



ATTENTION! IMPORTANT INSTRUCTIONS PRIOR TO FIELD WELDING

Field Welded Risers Label/Vent Plug Instructions **02-2019**

Riser Vent Hole

Risers are supplied with a threaded vent hole located just below the loop top. Vent holes are required to be left unplugged during field welding to allow gasses to escape. Each riser is supplied with a stainless steel hex screw that is required to be installed after field welding. In addition, the Product I.D. label (PID) and clear label cover must also be installed after welding as it covers the hex screw. Follow the instructions below:

1. Remove Vent Plug and label package from the riser prior to welding.
2. After field welding a cold zinc spray or other type of coating should be applied to the riser where it is welded to the supporting structure.
3. Apply a coating of steel pipe thread sealant to the threaded vent hole and the stainless steel vent plug prior to installing it. **Fig. 1**
4. Install vent plug flush with riser surface using a hex wrench. Remove any excess sealant after installation of the plug. **Fig. 2**
5. Remove the PID label from its backing and attach the top edge to the riser about 1/2" below the loop top. Attach the LH end of the label first as the right hand end will overlap. Make sure the label is pressed firmly against the riser wall with no air bubbles. **Fig. 3**
6. The clear cover is sized to overlap the top and bottom edges of the PID label by approx 1/4". Remove the clear cover from the backer and overlay the PID label pressing the cover firmly against the PID label. **Fig. 4**



The above installation is complete and should be inspected by the project manager or other person authorized to certify the field welded riser installation.