

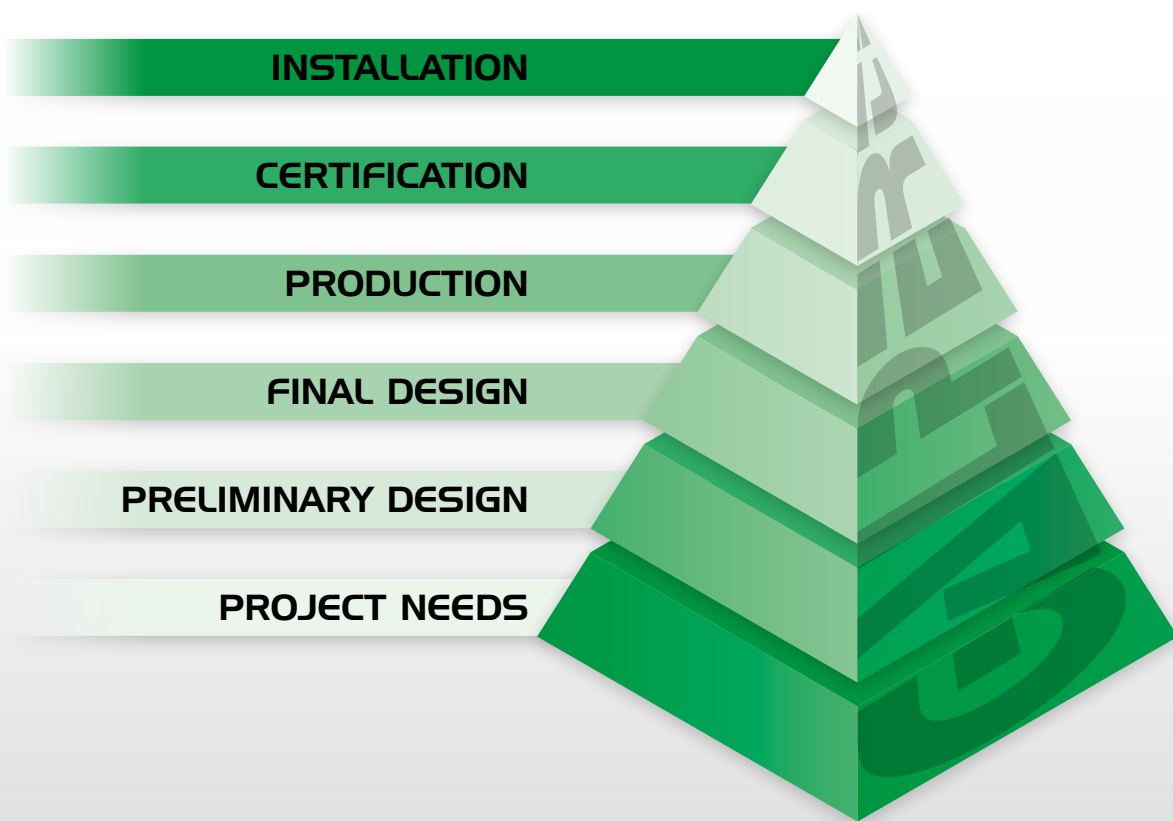
®

The Original

GALPERTI®

TECH FORGED PRODUCTS

The fully integrated, energy project oriented, forged product supplier.



GALPERTI TECH FORGED PRODUCTS

Last born inside GALPERTI group universe.

With the merge of ours 100 years forging expertise, and a brand new mechanical production facility, GALPERTI TECH FORGED PRODUCTS updates again its offer, increasing the Energy market dedicated solution portfolio.



The Original

Partner for Energy Project



IN-HOUSE PROCESS

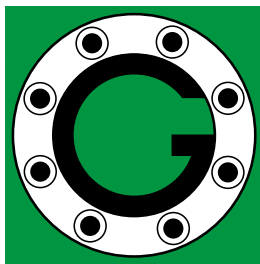
Forging - Heat treatment - Manufacturing - Assembling

FORGING

- Steel bar cutting
- Heating
- Forging
- Rolling

HEAT TREATMENT

- Quench and tempere
- Normalizing
- Material qualification tests



The Original
GALPERTI®
TECH FORGED PRODUCTS

MANUFACTURING

- Turnin
- Induction hardening
- Non desctructive test
- Gear cut
- Gear grinding
- Boring-Tapping
- Finishig

ASSEMBLING

- Assembling
- Zinc spray
- Paint
- Greasing
- Dimensional check
- Testing
- Rust protect
- Packing
- Delivering

