

**Welded Pipeline Sleeves Catalog**

# Welded Pipeline Sleeves

## Code Compliant Repairs to Damaged Pipeline Assets

Designed in accordance with ASME PCC-2 with ratings derived using ASME B31.8, TEAM's range of welded type B repair sleeves are designed and manufactured to provide cost effective code compliant repairs for a wide range of pipeline damage mechanisms. Including:

- + Internal corrosion/erosion
- + External corrosion
- + Mechanical damage such as dents and gouges
- + Cracking

Welded sleeves have long been the go-to technology for pipeline damage due to the wealth of positive operating history and well-codified design and installation guidance.

TEAM's range of Type B welded sleeve repairs provides the ultimate ordering flexibility with a wide range of pipeline diameters, location classes and repair lengths covered with a simple ordering system.

TEAM welded pipeline are designed and manufactured to the following standard specification and options:

- + Materials of 50, 52, 65 and 70ksi yield stress
- + Up to 10' length (3/4" thick and above available up to 5')
- + Wide range of standard thicknesses
- + 16ga backing strips
- + Optional milled groove to accept backing strips
- + 30° longitudinal bevel
- + Flat end faces

TEAM's welded pipeline sleeves can be ordered directly if the required sleeve wall thickness is known. Otherwise, TEAM's standard rating tables can be used to evaluate the required thickness (tables available for review at back of catalog).

Integrated in-house capabilities enable TEAM to carry out turn-key installation of welded sleeves including in-service welding and non-destructive testing. This turn-key approach ensures that projects are executed to the highest safety and quality standards, with zero hand-offs and a single PO.



Scan or click on QR codes to receive a quotation:



Click or scan if sleeve thickness is known



Click or scan for TEAM to calculate sleeve thickness

For general inquiries or custom solutions, please contact [pipelineproducts@teaminc.com](mailto:pipelineproducts@teaminc.com)

### Sleeve Ordering Information – By Part Number

TEAM's welded sleeves can be ordered using the below standard part numbering system. The standard, most cost-effective selection is highlighted in bold:

	TWS-	65 -	8 -	0.375 -	6 -	NG -	P
<b>TEAM Welded Sleeve</b>							
<b>Sleeve SMYS (ksi)</b> 50, 52*, 65, 70*							
<b>Pipeline Diameter</b> 6 thru 36							
<b>Welded Sleeve Thickness</b> 0.25, 0.3125, <b>0.375</b> , 0.5, 0.625, 0.75							
<b>Full Encirclement Sleeve Length (feet, 1' Steps)</b> For sleeves up to 5/8" thick 1' to <b>10'</b> For sleeves 3/4" and above 1' to 5'							
<b>Backing Strip Groove</b> NG = No Groove, G = 1/16" milled groove							
<b>Coating</b> P = Red Oxide Primer, <b>NC</b> = No Coating							

\*Sleeves with SMYS 52 and 70 ksi are supplied by selecting ASTM A572 Gr 50 & 65 materials with adequate tensile properties to meet the higher yield designation.

Specific material properties over standard ASTM A572 must be communicated including, carbon equivalent, impact test temperature and energy, hardness or any other specific requirements.

For practicality of manufacture, the below table provides guidance on the maximum sleeve thickness by pipeline diameter for TEAM's standard sleeves. Thicker sizes may be accommodated by special request:

Nominal Pipeline Size	2"+	6" +	12"+	16"+	24"+
<b>Maximum Sleeve Thickness</b>	1/4"	3/8"	1/2"	5/8"	3/4"

### Ordering Example:

TWS-65-16-0.625-8-G-NC represents 65ksi sleeve for a 16" pipeline that is 5/8" thick and 8' long with backing strip grooves and no coating.

### Pressure Rating Tables

Sleeve allowable pressure is evaluated using ASME B31.8 841.1.1 & ASME PCC-2 Article 206.

$$P = \frac{2St}{D} FET$$

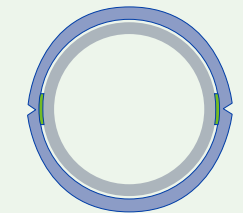
Where:

- D = Outside diameter of sleeve (in)
- E = Longitudinal joint factor (1.0 for full volumetric inspection or 0.8 otherwise as per ASME PCC-2 206-3.2)
- F = Design factor ASME B31.8 Table 841.1.6-1
- P = Design pressure (psi)

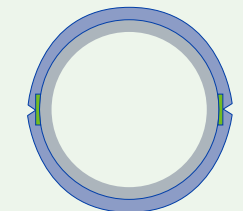
- S = Specified minimum yield stress of sleeve (psi)
- T = Temperature derating factor (1.0 for design temperatures 250°F or lower)
- t = Sleeve thickness (for sleeves with backing strip grooves the section is reduced by the groove depth giving a lower allowable pressure)

### Backing Strip Grooves:

TEAM's welded sleeves can be furnished with or without grooves to house the backing strips. Backing strip grooves may be a client preference and assist in installation. The groove reduces the effective wall thickness and hence the pressure capability of the sleeve a small amount. The diagrams below illustrate the backing strip groove options:



Sleeve with no backing strip groove



Sleeve with backing strip groove

The tables that follow at the back of this catalog illustrate the maximum allowable pressure for each option of TEAM's welded sleeve.







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