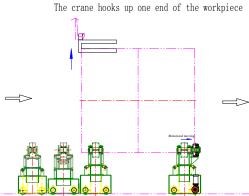
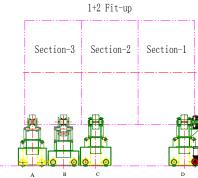


Step 1: Load Section 1 and Section 2 on the rotator, Fit-up every 200-300mm and spot welding.

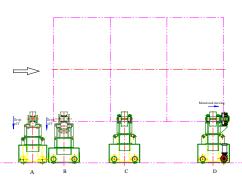


Step 2: Because the single section is short and the distance between rotators is small, so one end of the pipe needs to be lifted by crane as the sketch above. The other end of the pipe load on the D power rotator.

D work with the crane can move the pipe along the rail, till the pipe end can load on C, then low down the pipe on the rotator.

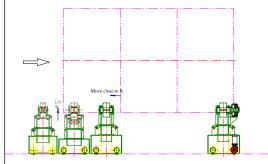


Step 3: Load Section-3 on A&B, the repeat the fit-up job.



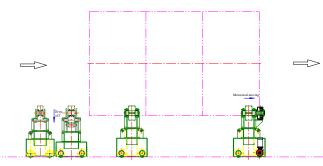
Step 4: Drop off the roller on A and B till the roller not touch the pipe. Moving the pipe with C and D along the rail till one end of the pipe just can load on B.



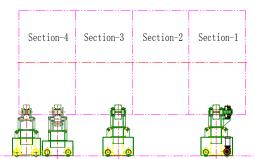


Step 5: Lift up the roller of B till the pipe not touch with C. Move C close to B.

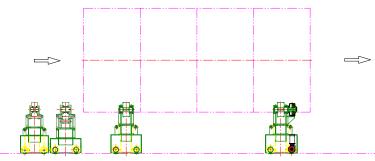
Then drop off the roller of B, let the pipe load on C and D.



Step 6: Move the pipe with C and D till the pipe end not touch with B.

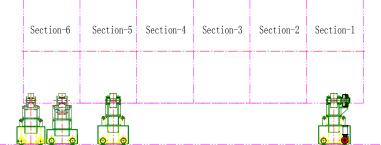


Step 7: Load Section-4 on A&B, the repeat the fit-up job.



Repeat the Step 4 to Step 6, let free space on A and B.

## Till all setions finished Fit-up



When all of the setcions are completed fit-up, C and D will move the pipe to welding station for Circular-seam welding. At the same time, another set of C and D will work in this fit-up line.

Repeat the above steps till all the sctions finished fit-up.

_			_	-	Fit-up Rotators	WF	
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Design			Sundurdize			1	
Check						All pages Page No.:	
Ratify		Teng Zhithong	Audit		Sketch Drawing	IRIZAR HEAVY INDUSTRIES DC.	
			Date	2022.10			