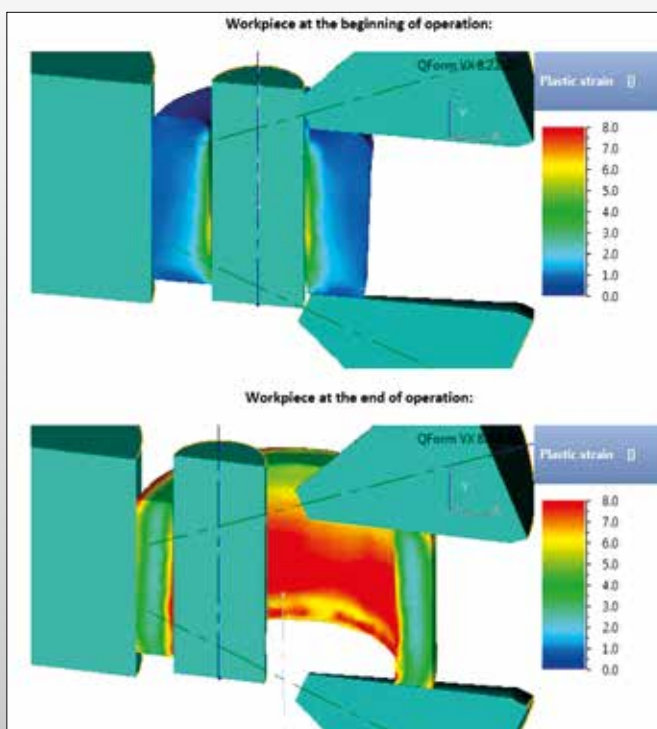
DESIGN

In-house engineering process

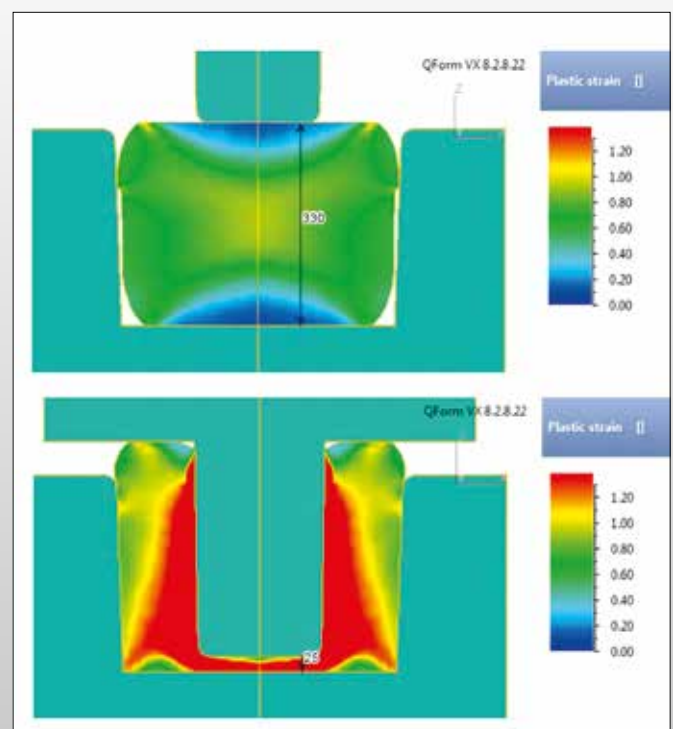
Internal design, and the highest level of control in all the project steps: from the supply chain management to the shipment, it is the best guarantee of success to our customers and their projects.

- 2D drawings
- 3D modelling
- Design calculations
 - ASME VIII Div.1
 - PD5500
 - ASME VIII Div.2
 - DNV OS F01
- Design

DESCRIPTION	REMARKS	3D' - 1-1318-00-70.1495_03 APBW FRG - DIM 0128679A387	Simulation Results
1	Starting from plate blank		
2	Lapwelding		Min $\sigma_{eq} = 0.000000$
3	Flaring		Min $\sigma_{eq} = 0.000000$ Max $\sigma_{eq} = 0.000000$ Min $\sigma_{eq} = 0.000000$
4	Ring rolling		$D1 = 80$ $D2 = 627$ Min $\sigma_{eq} = 0.000000$ (SP) = 0



Ring rolling



Punching

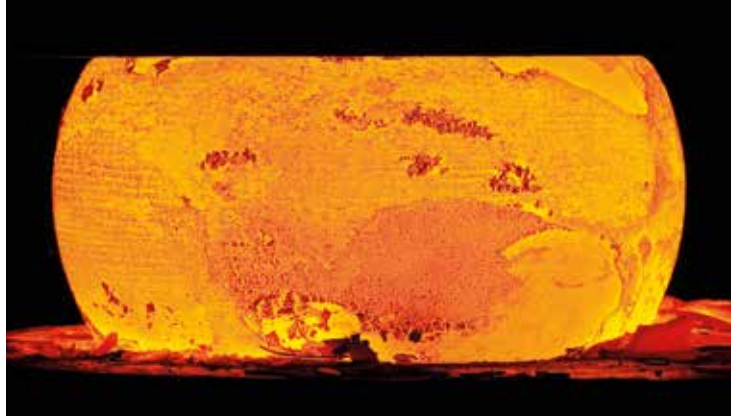
FORGING

In-house forging process

OPEN DIE

Forging Plant No. 1 - Dervio

N° 7 Forging lines and ring rolling, capacity from ½" up to 4000 mm external diameter.



SEMI CLOSE DIE

Forgings from 0.5 kg up to 30 Tons.



ROLLING RING

Forging Plant No. 2 - Cercino

N° 4 Forging lines and ring rolling, capacity from ½" up to 6300 mm external diameter.



Rights products born from the beginning, and GALPERTI TECH FORGED PRODUCTS consider this founder heritage as a lesson of life.

HEAT TREATMENT

Competitors bottle neck

OUR STRENGTH POINT

GALPERTI heat treatment capacity it is designed to guarantee the maximum flexibility and shorter response time. HT capacity with furnaces from 10 up to 40 tons.

Dedicated HT for pipes up to 16.000 mm length and 700 mm OD.

GALPERTI has removed any weakness from performing heat treatments making it its hown strong point.



LONG PRODUCT HEAT TREATMENT PLANT

The furnace

Internal length:	16.770 mm
Internal width:	1.675 mm
Internal height:	1.700 mm
Max batch weight:	20 ton
Max working temp.:	1.200°C
Nominal working temperature:	400/1.100°C
Burners:	N° 14
Max thermal power:	2.3 MW



Fully automated loading and unloading heat treatment plant



MACHINING

Flexibility and on time delivery is our commitment



Our Strength guaranteed by a customer need designed workshop, with the perfect integration of single lot and commodities volume production.



