

Safety Inspection Notification
Immediate Attention Required

Date: 18 May 04

Dear Customer,

Our records indicate that you have Yarway Welbloc, Yarway L100v, Yarway L200v, Penberthy SB2500 or Penberthy GC3000 OS&Y gagecocks installed at your facility. These gagecocks are typically used with boiler gauge glass and level controls. We strongly recommend that you perform an immediate safety inspection on these gagecocks.

It is possible that the brass bushing anti-rotation weld nugget on the yoke is inadequate or missing. In this event, the brass bushing may unthread as the gagecock is opened. This could result in property damage, serious physical injury or death caused by either the forceful ejection of the stem or escaping steam.

 **DANGER**

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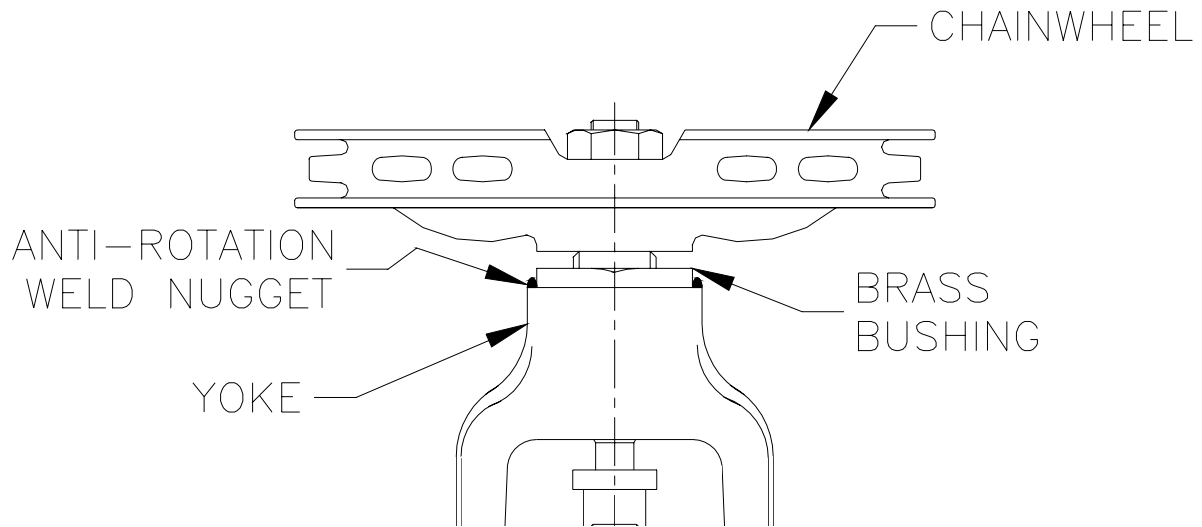


Figure 1: Yoke, Bushing and Weld Nugget Assembly

Figure 1 shows the yoke, bushing and weld nugget in a side view for orientation.

Note: The bushing must be threaded tightly against the yoke.

