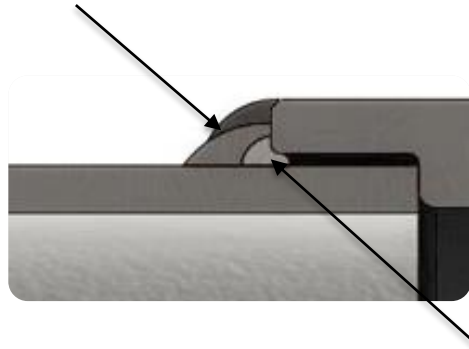
Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

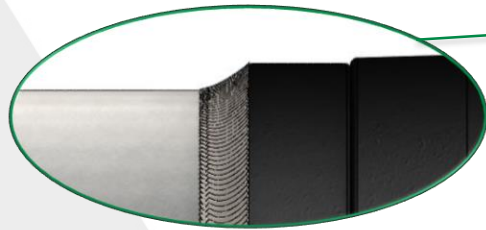
Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Weld root weld and grind it clean
3. Weld final welding/s to required dimensions
4. Make sure connection is fully welded as presented below

Final weldings



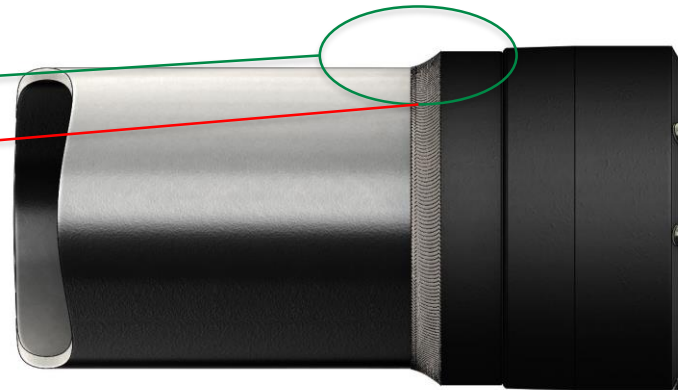
Root weld



Correct



Wrong





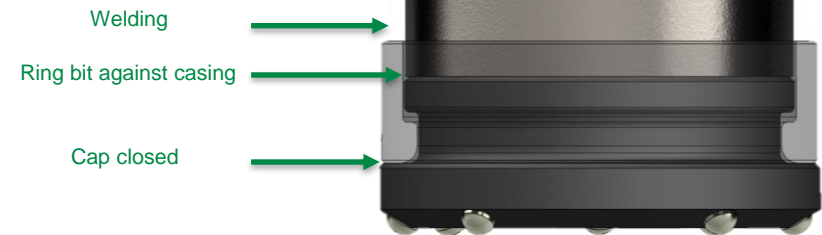
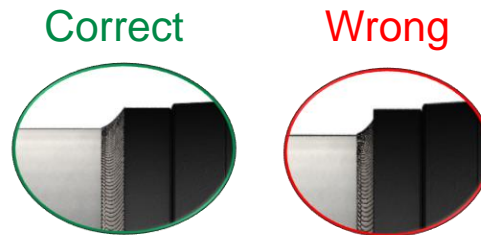
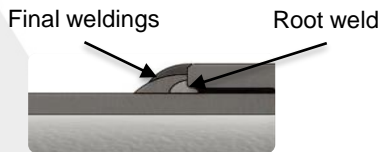
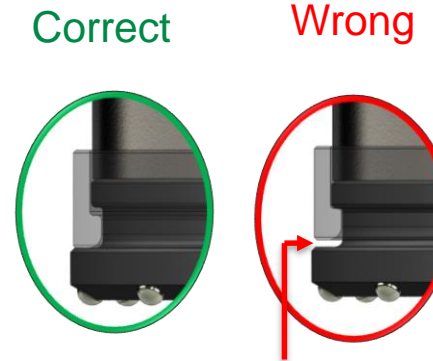
Welding the casing shoe NEW MODEL

Integrated thick wall, diameters 114-273mm

Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00
Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Make sure cap between ring bit and casing shoe is closed
3. Place the ring bit against the casing (note 2. cap closed)
4. Weld root weld and grind it clean
5. Weld final welding/s to required dimensions
6. Make sure connection is fully welded as presented below





Welding the casing shoe

Integrated thick wall, diameters $\geq 323\text{mm}$

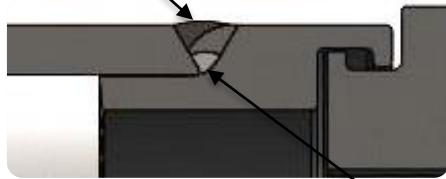
Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