Tube straightening

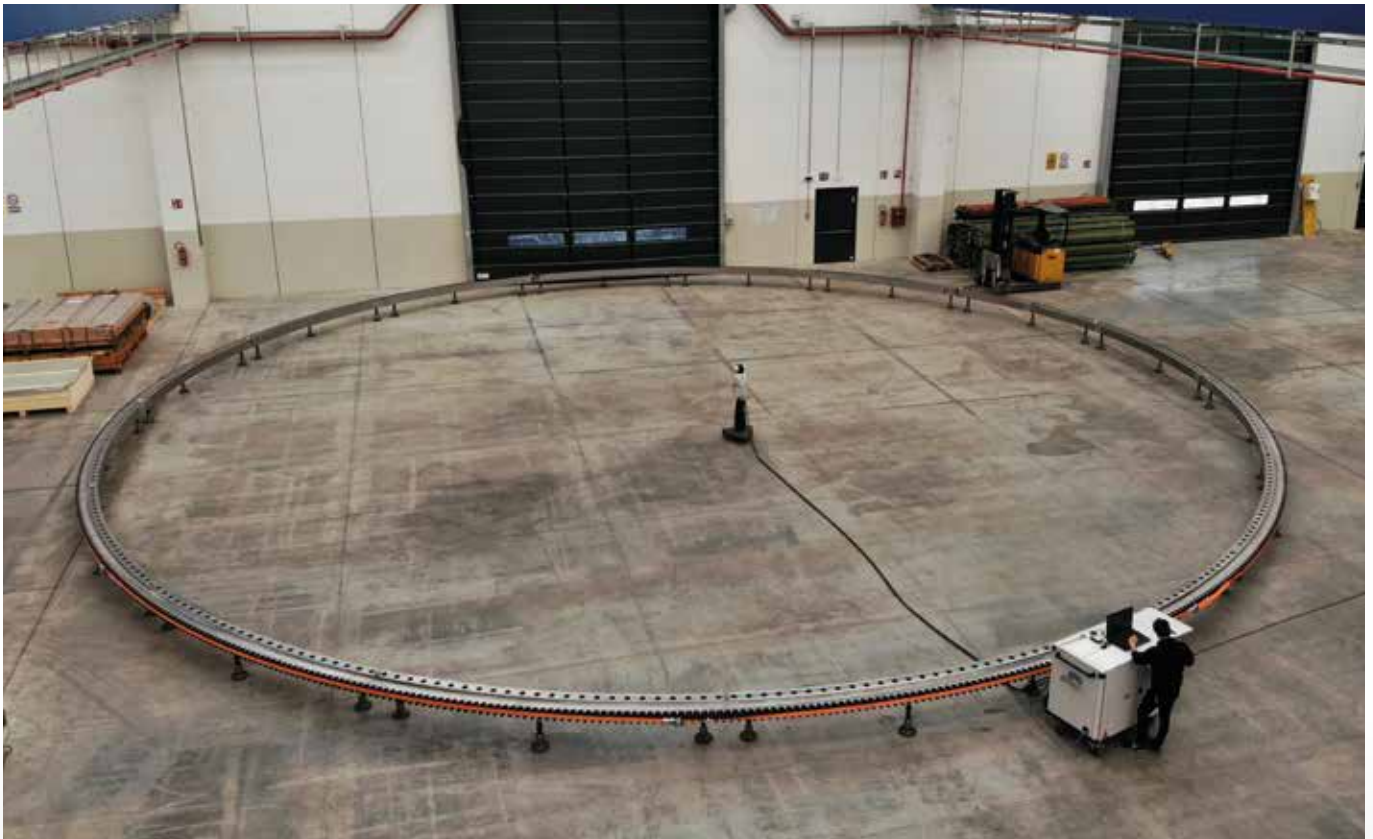


Tube drilling

GALPERTI SLEWING RINGS

Slew bearings and rings information

Galperti Tech Forged Products manufactures excellence in large diameter slew bearings, geared rings and related products. Excellence is met using state of the art design, manufacturing and testing methods, maximizing the value of the experienced senior engineers' knowledge and the most reliable calculation methods. Design verification is performed with the newest CAD/CAM design tools and FEA analysis programs. A fully integrated server based computerized system allows manufacturing control on all manufacturing phases, supply chain survey and project management.



Segmented gear ring



GALPERTI SLEWING RINGS

Slew bearings and rings information

Different applications and requirements ask customized solutions for slew bearings. This means different rolling bodies' sizes and types segmented gear ring and their combination, different rolling bodies' races paths and design. Inner or outer gears, no gear, may be required as well. Galperti Tech Forged Products manufacturing capability to manufacture slew bearings with the mentioned customized solutions dimensionally ranges from 250 mm minimum to 6.200 mm outer diameter. Such size and products range of choice allow GTFP to serve different market segments starting from petrochemical applications and energy industry, including Wind Power for pitch and yaw bearings, three rows of roller type main bearings and tower flanges.



Tower flanges



Yaw bearings



Male pinion



ENERGY PROJECTS

Energy dedicated Forged Products

The GTFP internal Design resources, our manufacturing characterized by the flexibility of our machining allows in house design and manufacture of a large variety of forged products, to serve a Broad range of market segments as Oil&Gas offshore and onshore, SubSea, Power Generation and pressure vessels.



SUBSEA	Field Development	Wye Tees Bulk Heads Anchoring Flanges Reducers
	PLEM/PLET	"Forged Rings" Ball Mis- Alignment Flanges Connection Pieces
	Riser System	Hanger Spool Coiled Tubing Riser Connectors Tapered Joints Goosenecks Forgings Forged Pipes Pad Eye
	Pipeline Installation	J-lay collars Buckle Arrestors CHOCs Centralizers

ON-SHORE	Special components	Forged Pipes Monoblock Insulating Joint
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OFF-SHORE	Forged Components	Rings, Pinions, Bars, ...
	Assembled Components	Swivel Stacks Utility Swivels Chain Stopper

POWER GENERATION	Forged Components	Shaft Plates Rolls Heavy wall Forged Tubes
	Rolled Rings Built to Drawing	Rings Hollow Forging Shafts Flanges



