



TechTip #5

Bottom Unheading Valve Warm-up Procedure

The purpose of this procedure is to ensure that all bonnet welds achieve the ASME code suggested impact values prior to full pressurization of the bonnets.

Warm up procedure for the GV815/GV820 unheading valves for temperatures starting below 80°F.

Procedure:

- Throttle the valve to a partially opened position – a minimum of 6.625 inches. This will allow steam to escape the body and bonnets without causing pressurization. An alternative to throttling the valve is to open the steam trap bypass valves. *Note: Only certain models of the bottom unheading valves have steam trap bypass valves as an added option.*
- Introduce steam into the body of the valve until temperatures of the body and bonnets reach at least 80°F
- Once the valve reaches its goal temperature, the gate can be closed and the valve fully pressurized