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111. TUBE-TO-TUBESHEET JOINTS:
THE MANY CHOICES B. J. Sanders
Consultant 307 Meyer Street Alvin,
Texas 77511 ABSTRACT. After a
decision has been made to use
zirconium as the material of
construction for a shell and tube heat

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exchanger, one must take into account
the process design parameters and
other considerations in order to
obtain the optimum mechanical
design for the specific application.

~~TUBE TO TUBESHEET JOINTS: THE
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Design engineers have basically two weld options for a tube-to-tubesheet joint: 1) roll or expand (with grooves milled in tube holes) and seal welded, or, 2) strength welds (no grooves required). Each type of joint has advantages and disadvantages; regardless of which type you choose,

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it's crucial to use a welding technique that achieves consistent quality.

~~Tube to Tubesheet Welding Types:
Choosing the Right Joint ...~~

One of the most important steps in the mechanical design process is

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determining the method of attachment for the tube-to-tubesheet joint. Many of the problems which have been experienced with zirconium shell and tube heat exchangers could have been avoided by giving more attention to the selection and design of the tube-to-tubesheet joint.

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~~TUBE TO TUBESHEET JOINTS_ THE
MANY /u2026.pdf TUBE TO ...~~

A variety of methods are used for making the joint between the tubesheet and the tubes. The joining technique must lend itself to mass production and to uniformity of

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~~Tube to Tubesheet Joints |
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The main function of tube-to-tubesheet joint is to seal the tubes tightly to the tubesheet, and for some exchangers, an additional function is

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to support the tubesheet against pressure induced load. Tubes are sealed inside the tubesheet by the following methods. • Expanding tube inside tubehole • Welding tubes to tubesheet

~~Tube-to-Tubesheet Connection~~

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The idea was to make 3mm deep narrowest groove possible on the tube side face of tube-sheet. The narrow gap would ensure proper welding of the groove between the tube and tubesheet. Subsequent weld runs between the tube and the tubesheet

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made the size of the weld close to
strength weld with a maximum leak-
path.

~~IN HP EXCHANGERS, TUBE TO-
TUBESHEET JOINTS MUST HAVE ...~~

Tube to tube sheet joint shall be
examined during hydro test to detect

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leakage, if any. In the event of leakage, the tube shall be re – expanded. Care shall be taken to ensure that there is no excessive thinning of the tubes. This is all about procedure for Expansion Joints.

~~Procedure For Tube to Tube-sheet~~

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To ensure leak tightness, the author suggests using seal- or strength-welding followed by expanding tube-to-tubesheet joints. For welded-and-expanded joints, the author further recommends welding and expanding criteria and nondestructive

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~~Heat Exchangers: Tube to Tubesheet
Joint Tightness ...~~

A very common question arises while deciding the sequence of welding and expansion of Tube to Tubesheet Joint. The preferred and the recommended

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sequence is welding before expansion:
The reasons as mentioned below;

1. Welding shall be performed in an atmosphere where welding gases can escape; welding after expansion will surely result in bad tube-to-tubesheet joints having porosity or weld ...

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~~Tube to Tubesheet Joint—Expansion—
before or after ...~~

Failure analysis was carried out on a tube-to-tubesheet welded joint of a shell-tube heat exchanger to confirm its failure mechanism. The collected evidence suggests that the failure of the tube-to-tubesheet welded joint

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was induced by fatigue. Under the morphology analysis, the fracture surface exhibit obvious fatigue crack propagation traces.

~~Failure analysis of tube to tubesheet
welded joints in a ...~~

Concept – while designing the heat

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exchanger, critical and potential leak path of the fluid is tube to tubesheet joint. Thus, T#TS joint design become more important. It has to be decided whether to go for expansion joint, seal weld or strength weld or combination of strength weld and expansion.

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~~Choice Abstract~~ #Tubesheet
joint | weldknowledge

Tubes will be expanded in such a way that it will flow in these grooves. In Heavy expansion normally 5% thinning of tube thickness occurs. 3) For strength, a weld is an expansion necessary. For strength welded tube

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to tube sheet joints, contact expansion is necessary as explained in (1) above.

~~Expansion of Tube to tubesheet joint |
Welding & NDT~~

There are four types of tube-to-tubesheet joints: 1. Roll or expand only (without grooves) - strength is

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poor. - leak resistance is poor. - tube replacement is very easy. - application is limited (i.e. low pressure water or air) 2. Roll or expand only (with grooves)

~~What is the type of joint between tube and tube sheet in a ...~~

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As a result of the sticking interface which is formed between the tube and tubesheet hole, it is shown that: 1) the expanded joint of tube-tubesheet interface is not sensitive to cyclic loads, 2) the fatigue strength of the expanded joint is higher than that of the tube materials, and 3) cyclic loads

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have no obvious effect on the static
pull-out strength.

~~Fatigue Behavior of Tube to
Tubesheet Expanded Joints ...~~

Tube-Tubesheet Joint: A Proposed
Equation for the Equivalent Sleeve
Diameter Used in the Single-Tube

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Model,” ASME JOURNAL OF
PRESSURE VESSEL TECHNOLOGY,
Vol. 114

~~Calculation of Hydraulically Expanded
Tube to Tubesheet Joints~~

Tube to tube Sheet Joint (TTSJ)
welding after retubing of Heat

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~~Heat Exchanger Tube to Tube Sheet
Welding after Retubing ...~~

Explosive Expansion. Almost all explosive expanding is done on constructions where the primary seal of the tube to the tubesheet is by

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welding. Explosive expansion has been successfully applied to expand tubes into tubesheets as thin as 1 1/2" and as thick as 33".

~~TUBE EXPANSION ISSUES AND METHODS~~

The design consists of an array of

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tubes, which is connected on each side to a flat plate called a tubesheet. The tubesheet also separates the shell and tube sides of the exchanger. Baffles on the outside of the tubes direct the flow of the shell-side fluid back and forth across the tubes to promote heat transfer.

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