

We make your plants corrosion-proof!

Did you know that Itag L + R offers cladding with a melting rate of up to 15 kg/h?

Our group of companies is a manufacturer, contract manufacturer and service provider for natural gas and oil production. To ensure that our valves and piping components meet the required service life, the carbon steel components are provided with a nickel-based corrosion protection layer (NBA 625) inside or outside. For the application of this layer we also use a combined MAG hot-wire welding process.



Very low ripple during external cladding



Internal cladding

NBA 625 is a nickel-based metal alloy with excellent corrosion resistance. The built-up of the iron content of 5 percent at the surface, which is customary in the industry, is not only reliably achieved with the processes used by ITAG, but is well below this level.



Ripple internal welding

Ermittelte Gehalte (Auszug):					
Abstand (µm)	Fe Wt%	Ni Wt%	Cr Wt%	Mo Wt%	Nb Wt%
500	98,0	0,0	2,0	0,0	0,0
1000	97,5	0,0	2,5	0,0	0,0
1500	0,0	65,0	21,4	9,4	4,2
2000	0,0	64,5	22,0	10,0	3,4
2500	0,0	60,9	21,4	11,8	6,0
3000	0,0	64,0	23,8	9,2	3,0
3500	0,0	66,3	23,5	10,2	0,0

Hannover, 27. November 2017
 Tester: Dr. Bietke (TÜV NORD EnSys GmbH & Co. KG, Hamburg)



A. Wirth
 Sachlich geprüft
 A. Wirth

Tested by TÜV with excellent results

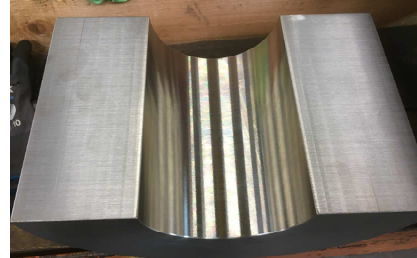
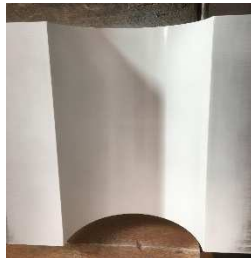
Multiply melting capacity

The welding processes used at ITAG impress with an extremely high melting rate of up to 15 kg/h combined with such low ripple that the reworking can be reduced to a minimum.

This means enormous cost savings compared to conventional processes with guaranteed compliance with all quality specifications.



Verification of the absence of cracks by dye penetrant testing



Applications:

- ✓ Pipe internally: > ID 140mm and up to 12,2m length
- ✓ Valves & Fittings
- ✓ Shafts outside: up to 20t of weight and up to 20m of length

Comparison of the welding procedures used at ITAG

	TIG-HD	TIG-HW-DW	MAG	MAG-HW-DW
Welding speed	35 cm/min	100 cm/min	45 cm/min	150 cm/min
Wire feed speed	max. 360 cm/min	12 m/min	max. 12 m/min	40 m/min
Melting capacity	1,5kg/h	4,3 kg/h	4,3 kg/h	15 kg/h

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