

SIGRAFLEX® HOCHDRUCKPRO

TA Luft-Compliant Sealing Sheet Made from Natural Graphite with High-Integrity Stainless Steel Foil Reinforcement for Extreme Conditions

Expanded Graphite



Broad Base. Best Solutions.

SIGRAFLEX® HOCHDRUCKPRO

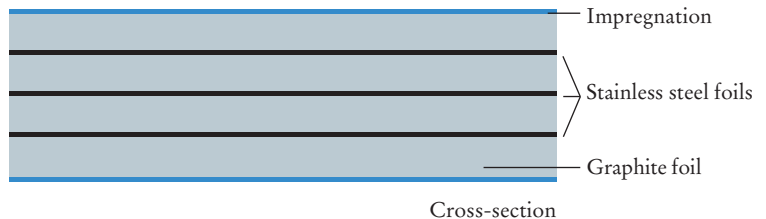
Our Contribution to Environmental Protection

SIGRAFLEX® HOCHDRUCKPRO

is a multilayer high-strength graphite sealing sheet comprising 0.5 mm thick layers of high-purity graphite foil and 0.05 mm thick stainless steel foils. Depending on the sheet thickness required, several layers of graphite and stainless steel foil are joined together in a patented adhesive-free process. As a result, the sheets have outstanding mechanical properties. The sealing sheet is impregnated to reduce leakage and improve handling. SIGRAFLEX HOCHDRUCK PRO allows end users in the process industry to cover almost their entire gasket application range with a reliable and safe product.

Applications

- ▶ For difficult and mechanically highly stressed sealed joints (in tongue-and-groove and special-dimension flanges, process equipment, heat exchangers); also suitable for all common pipework and vessel flange designs
- ▶ Recommended for one-piece gaskets up to 1500 mm outside diameter; for diameters over 1500 mm as two-layer structures with segmented sections and staggered joints, for instance
- ▶ For high internal pressures of up to 250 bar
- ▶ For corrosive media
- ▶ Suitable for a broad range of temperatures from -250°C to approx. 550°C; for applications at more than 450°C, users should request our advice
- ▶ Gaskets for the chemical, petrochemical and refinery industries
- ▶ Steam pipework and boilers in power stations
- ▶ Heat transfer oil and heating facilities
- ▶ Inspection glasses, pumps, fittings
- ▶ Existing plants



Properties

- ▶ Reduction in fugitive emissions due to very high leak-tightness
- ▶ Complies with the strict TA Luft leakage requirements for all sheet thicknesses
- ▶ Very high maximum permissible gasket stress
- ▶ High operational reliability and excellent oxidation resistance
- ▶ High blow-out resistance and very high mechanical strength
- ▶ Very high fault tolerance during assembly and operation
- ▶ Good chemical resistance
- ▶ Long-term stability of compressibility and recovery, even under fluctuating temperatures
- ▶ Good scratch resistance; antistick finish due to special impregnation
- ▶ No measurable cold or warm flow characteristics up to the maximum permissible gasket stress
- ▶ No aging or embrittlement, owing to the absence of adhesives or binders
- ▶ Ease of processing
- ▶ Asbestos-free, no associated health risks

Approvals

- ▶ TA Luft (VDI 2440/VDI 2200) for all thicknesses
- ▶ Fire safety according to API 607
- ▶ Blow-out resistance (TÜV at 2.5 times the nominal pressure)
- ▶ BAM oxygen
- ▶ DVGW (DIN 3535-6)



Assembly instructions

For assembly, use dry and undamaged gaskets only. Wet graphite gaskets must not be fitted unless first dried completely. The sealing faces must be clean, dry and free from grease. Do not use release agents! Position the gasket centrally and avoid mechanical stresses during assembly. An assembly aid can be used if necessary. To facilitate assembly in difficult positions, the gasket may be fixed by using a commercially available adhesive. However, the adhesive should be applied sparingly at a few points only.

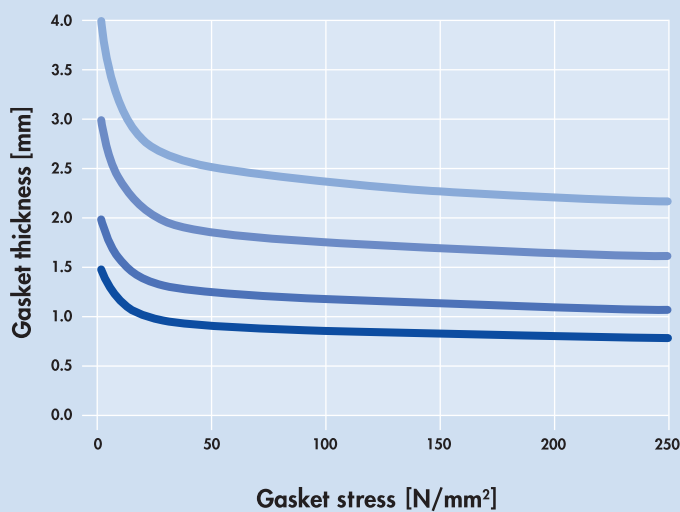
Align the flanges as plane-parallel as possible. First hand-tighten the bolts and then tighten the bolts in a crosswise order to about 50% of the maximum torque value, in the second stage to about 80% and to the full value in the third stage. All bolts must be tightened to the specified bolt load, so the torque must be checked repeatedly. Our detailed assembly instructions are available on request.