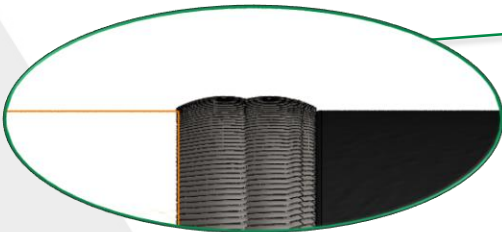
Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Weld root weld and grind it clean
3. Weld final welding/s to required dimensions
4. Make sure connection is fully welded as presented below

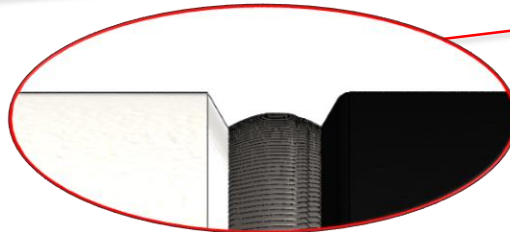
Final weldings



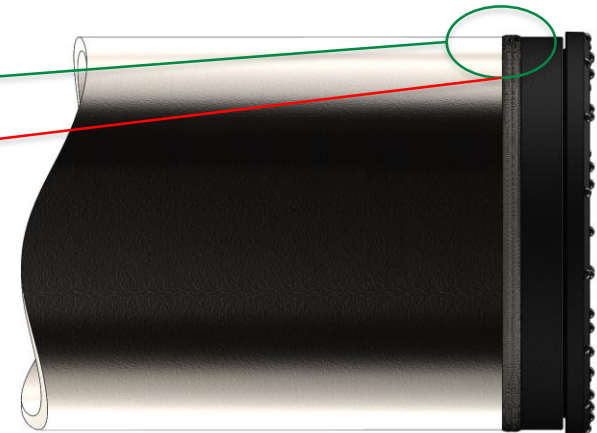
Root weld



Correct



Wrong

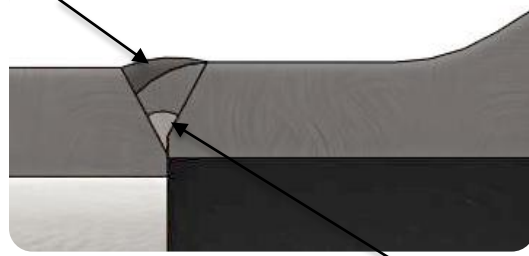




Welding the casing shoe

Retrievable, all diameters

Final weldings



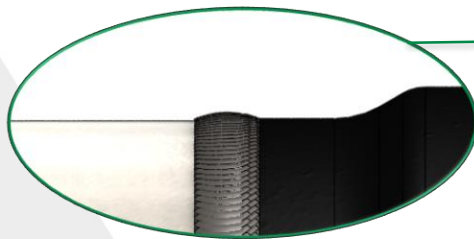
Root weld

Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

Preheating is highly recommended. (180°C welded areas)

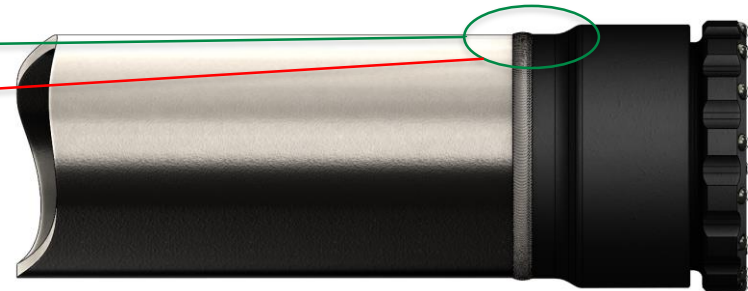
1. First grind all surfaces that are to be welded
2. Weld root weld and grind it clean
3. Weld final welding/s to required dimensions
4. Make sure connection is fully welded as presented below



Correct



Wrong





Welding the casing shoe

Retrievable, slip on type ring set

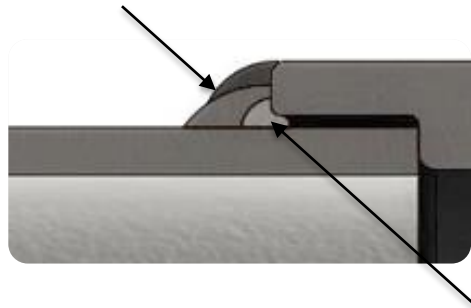
Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

