

ButtWeld Centralizer Sub

- ❖ Body is same material as casing
- ❖ Weld bevel on each end
- ❖ Vanes are mild steel (typically A-36 plate)
- ❖ Vanes are fillet welded to sub
- ❖ Sub is welded into the joint with SMAW process (KB-SMAW-7rev01)
- ❖ Stress relieve all welds per KB-SMAW-7rev01 to 1175^o F – 1200^o F