With automatically direct marking of hardness value on item



Hardness test

ENERGY PROJECTS

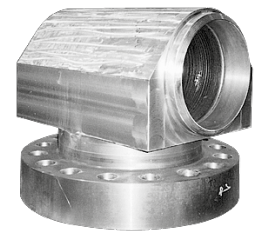
Energy dedicated Forged Products



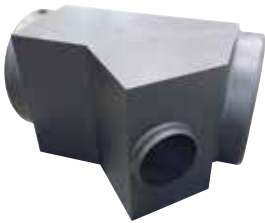
CONNECTING PIECE



BUCKLE ARRESTOR



FLANGED BLOCK



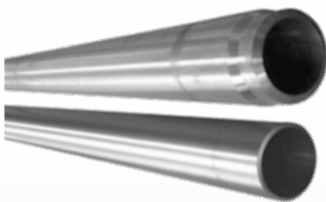
WYE



FORGED ANCHOR



SWIVEL JOINT



FORGED PIPES



PIPE ASSEMBLING



TUBE SHEET



MULTILINES BULKHEAD



NON STANDARD FLANGES



J-LAY COLLARS



INSULATING JOINT



NOZZLE



LONG WELDING NECK

GALPERTI FLANGES

Energy dedicated Products

The standard flange and special flange range produced at Galperti Group are available in various dimension options in a wide range of material.



The standard type of steel flanges mostly used are:

- Welding Neck Flange
- Slip On Flange
- Socket Weld Flange
- Lap Joint Flange
- Threaded Flange
- Blind Flange

In addition to the most used standard flanges, there are still a number of special steel flanges such as:

- Orifice Flanges
- Long Welding Neck Flanges
- Weldo flange
- Nipo flange
- Expander Flange
- Reducing Flange

Other flanges may be produced upon drawing and other specific requests.

Further important parameter to produce your flange is the flange faces classification:

- Flat Face (FF)
- Raised Face (RF)
- Ring-Type Joint (RTJ)
- Tongue and Groove (T&G)
- Male and Female (M&F)



Materials for Flanges used mostly are Carbon steel, Stainless steel, Alloy Steel, Inconel, Nickel, Titanium and other.

GALPERTI FLANGES

G-C[®] COMPACT FLANGES

G-C Compact Flange System[®] is a fully proven alternative to the conventional flanged connection used throughout the oil, gas, petrochemical and power generation industries.

Produced in a comprehensive range of sizes and materials they offer versatility, compactness, weight saving and cost effectiveness in connecting piping system.



G-C Compact Flange System[®] is designed to meet ANSI B 16.5, ASME VIII, API 6A/Q1 and other design codes. The design has the approval of Lloyds, DNV and Stoomwezen.



Fully fire tested in accordance with API 6FB parts 1 and 2, and gas tested to meet all aspects of ASME B31.3 Chapter IX (e.g. 1400 bar at 180°C Gas test with applied bending moment).



FORGED TUBES

Special products

Forged high thickness tubes

Galperti FORGED TUBES are designed according with the highest production standards to guarantee the wider applicability in projects with strictly design rules. Galperti FORGED TUBES are designed, manufactured and tested completely internally of GALPERTI Group in full compliance with the most stringent international Standards and Customer's specifications.

QUALITY ASSURANCE

- Our facility is ISO 9001 Certified Quality System.
- Our metallurgy laboratory is ISO 19025, to meet highest level of Project quality assurance requirements.

SIZE RANGE

- OD From 12" to 30" as standard design.
- Length up to 12 m

TYPE

- Butt Weld, BW / Fillet Weld, FW

OTHER TEST ACCORDING TO CUSTOMER SPECIFIC REQUIREMENTS SUCH AS:

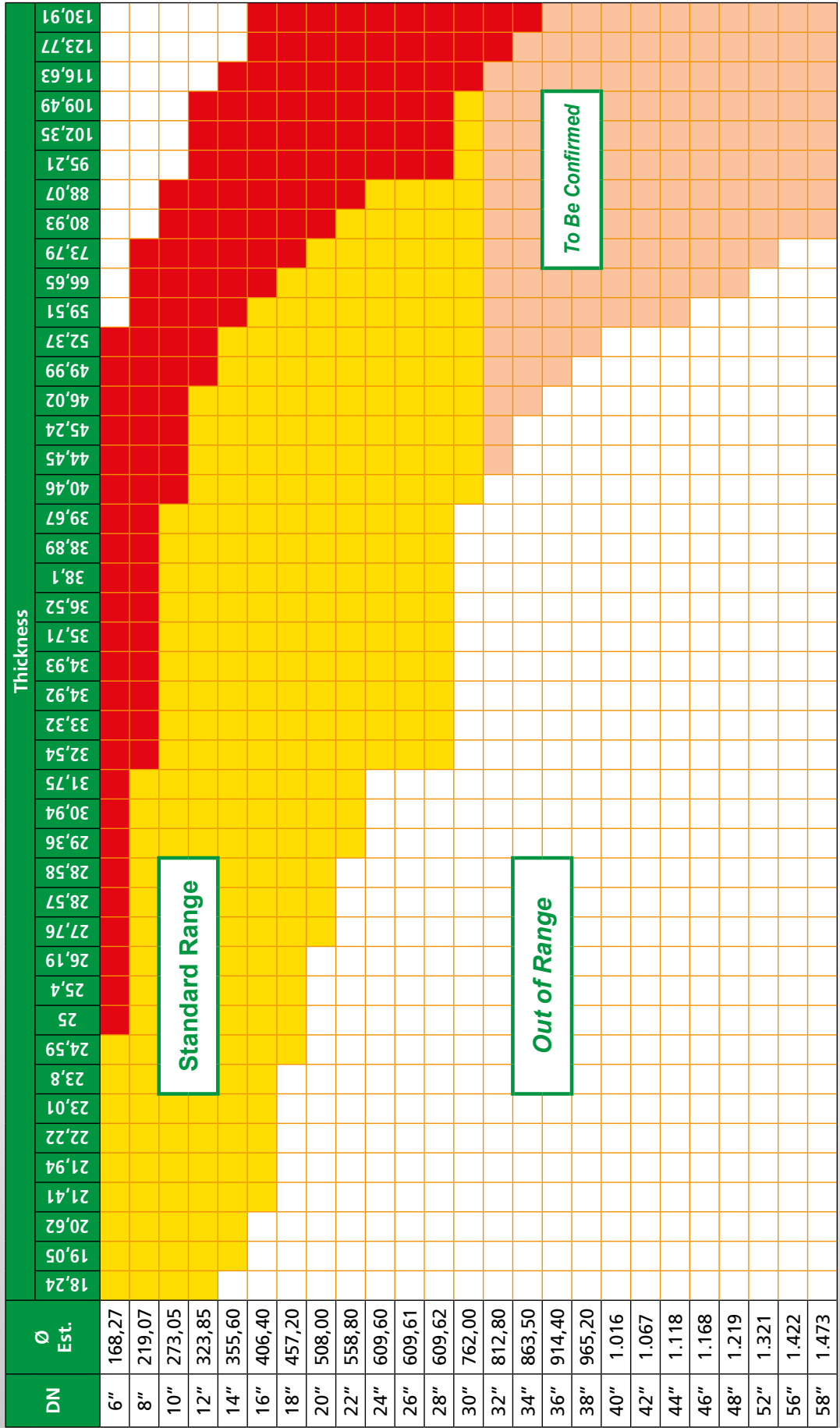
- Hydrostatic pressure and Bending test
- Torsional test
- Hydrostatic Fatigue test
- Combined Hydro-Thermo-Bending test



