

# Steel Repair Sleeves

## Steel Repair Sleeves / Girth Weld Steel Repair Sleeves

Half-Sole Segments: Sizes 2- to 48-inches



T.D. Williamson

Bulletin No: 7300.002.06

Version:06.2019

Cross Indexing No: n/a

Supersedes: 7300.002.05 (06.2016)



### Description

T.D. Williamson provides a variety of alternatives to pipeline maintenance needs. The Steel Repair Sleeve is one such option. With the Steel Repair Sleeve, repairs can be made without shutting down the pipeline. Steel Repair Sleeves are available in a variety of sizes, from 2- through 48-inch.

The Steel Repair Sleeves are sold in the Half-Sole configuration (180°). The Half-Sole segment can be used as a pad or cradle while a pair of Half-Sole segments can be used to create a full-encirclement steel sleeve. Steel Repair Sleeves may be made from rolled- or die-formed plate material. This maintenance option is ideal to repair defects in pipelines.

There are four types of material available for the Steel Repair Sleeves, two pressure-rated steels and two structural-grade steel. The pressure-rated steel sleeves can be used to repair leaking and non-leaking defects while the structural-grade steel sleeves can function as reinforcement for a defective area.

### Features

The Steel Repair Sleeves can be used for internal and external corrosion, gouges, dents, grooves, arc burns, cracks, defective girth welds, laminations and leaks.

Pressure containing sleeves feature a wall thickness equal to or greater than required for the maximum allowable operating pressure or the full strength of the pipe being repaired. The Steel Repair Sleeve material is certified and the carbon equivalent (long formula)

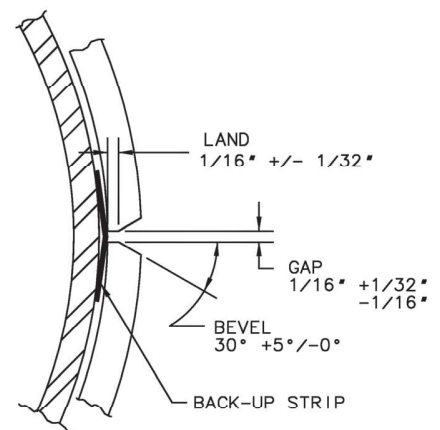
will not exceed 0.45 percent. Each half-sole segment comes with one pre-cripped back-up strip.

Steel Repair Sleeves can be used as pads or cradles for above ground piping, drain tile supports and patches (segments in 90° and 180° arcs, from 6-inches to 10-feet in length are available as specials).

Each Steel Repair Sleeve has standard, longitudinal bevels with a back-up strip and material certifications. Sleeve ends are square cut. Back-up strips are not included with Standard Girth Weld Steel Repair Sleeves.

**NOTE:** Steel Repair Sleeves are sold as single half-sole segments (180°).

Girth Weld Steel Repair Sleeves are only sold as sets of two, half-sole segments.





Steel Repair Sleeves Half-Sole Segments

RS - XXXX - X000 - XX

Pipe Size (inches)	Material	Wall Thickness *	Finish	Pipe Size	Sleeve Length
02 24	00 = ASTM A516 GR 70 - Pressure Vessel Grade	1 = .250-inch	00 = Unpainted - No bevel	2-3-1/2	5-feet
03 26	01 = ASTM A537 CL 1 - Pressure Vessel Grade	3 = .375-inch	01 = Unpainted - Bevel w/o back-up strip groove w/o back-up strips	4-48	10-feet
04 28	02 = ASTM A572 GR 50 - Structural Grade	5 = .500-inch	02 = Unpainted - Bevel with back-up strip groove with back-up strips		
06 30	03 = ASTM A572 GR 65 - Structural Grade	7 = .625-inch	03 = Painted - No bevel		
08 32		9 = .750-inch	04 = Painted - Bevel w/o back-up strip groove w/o back-up strips		
10 34			05 = Painted - Bevel with back-up strip groove with back-up strips		
12 36			06 = Unpainted - bevel w/o back-up strip groove with back-up strips		
14 40			07 = Painted - Bevel w/o back-up strip groove with back-up strips		
16 42					
18 44					
20 46					
22 48					

**Example:** RS-3001-3000-05 is a 30-inch Half-Sole Steel Repair Sleeve with ASTM A537 CL 1 material, wall thickness of .375-inch, standard bevel with back-up strip, 10 feet long with a painted finish.

**NOTE:** Steel Repair Sleeves are sold as single half-sole segments.

\* Repair sleeves are available in limited Wall Thickness sizes. See Available Thickness chart.

Pipe Size (inches)	Available Thickness (inches)						
	0.188	0.250	0.312	0.375	0.500	.625	.75
2-4	X	X					
6-8		X	X	X			
10-22		X	X	X	X		
24-48		X	X	X	X	X	X

Available thicknesses marked with "X"

Girth Weld Steel Repair Sleeves Full-encirclement Sets

RG - XXXX - X000 - XX

Pipe Size (inches)	Material	Wall Thickness *	Finish	Pipe Size	Sleeve Length
02 24	00 = ASTM A516 GR 70 - Pressure Vessel Grade	0 = .188-inch	00 = Unpainted, No Bevel	2	4 in.
03 26	01 = ASTM A537 CL 1 - Pressure Vessel Grade	1 = .250-inch	01 = Unpainted, With Bevel	3	5 in.
04 28	02 = ASTM A572 GR 50 - Structural Grade	3 = .375-inch	02 = Painted, No Bevel	4-8	6 in.
06 30	03 = ASTM A572 GR 65 - Structural Grade	5 = .500-inch	03 = Painted, With Bevel	10	8 in.
08 32		7 = .625-inch		12	10 in.
10 34				14-20	11.5 in.
12 36				All sizes over 20	12 in.
14 40					
16 42					
18 44					
20 46					
22 48					

**Example:** RG-3001-3000-01 is a set of 30" Girth Weld Steel Repair Sleeves with ASTM A537 CL 1 material, wall thickness of .375-inch, standard bevel, 12 inches long with unpainted finish.

**NOTES:** Girth Weld Steel Repair Sleeves are only sold as sets of two, half-sole segments.

\* Repair sleeves are available in limited Wall Thickness sizes. See Available Thickness chart.

Pipe Size (inches)	Available Thickness (inches)				
	0.188	0.250	0.375	0.500	0.625
2	X				
3-6		X			
8-30			X		
36-48			X	X	
24-48					X

Available thickness marked with "X"