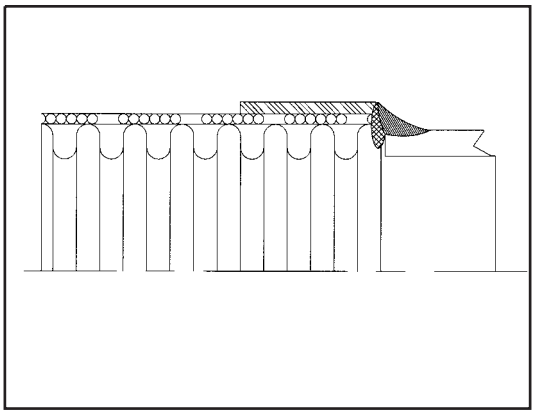
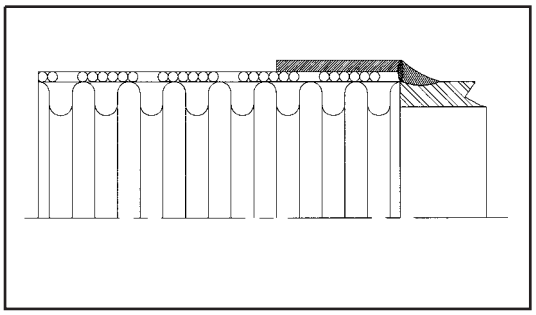
Corrugated Metal Hose *(Fabrication Options)*

A. Specialized Attachment Techniques:

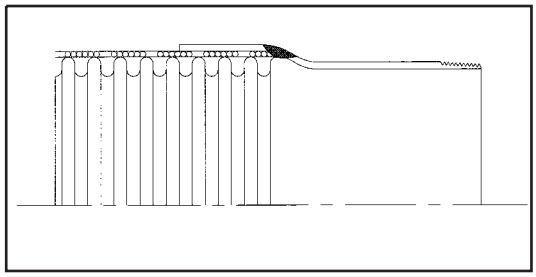


Industry Standard ***- This method will be used unless another method is specified.***
Standard fabrication of an assembly generally consists of:

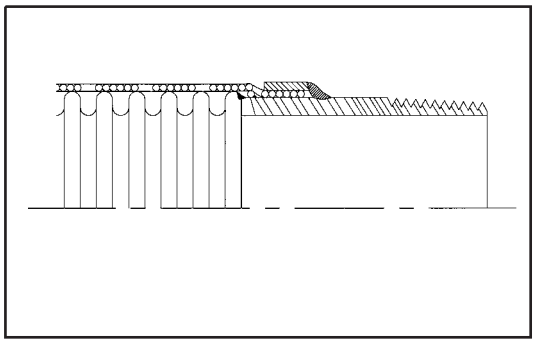
- Cutting the hose and braid through a hose corrugation valley.
- Installation of a braid collar over each end of the hose.
- Trimming of any excess braid.
- "Cap" welding the hose, braid, and braid collar together.
- Cleaning the cap weld surface.
- Placement and alignment of a fitting on the cap weld.
- "Attachment" welding the fitting to the cap weld.
- Silver brazing is also available. Consult factory.



Half-Corrugation - Standard fabrication sometimes leaves a portion of the cut corrugation, or corrugation "lip", just under the base of the fitting. In specialized applications this residual lip may not be desirable. To prevent any exposed corrugation edges from causing damage, the hose can be specially prepared for welding by cutting the corrugation on the crest, rather than in the valley, thereby removing the lip.



Smooth Transition Weld - For applications in which corrosion is a concern, all crevices and fissures must be minimized. Specialized hose and fitting preparation, in conjunction with proprietary welding techniques, is available to provide a full penetration hose-to-fitting weld that is smooth and crevice free.



Braid-Over Construction - Assemblies operating at the upper limits of their rated working pressure or in severe service may benefit from a braid-over construction. The fitting is first welded to the unbraided hose. Then a special metal reinforcing ring is installed over the fitting and next to the weld. Finally the braid is drawn over the end of the hose and the ring, and welded to the side of the fitting. This technique reduces the amount of heat introduced into the braid wires, nearly eliminates the heat effected zones of the cap and attachment welds, and maximizes the wire strength. Braid-over construction may also be used for specific high cycle applications.