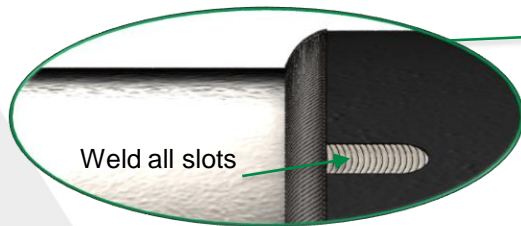
Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Weld root weld and grind it clean
3. Weld final welding/s to required dimensions
4. Weld casing shoe slots also
5. Make sure connection is fully welded as presented below

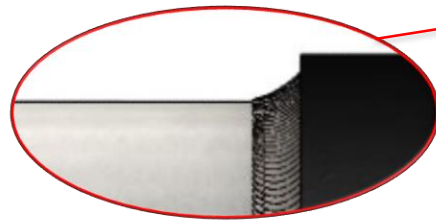
Final weldings



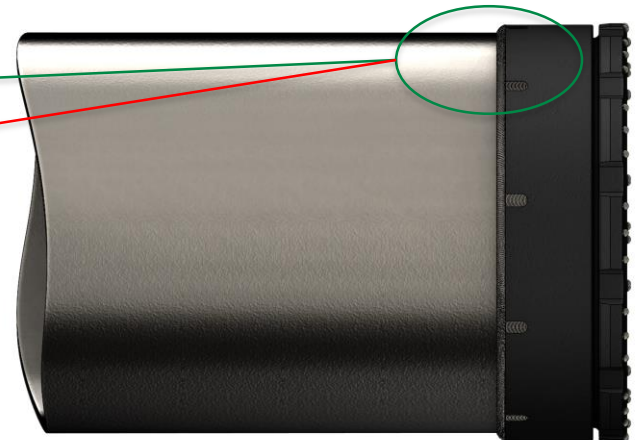
Root weld



Correct



Wrong





Welding the casing shoe

Solitary & Solitary O-pile, all diameters



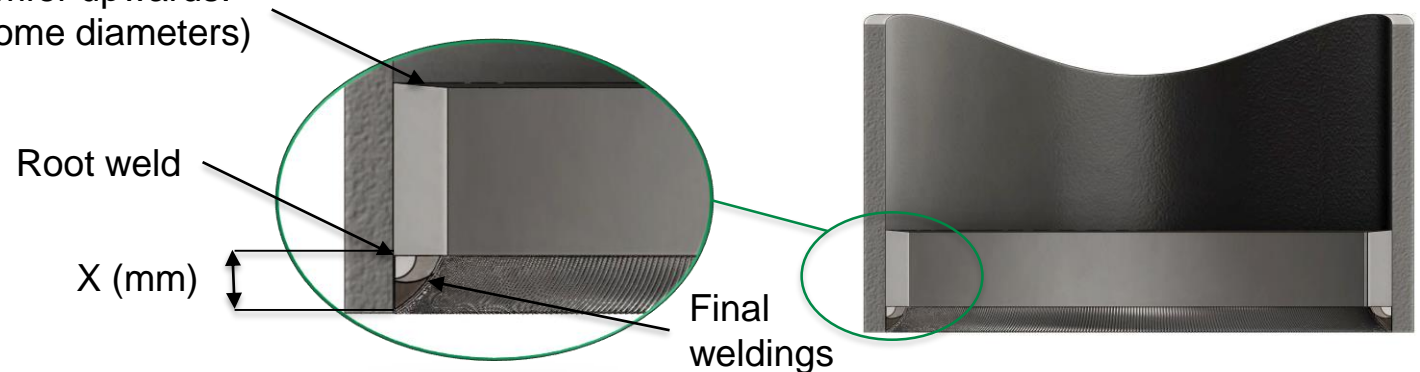
Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Check right installing depth (x) from table 1.
3. If there is a 5° chamfer on the other side of casing shoe, install casing shoe in to the casing chamfer upwards
4. Weld root weld and grind it clean
5. Weld final welding/s to required dimensions
6. Make sure connection is fully welded as presented below

5° Chamfer upwards.
(only some diameters)





