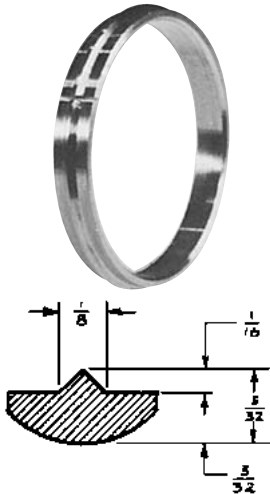


IMPERIAL STANDARD WELD RINGS



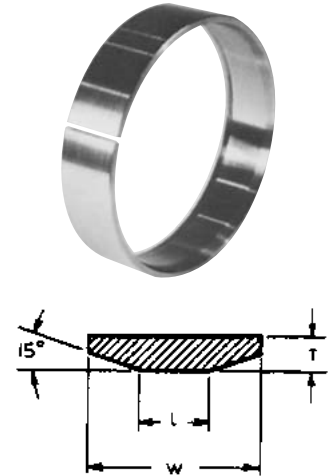
**RIDGE-TYPE
CONTINUOUS SPACERS**

STD-136C XSTG-137C

This style weld ring provides a continuous root opening for obtaining quality pipe welds.

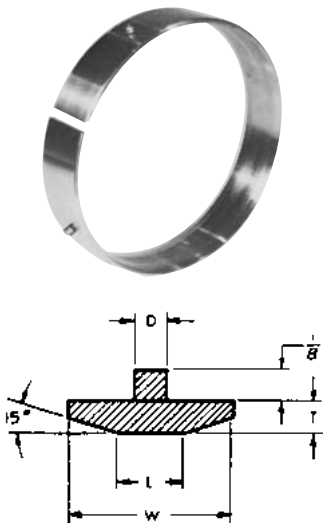
NOMINAL PIPE SIZE	RING SPECS				FOR USE WITH THIS I.D. OF PIPE	
	THICKNESS T	WIDTH W	DIAMETER ROOT OPENING SPACER D	AMOUNT OF SPACERS	STD-136	XSTG-137
1/2"	1/16"	1/2"	1/8"	3	.622	.546
3/4"	1/16"	1/2"	1/8"	3	.824	.742
1"	1/16"	1/2"	1/8"	3	1.049	.957
1-1/4"	3/32"	5/8"	1/8"	3	1.380	1.278
1-1/2"	3/32"	5/8"	1/8"	3	1.610	1.500
2"	3/32"	5/8"	3/16"	3	2.067	1.939
2-1/2"	3/32"	5/8"	3/16"	3	2.469	2.323
3"	3/32"	5/8"	3/16"	3	3.068	2.900
3-1/2"	3/32"	5/8"	3/16"	3	4.026	3.364
4"	3/32"	5/8"	3/16"	3	4.026	3.826
5"	1/8"	1"	3/16"	4	5.047	4.813
6"	1/8"	1"	3/16"	4	6.065	5.761
8"	1/8"	1"	3/16"	4	7.981	7.625
10"	1/8"	1"	3/16"	4	10.020	9.750
12"	1/8"	1"	3/16"	5	12.000	11.750
14"	1/8"	1"	3/16"	5	13.250	13.000
16"	1/8"	1"	3/16"	5	15.250	15.000
18"	1/8"	1"	3/16"	5	17.250	17.000
20"	1/8"	1"	3/16"	5	19.250	19.000
24"	1/8"	1"	3/16"	5	23.250	23.000
30"	1/8"	1"	3/16"	5	29.250	29.000
36"	1/8"	1"	3/16"	5	35.250	35.000

IMPERIAL WELD RINGS ARE AVAILABLE IN CARBON, STEEL, STAINLESS, CHROME-MOLY, ALUMINUM, ETC. FOR ALL PIPE SCHEDULES. RINGS CAN BE MANUFACTURED TO FIT ALL PIPE AND TUBE I.D.S. OTHER DIMENSIONS OR ROOT OPENING SPACER DIAMETERS UPON APPLICATION.



PLAN (WITHOUT SPACERS)
STD-136P XSTG-137P

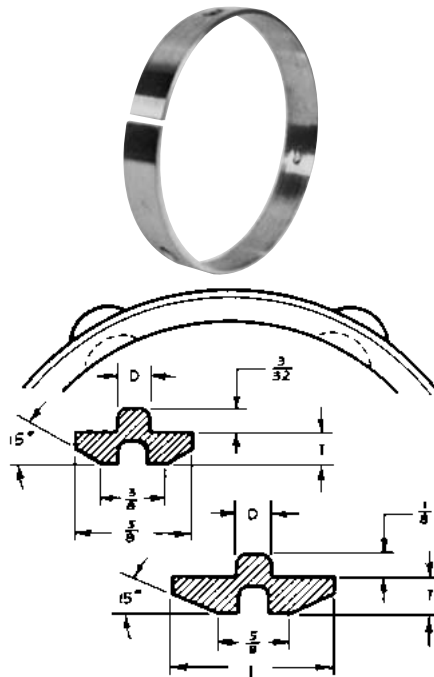
With this style spacer, welder has the preference to adjust root opening depending on wall thickness and speed of initial pass.



SHORT SPACERS

STD-136S XSTG-137S

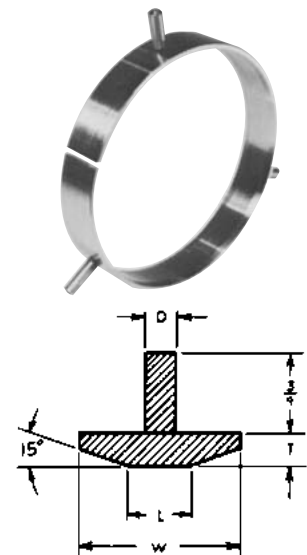
This style eliminates the need for tacking before welding joint. Required root gap easily established. Length of spacer is sufficient to overcome small variations in pipe diameters. Spacers are readily consumed in initial pass. No long pins to strike off.



PRESSED-TYPE SPACERS

STD-136PS XSTG-137PS

Pressed style provides precise close tolerance fit-up in tube and pipe systems and eliminates the need for tacking before welding joint. This style also makes it impossible to have foreign material in root opening such as short spacer pins.



LONG SPACERS

STD-136L XSTG-137L

Easily aligns pipe where variation of pipe diameters is great and automatically establishes required root gap for best welding. After tacking pipe ends in place, long spacers readily removed to eliminate all foreign metal from root to joint. Full penetration weld and X-Ray inspection quality consistently assured.