FORGED TUBES

Special products

Delivery program



SIZE RANGE

- From 6" to 30" as standard design.
- Length up to 16 m

- Special Alloy's**
- ASTM/ASME B/SB 444
 - ASTM/ASME B/SB 423

- Duplex**
- ASTM/ASME A/SA 790
 - ASTM/ASME A/SA 790
 - EN 10216-5

- Stainless Steel**
- ASTM/ASME A/SA 312
 - ASTM/ASME A/SA 213
 - ASTM/ASME A/SA 182
 - EN 10216-5

COMMON STANDARDS

- Carbon Steel**
- ASTM/ASME A/SA 106
 - ASTM/ASME A/SA 213
 - ASTM/ASME A/SA 333
 - ASTM/ASME A/SA 334
 - ASTM/ASME A/SA 335
 - ASTM/ASME A/SA 369
 - EN10216-2
 - API 5L

MONOLITHIC INSULATION JOINT

Special Products



The state of the art in Oil&Gas pipeline corrosion protection

Galperti G-JOINT monolithic insulating joints are used to electrically isolate sections of a pipeline to ensure full efficiency to cathodic protection systems against corrosion.

Galperti G-JOINT monolithic insulating joints are designed, manufactured and tested in full compliance with the most stringent international Standards and Customer's specifications.

QUALITY ASSURANCE

- Our facility is ISO 9001 Certified Quality System.
- Our metallurgy laboratory is ISO 19025, to meet highest level of Project quality assurance requirements.

DESIGN AND CALCULATIONS

- Galperti G-JOINT monolithic insulating joints are designed in accordance with ASME VIII Div.1 and applicable Codes (ASME B31.3, 31.4, 31.8), or according to Clients' specific requirements.
- Finite Elements Analysis (with ANSYS software) available on request.

SIZE RANGE

- From ½" to 56"

PRESSURE RATING

- From PN 25 to PN 100.
- Other pressure ratings available upon request.

TYPE

- Butt Weld, BW / Fillet Weld, FW

OTHER TEST ACCORDING TO CUSTOMER SPECIFIC REQUIREMENTS SUCH AS:

- Hydrostatic pressure and Bending test
- Torsional test
- Hydrostatic Fatigue test
- Combined Hydro-Thermo-Bending test

MATERIALS

- PIPE SECTIONS
 - Carbon steel pipes in accordance with API, ASTM, DIN and other standards
 - Rolled plates longitudinally arc welded
- BODY
 - Forged materials or seamless ring made of plate material, depending upon requirements
- SEALING
 - Seals of aging resistant material from nitrile, fluoride and silicone elastomers in accordance with ASTM D-2000
- INSULATING MATERIALS
 - Epoxy-glass laminates or epoxy-glass prefabrications in accordance with ASTM D-709
- COATINGS
 - Internal surfaces: epoxy resins or according to Clients' specific requirements
 - External surfaces: epoxy primers, epoxy paints or according to Clients' specific requirements

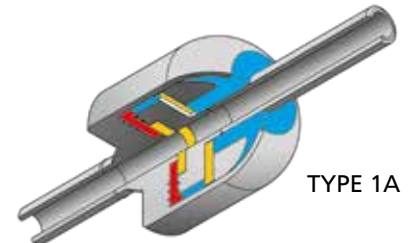
WELDING AND NON DESTRUCTIVE TESTING

- All welding processes are in accordance with ASME IX and are certified by independent and Internationals Authorities. Non destructive tests using dye penetrants, magnetoscopic, x-rays and ultrasonic inspections in accordance with ASME VIII, ASME V, ASME B16.34, ASME SA-388 and applicable Codes.