Welding the casing shoe

Solitary & Solitary O-pile, all diameters



Casing diameter mm/(inches)	Installing depth (x) mm/(inches)
114.3 (4 1/2")	10 (3/8")
139.7 (5 1/2")	15 (5/8")
168.3 (6 5/8")	15 (5/8")
177.8 (7")	15 (5/8")
219.1 (8 5/8")	15 (5/8")
273 (10 3/4")	15 (5/8")
323.9 (12 3/4")	15 (5/8")
406.4 (16")	15 (5/8")
457.2 (18")	15 (5/8")
508.0 (20")	15 (5/8")
609.6 (24")	20 (3/4")
711.2 (28")	20 (3/4")
812.8 (32")	20 (3/4")
914.4 (36")	20 (3/4")
1016.0 (40")	20 (3/4")
1219.2 (48")	30 (1 1/4")
1320.8 (52")	30 (1 1/4")
1422.4 (56")	30 (1 1/4")
1524 (60")	30 (1 1/4")

Table 1. Casing shoe installing depth



Welding the casing shoe

Integrated O-pile

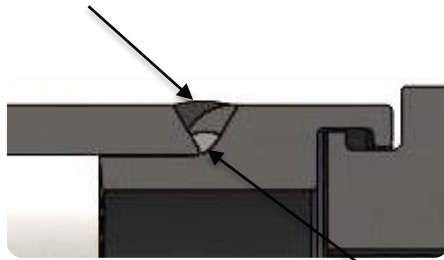
Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

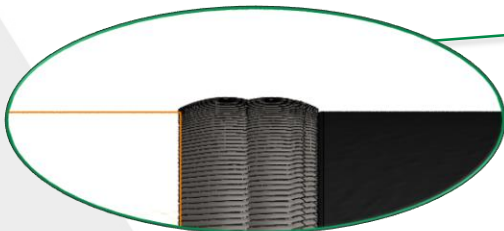
Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Weld root weld and grind it clean
3. Weld final welding/s to required dimensions
4. Make sure connection is fully welded as presented below

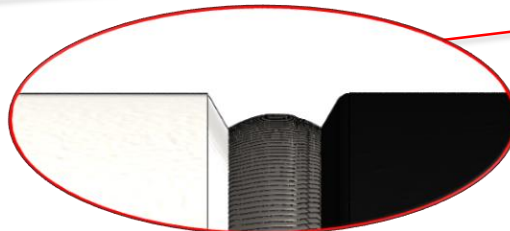
Final weldings



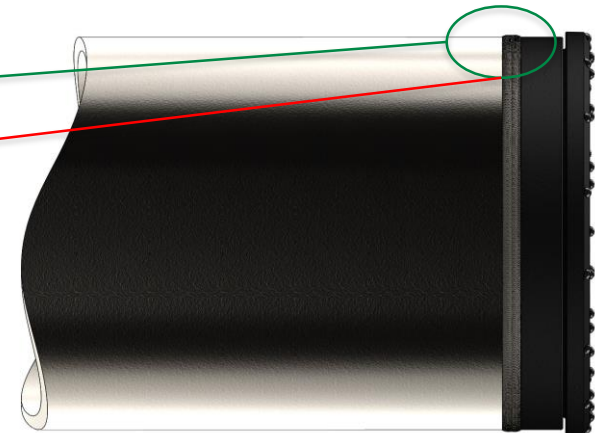
Root weld



Correct



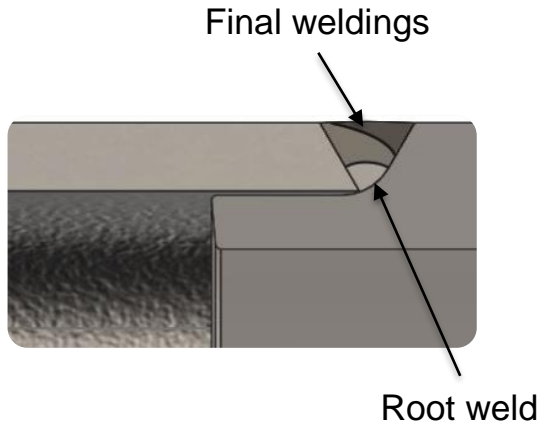
Wrong





Welding the casing shoe

Horizontal casing shoe with shoulder

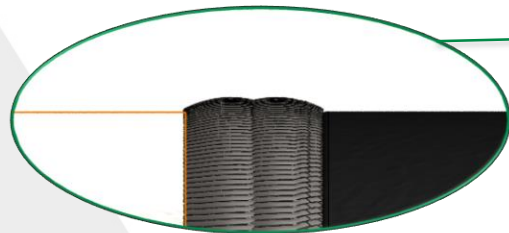


Welding rod:

