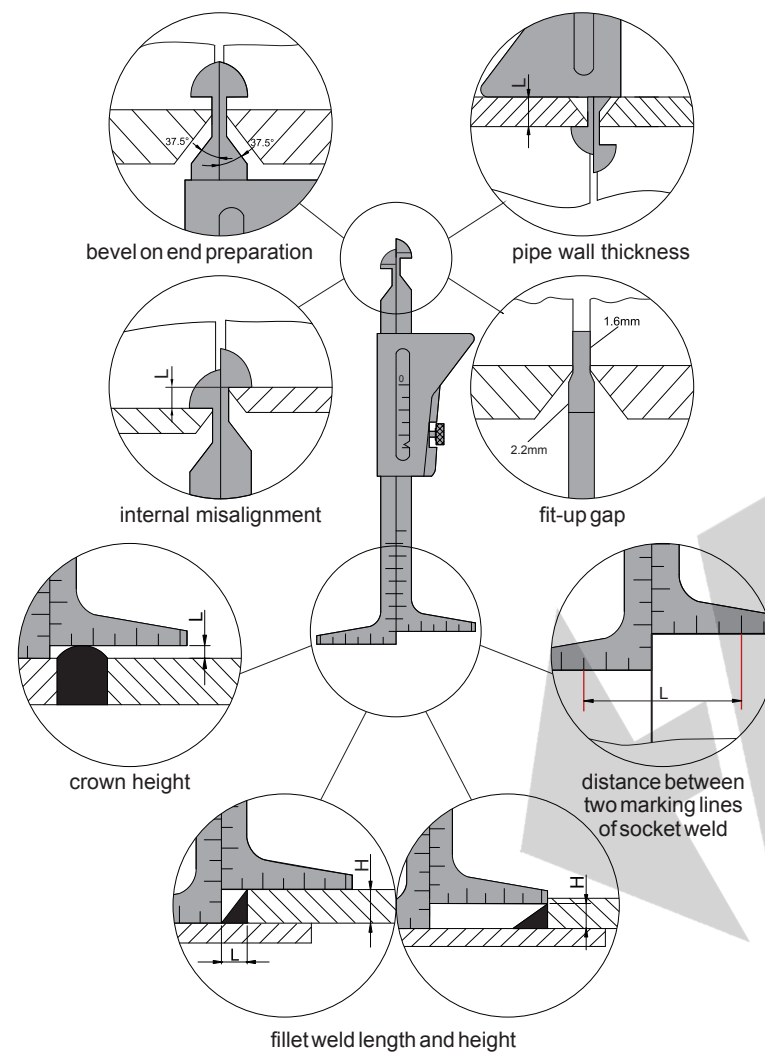




OPERATION INSTRUCTION

Pipe Welding Gauge Code 4839-1

Measuring purpose



Measurement	Range	Graduation	Accuracy
bevel on end preparation	37.5°	—	±1°
pipe wall thickness	0 - 45mm (0 - 1-3/4")	1mm (1/16")	±0.5mm
internal misalignment	0 - 35mm (0 - 1-3/8")	1mm (1/32")	±0.5mm
fit-up gap	1.6mm, 2.2mm	—	±0.1mm
crown height	0 - 35mm (0 - 1-3/8")	1mm (1/32")	±0.5mm
distance between two marking lines of socket weld	0 - 60mm (0 - 2-3/8")	1mm (1/16")	±0.5mm
fillet weld length	0 - 30mm (0 - 1-1/4")	1mm (1/16")	±0.5mm
fillet weld height	0 - 35mm (0 - 1-3/8")	1mm (1/32")	±0.5mm

MN-4839-1-E