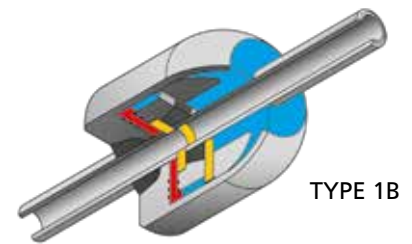
TESTING

According to the agreed requirements, typically:

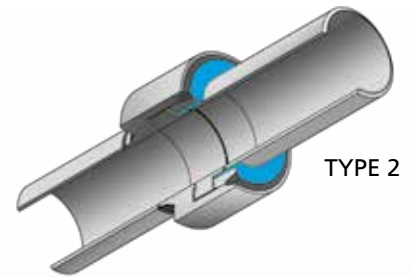
- Hydrostatic pressure test (typically 1.5 times the rated pressure)
- Electrical resistant test in dry air (typical 5M with 1kV d.c.)
- Dielectric strength test (typical 3kV with 50Hz a.c. for 1')
- Dimensional checks



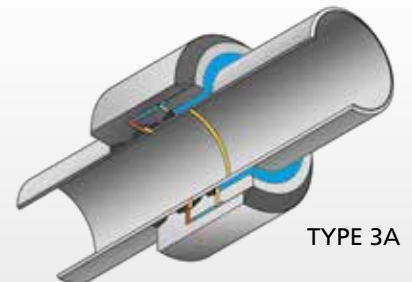
TYPE 1A



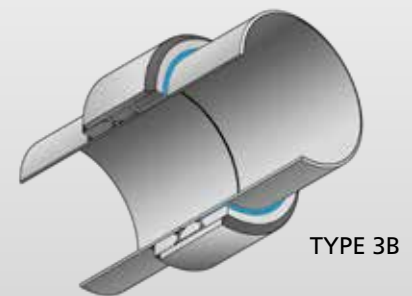
TYPE 1B



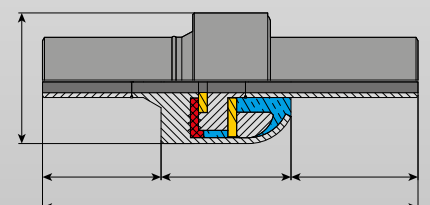
TYPE 2



TYPE 3A



TYPE 3B



MIJ - BW DESIGN

SIZE		PN25 - ANSI Class 300						PN64 - ANSI Class 600						PN100 - ANSI Class 600					
DN		Overall Length	External Diameter	Length	Length	Weight	TYPE	Overall Length	External Diameter	Length	Length	Weight	TYPE	Overall Length	External Diameter	Length	Length	Weight	TYPE
[mm]	[inch]	L [mm]	D [mm]	L1 [mm]	L2 [mm]	W [kg]		L [mm]	D [mm]	L1 [mm]	L2 [mm]	W [kg]		L [mm]	D [mm]	L1 [mm]	L2 [mm]	W [kg]	
15	1/2"	250	70	86,5	77	1,6	1a	250	84	80,75	88,5	2,4	1a	250	86	78,25	93,5	2,7	1a
20	3/4"	250	75	83,5	83	2,0	1a	250	89	77,75	94,5	2,9	1a	250	91	75,25	99,5	3,3	1a
25	1"	250	82	82	86	2,4	1a	250	96	76,25	97,5	3,5	1a	250	98	73,75	102,5	3,9	1a
32	1-1/4"	300	94	104	92	3,2	1a	300	108	96,25	107,5	5,0	1a	300	111	93,25	113,5	5,7	1a
40	1-1/2"	300	101	101	98	4,1	1a	300	122	93,75	112,5	6,5	1a	300	125	91,75	116,5	7,3	1a
50	2"	350	120	123,5	103	6,2	1a	350	135	117,25	115,5	8,4	1a	350	137	112,25	125,5	9,4	1a
65	2-1/2"	350	136	119	112	8,4	1a	350	151	112,25	125,5	11,0	1a	350	154	107,25	135,5	12,8	1a
80	3"	400	150	136,25	127,5	11,5	1a	500	165	181,25	137,5	16,4	1a	500	167	177,25	145,5	17,9	1a
100	4"	400	178	134,75	130,5	21	1a	500	191	176,75	146,5	22	1a	500	193	168,25	163,5	25	1a
125	5"	500	206	182,75	134,5	20	1a	600	244	222,75	154,5	45	2	600	248	209,25	181,5	53	2
150	6"	500	240	181,25	137,5	28	1a	600	279	218,75	162,5	59	2	600	284	202,75	194,5	71	2
200	8"	500	300	178,25	143,5	42	1a	600	338	212,75	174,5	86	2	600	344	191,25	217,5	107	2
250	10"	700	359	274,75	150,5	64	1a	800	407	302,25	195,5	143	2	800	429	280,25	239,5	189	2
300	12"	700	428	273,25	153,5	88	1a	800	458	297,75	204,5	173	2	800	478	275,75	248,5	224	2
350	14"	900	479	349,25	201,5	162	2	1000	498	393,25	213,5	250	2	1000	518	371,25	257,5	308	2
400	16"	900	540	345,75	208,5	201	2	1000	553	388,75	222,5	295	2	1000	577	362,25	275,5	378	2
450	18"	900	592	333,75	232,5	242	2	1000	606	384,25	231,5	339	2	1000	636	351,75	296,5	459	2
500	20"	1000	646	378,25	243,5	289	2	1200	664	478,25	243,5	432	2	1200	692	442,75	314,5	571	2
550	22"	1000	719	376,75	246,5	359	2	1200	734	444,5	311	586	2	1200	763	425,5	349	720	2
600	24"	1000	774	366,75	266,5	415	2	1200	785	440	320	647	2	1200	815	400	400	861	2
650	26"	1000	832	347,25	305,5	522	2	1200	847	426,5	347	801	2	1200	878	391	418	1037	2
700	28"	1100	889	390	320	617	2	1300	906	466	368	949	2	1300	933	436,5	427	1168	2
750	30"	1100	940	385,5	329	672	2	1300	964	457	386	1147	2	1300	994	432	436	1390	2
800	32"	1100	995	376,5	347	810	2	1300	1023	446,5	407	1341	2	1300	1055	427,5	445	1562	2
850	34"	1100	1066	373	354	932	2	1300	1076	442	416	1448	2	1300	1106	421,5	457	1715	2
900	36"	1200	1117	411	378	1059	2	1400	1134	487,5	425	1691	2	1400	1164	467	466	1976	2
950	38"	1200	1179	406,5	387	1247	2	1400	1198	483	434	1929	2	1400	1225	425	550	2440	2
1000	40"	1200	1232	399	402	1354	2	1400	1250	474	452	2139	2	1400	1286	414,5	571	2784	2
1050	42"	1200	1287	390	420	1503	2	1400	1315	466,5	467	2452	2	1400	1341	401	598	3098	2
1200	48"	1400	1448	480	440	1904	2	1800	1468	645,5	509	3241	2	1800	1510	569,5	661	4259	2
1400	56"	1900	1663	695	510	2778	2	2500	1718	963	574	5168	2	2500	1753	877,5	745	6559	2