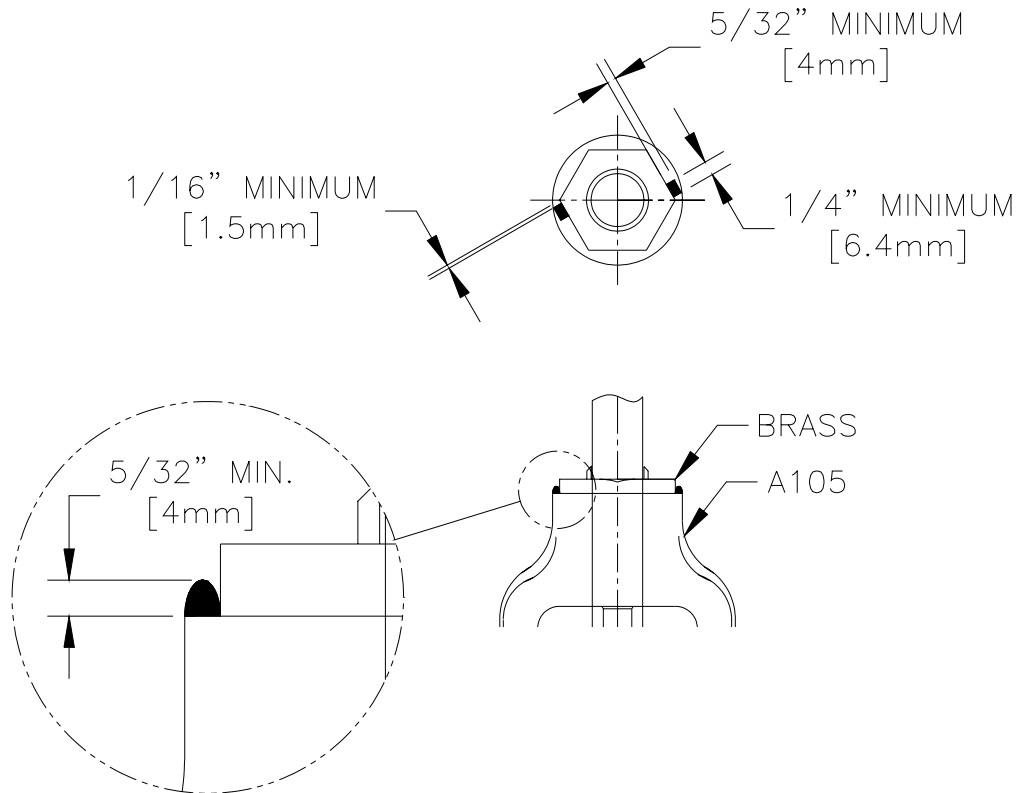


Figure 2: Anti-Rotation Tack Weld Minimum Dimensions and Placement

Figure 2 shows the proper placement and size of the weld nugget to prevent the brass bushing from rotating while opening the gagecock.

- If the weld nuggets meet the specified criteria, no action is required.
- However, if the weld does not meet the stated dimensions or is missing, **immediate action is required.**
- If process conditions allow – close the gagecock, otherwise do not operate the gagecock. Do **NOT** open a closed gagecock.

Action

We recommend that the work be performed on-site by a Code-certified welder. Relieve all pressure in the system before initiating repair. With the stem unseated at least one turn, ascertain that the brass bushing is torqued to 40-60 ft·lb [54-81 N·m].

Assuming the yoke is ASTM A-105, use E-7018 filler metal with the shielded metal arc welding process to create the weld nuggets. For other yoke materials

contact the factory. It is important that the weld not penetrate the brass bushing. Protect the gauge glass from weld splatter, etc. The bead of filler material should be allowed to lay against the brass without penetration. However, enough heat must be generated to allow the filler material to penetrate into the yoke material.

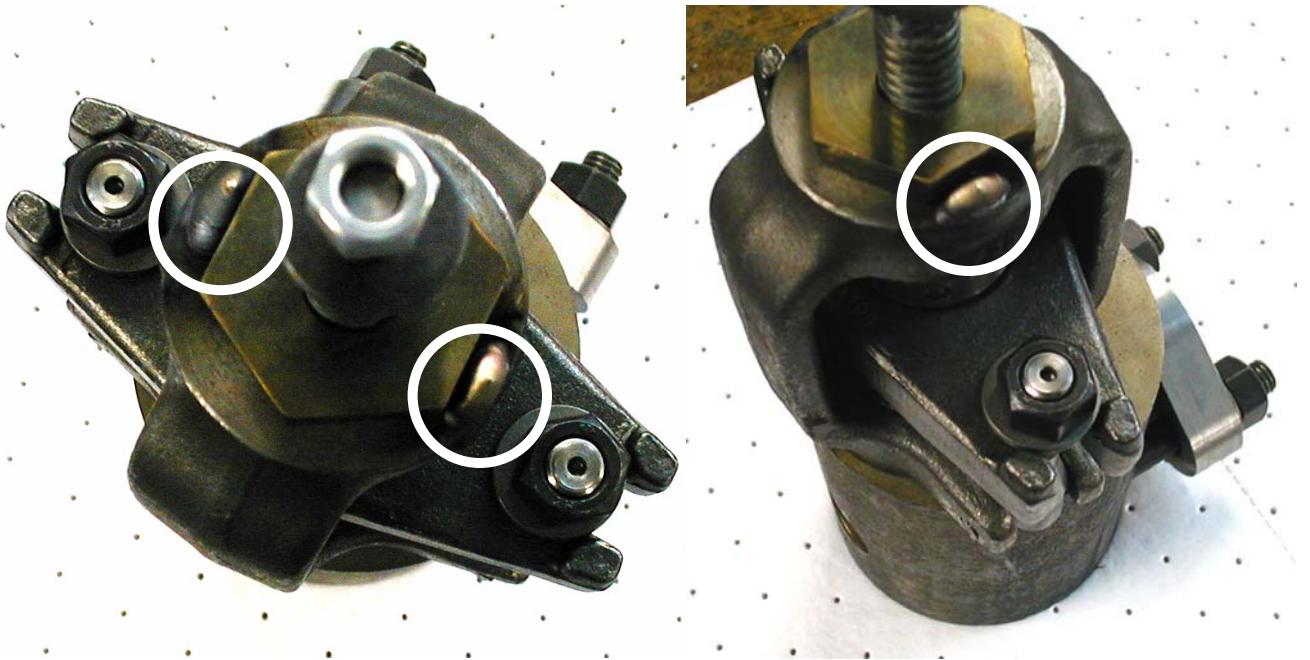


Figure 3: Proper Weld Nuggets

Proper weld nuggets should appear as shown in Figure 3.

Please contact Tyco Valves & Controls – Prophetstown should any questions or concerns arise concerning this issue.

For further information or technical assistance please contact:

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Gagecock Inspection Check List

Tag # _____

Location _____

Anti-rotation weld nuggets:

per safety notification

Number of welds

one weld

two welds

Dimensional Inspection

length

width

height

Location Inspection

1/16" [1.5 mm] from hex corner

Inspected by: _____

Date Inspected: _____