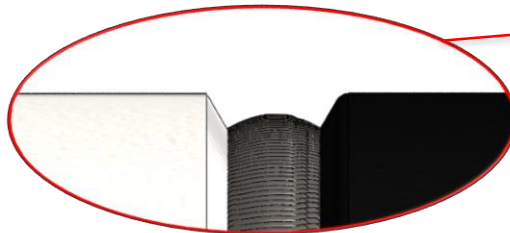
AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

Preheating is highly recommended. (180°C welded areas)

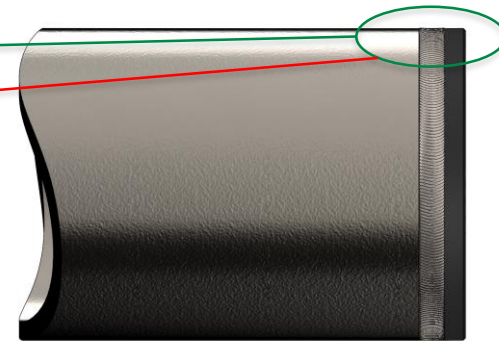
1. First grind all surfaces that are to be welded
2. Weld root weld and grind it clean
3. Weld final welding/s to required dimensions
4. Make sure connection is fully welded as presented below
5. Optional: install locally made sleeve (page 11)



Correct



Wrong





Welding the casing shoe

Horizontal, casing shoes without shoulder

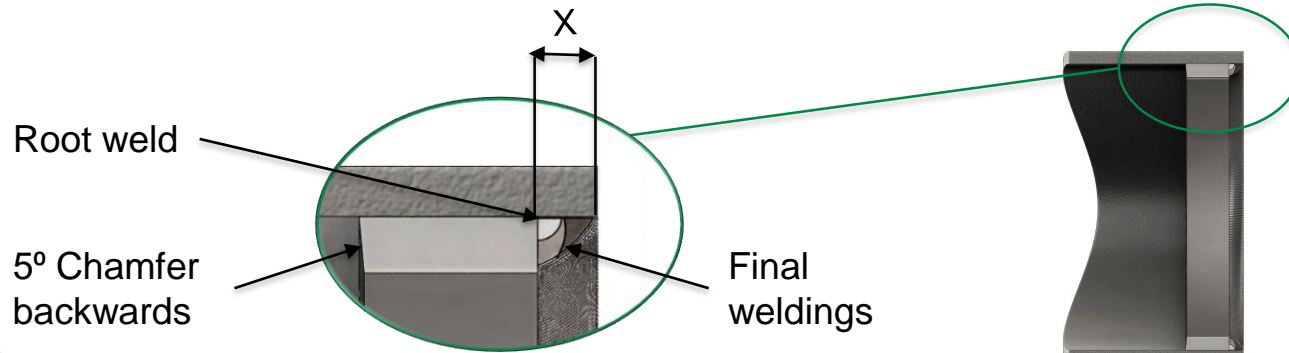


Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Check right installing depth (x) from table 2.
3. Install casing shoe in to the casing 5° chamfer upwards
4. Weld root weld and grind it clean
5. Weld final welding/s to required dimensions
6. Make sure connection is fully welded as presented below
7. Optional: install locally made sleeve (page 11)





Welding the casing shoe

Horizontal, casing shoes without shoulder

Casing diameter <i>mm/(inches)</i>	Installing depth (x) <i>mm/(inches)</i>
406.4 (16")	15 (5/8")
457.2 (18")	15 (5/8")
508.0 (20")	15 (5/8")
609.6 (24")	20 (3/4")
711.2 (28")	20 (3/4")
812.8 (32")	20 (3/4")
914.4 (36")	20 (3/4")
1016.0 (40")	20 (3/4")
1219.2 (48")	30 (1 1/4")
1320.8 (52")	30 (1 1/4")
1422.4 (56")	30 (1 1/4")
1524 (60")	30 (1 1/4")

Table 2. Casing shoe installing depth





Welding the casing shoe

Horizontal systems, sleeve installation



Welding rod:

AWS:E7018 DIN: E5153810 e.g. ESAB: OK 48.00

Preheating is highly recommended. (180°C welded areas)

1. First grind all surfaces that are to be welded
2. Install sleeve according to a drawing
3. Make sure there is 10mm gap between sleeve front end and ring bit
4. Weld root weld and grind it clean
5. Weld final welding/s