MIJ - FW DESIGN

SIZE		PN25 - ANSI Class 300						PN64 - ANSI Class 600						PN100 - ANSI Class 600					
DN		Overall Length	External Diameter	Length	Length	Weight	TYPE	Overall Length	External Diameter	Length	Length	Weight	TYPE	Overall Length	External Diameter	Length	Length	Weight	TYPE
[mm]	[inch]	L [mm]	D [mm]	L1 [mm]	L2 [mm]	W [kg]		L [mm]	D [mm]	L1 [mm]	L2 [mm]	W [kg]		L [mm]	D [mm]	L1 [mm]	L2 [mm]	W [kg]	
15	1/2"	250	70	86,5	77	1,6	1b	250	84	80,75	88,5	2,4	1b	250	86	78,25	93,5	2,7	1b
20	3/4"	250	75	83,5	83	2,0	1b	250	89	77,75	94,5	2,9	1b	250	91	75,25	99,5	3,3	1b
25	1"	250	82	82	86	2,4	1b	250	96	76,25	97,5	3,5	1b	250	98	73,75	102,5	3,9	1b
32	1-1/4"	300	94	104	92	3,2	1b	300	108	96,25	107,5	5,0	1b	300	111	93,25	113,5	5,7	1b
40	1-1/2"	300	101	101	98	4,1	1b	300	115	93,75	112,5	5,8	1b	300	118	91,75	116,5	6,6	1b
50	2"	350	120	123,5	103	6,2	1b	350	130	117,25	115,5	7,8	1b	350	132	112,25	125,5	8,8	1b
65	2-1/2"	350	136	119	112	8,4	1b	350	146	112,25	125,5	10,4	1b	350	149	107,25	135,5	12,0	1b
80	3"	400	150	136,25	127,5	11,5	1b	500	165	181,25	137,5	16,4	1b	500	167	177,25	145,5	17,9	1b
100	4"	400	178	134,75	130,5	21	1b	500	191	176,75	146,5	22	1b	500	193	168,25	163,5	25	1b
125	5"	500	206	182,75	134,5	20	1b	600	244	222,75	154,5	45	3a	600	244	209,25	181,5	50	3a
150	6"	500	239	181,25	137,5	28	1b	600	279	218,75	162,5	59	3a	600	279	202,75	194,5	67	3a
200	8"	500	300	178,25	143,5	42	1b	600	334	212,75	174,5	83	3a	600	340	191,25	217,5	103	3a
250	10"	700	359	274,75	150,5	64	1b	800	403	302,25	195,5	139	3a	800	415	280,25	239,5	170	3a
300	12"	700	416	273,25	153,5	78	1b	800	454	297,75	204,5	168	3a	800	468	275,75	248,5	208	3a
350	14"	900	479	349,25	201,5	157	3a	1000	490	393,25	213,5	239	3a	1000	504	371,25	257,5	283	3a
400	16"	900	539	345,75	208,5	194	3a	1000	547	388,75	222,5	285	3a	1000	563	362,25	275,5	349	3a
450	18"	900	590	333,75	232,5	233	3a	1000	600	384,25	231,5	328	3a	1000	622	351,75	296,5	423	3a
500	20"	1000	644	378,25	243,5	279	3a	1200	654	478,25	243,5	411	3a	1200	676	442,75	314,5	524	3a
550	22"	1000	709	376,75	246,5	335	3b	1200	724	444,5	311	555	3b	1200	743	425,5	349	649	3b
600	24"	1000	764	366,75	266,5	387	3b	1200	775	440	320	613	3b	1200	795	400	400	774	3b
650	26"	1000	824	347,25	305,5	495	3b	1200	837	426,5	347	762	3b	1200	849	391	418	908	3b
700	28"	1100	877	390	320	571	3b	1300	896	466	368	904	3b	1300	904	436,5	427	1028	3b
750	30"	1100	932	385,5	329	639	3b	1300	954	457	386	1096	3b	1300	964	432	436	1236	3b
800	32"	1100	983	376,5	347	754	3b	1300	1003	446,5	407	1249	3b	1300	1025	427,5	445	1396	3b
850	34"	1100	1054	373	354	871	3b	1300	1066	442	416	1387	3b	1300	1076	421,5	457	1534	3b
900	36"	1200	1105	411	378	990	3b	1400	1128	487,5	425	1652	3b	1400	1134	467	466	1782	3b
950	38"	1200	1179	406,5	387	1247	3b	1400	1178	483	434	1813	3b	1400	1185	425	550	2139	3b
1000	40"	1200	1232	399	402	1354	3b	1400	1232	474	452	2033	3b	1400	1256	414,5	571	2552	3b
1050	42"	1200	1287	390	420	1503	3b	1400	1295	466,5	467	2314	3b	1400	1311	401	598	2846	3b
1200	48"	1400	1448	480	440	1904	3b	1800	1458	645,5	509	3174	3b	1800	1498	569,5	661	4149	3b
1400	56"	1900	1663	695	510	2778	3b	2500	1678	963	574	4729	3b	2500	1698	877,5	745	5797	3b

