

IMPORTANT

For welding inline, **disassembly** of the valve is **not** required if **proper precautions** are taken to protect the seats and seals.

If the valve is to be welded **without disassembly**:

1. Welding should be done by qualified personnel as outlined in Section IX of the ASME Boiler Code.

2. Weld filler material should be the same as the base material.

3. The valve should be in the fully open position.

4. These temperatures should not be exceeded at the valve center body:

Fire Series (A60T): 350°F (177°C)

Steam Series (S60P): 500°F (260°C)

Thermal Series (T60M): 750°F (399°C)

5. After welding, the valve should be purged clean while still in the open position and before cycling. If valve disassembly is preferred, flange seal replacement is required. See reverse side for flange seal kit ordering information.

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“60” Series Ball Valves

Appropriate flange seal kits are available from your Swagelok Representative. Refer to chart below for flange seal kit ordering numbers.

Instructions are included.

VALVE SIZE	“A60T” SERIES	“S60P” SERIES	“T60M” SERIES
“62”	N/A	GW-9K-S62	N/A
“63”	GW-9K-F63	GW-9K-S63	GW-9K-T63
“65”	GW-9K-F65	GW-9K-S65	GW-9K-T65
“67”	GW-9K-F67	GW-9K-S67	GW-9K-T67
“68”	GW-9K-F68	GW-9K-S68	GW-9K-T68

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These instructions are also available in French, Italian, German and Spanish.