FORGED GOODS

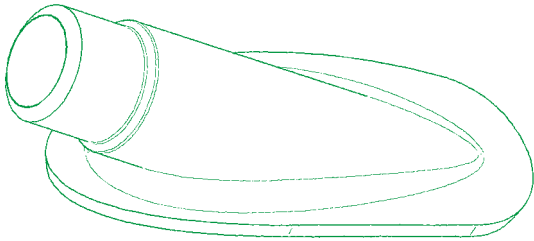
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From Design



To Final Production and Tests



QUALITY ASSURANCE

- Our facility is ISO 9001 Certified Quality System.
- Our metallurgy laboratory is ISO 19025, to meet highest level of Project quality assurance requirements.

SIZE RANGE

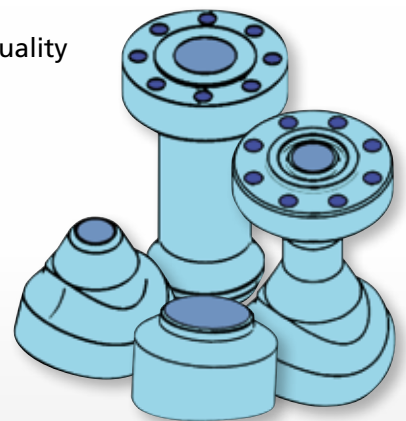
- From 1/2" to 30" OD as standard design.

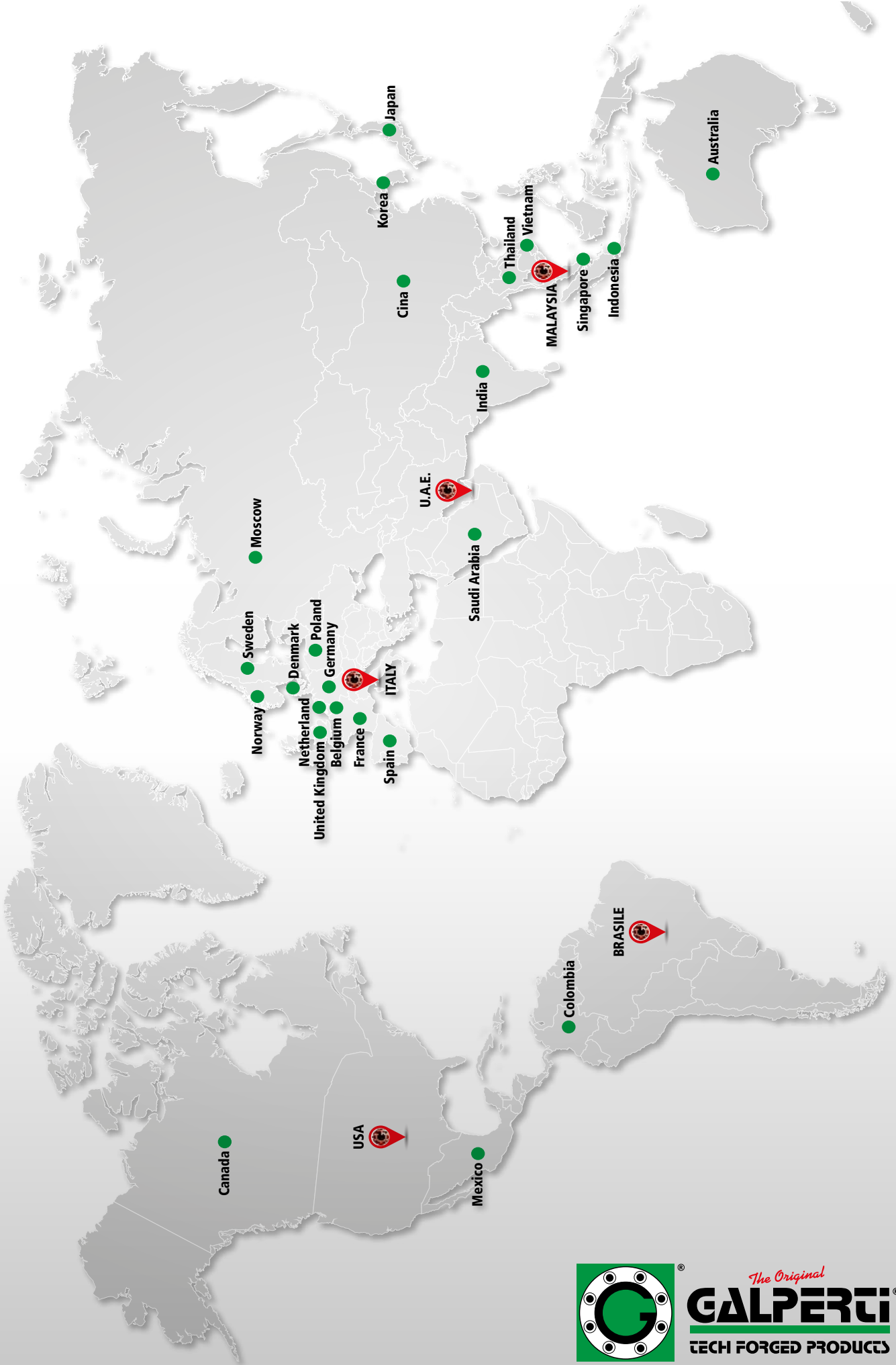
TYPE

- Butt Weld, BW / Fillet Weld, FW

OTHER TEST ACCORDING TO CUSTOMER SPECIFIC REQUIREMENTS SUCH AS:

- Hydrostatic pressure test
- Torsional test
- Hydrostatic Fatigue test
- Combined Hydro-Thermo-Bending test





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