Our patented, overlap-free laser welding process allows sheets of up to 1500 mm width without leakage channels



Compressibility of SIGRAFLEX® HOCHDRUCKPRO



■ V15011Z3I-P ■ V20011Z3I-P ■ V30011Z3I-P ■ V40011Z3I-P

Forms supplied

SIGRAFLEX HOCHDRUCK PRO sheets are available in the following dimensions and type designations:

Dimensions in mm

1500 x 1500 x 1.5
1500 x 1500 x 2.0
1500 x 1500 x 3.0
1500 x 1500 x 4.0

Types

V15011Z3I-P
V20011Z3I-P
V30011Z3I-P
V40011Z3I-P

The sheets can also be supplied in dimensions of 1000 x 1000 mm.

Material data of SIGRAFLEX® HOCHDRUCKPRO

Material type		V15011Z3I-P	V20011Z3I-P	V30011Z3I-P	V40011Z3I-P	
Thickness	mm	1.5	2.0	3.0	4.0	
Dimensions	m	1.5 x 1.5 / 1.0 x 1.0				
Bulk density of graphite	g/cm ³	1.1				
Ash content of graphite (DIN 51903)	%	≤0.15				
Total chloride content	ppm	≤10				
Reinforcing steel foil details		Flat stainless steel foil				
ASTM material number		316 (L)				
Thickness	mm	0.05				
Number of foils		2	3	5	7	
Residual stress (DIN 52913) σ_D 16 h, 300°C, 50 N/mm ²	N/mm ²	≥ 48				
Gasket factors (DIN E 2505/DIN 28090-1)						
Gasket width $b_D = 20$ mm						
$\sigma_{VU/0.1}$ at an internal pressure of	10 bar	N/mm ²	10	10	10	11
	16 bar	N/mm ²	10	12	13	14
	25 bar	N/mm ²	12	14	15	17
	40 bar	N/mm ²	14	16	18	20
m		1.3	1.3	1.3	1.3	
σ_{VO}		N/mm ²	290	270	240	200
σ_{BO} at 300°C		N/mm ²	230	210	180	160
Compression factors (DIN 28090-2)						
Compressibility	ϵ_{KSW}	%	30 - 40			
Recovery at 20°C	ϵ_{KRW}	%	4 - 6			
Hot creep	ϵ_{WSW}	%	< 3			
Recovery at 300°C	ϵ_{WRW}	%	3 - 5			
Young's modulus at 20 N/mm ² (DIN 28090-1)		N/mm ²	750			
ASTM	"m" factor		2.5			
	"y" factor	psi	2000			
Compressibility		%	30 - 40			
Recovery	ASTM F36	%	20 - 30			
The gasket factor conversion formulas as per AD Merkblatt B7 are as follows:			$k_0 \cdot K_D = \sigma_{VU} \cdot b_D$ $k_1 = m \cdot b_D$			

Definitions

$\sigma_{VU/0.1}$	Minimum gasket assembly stress needed to comply with leakage class L 0.1 (according to DIN 28090-1)	k_0	In mm, factor for gasket assembly stress
	Recommended gasket assembly stress: ≥ 20 N/mm ² up to σ_{BO}	k_1	In mm, factor for gasket stress in service
σ_{BU}	Minimum gasket assembly stress in service, where σ_{BU} is the product of internal pressure p and gasket factor m for test and in service ($\sigma_{BU} = p \cdot m$)	K_D	In N/mm ² , max. gasket stress-bearing capacity under assembly conditions
σ_{VO}	Maximum permissible gasket stress at 20°C	ϵ_{KSW}	Compression set under a gasket stress of 35 N/mm ²
$\sigma_{BO,300^\circ C}$	Maximum permissible gasket stress in service	ϵ_{KRW}	Gasket recovery after reduction in gasket stress from 35 N/mm ² to 1 N/mm ²
m	σ_{BU} / p_i	ϵ_{WSW}	Gasket creep compression under a gasket stress of 50 N/mm ² at 300°C after 16 h
"m" factor	Similar to m, but defined according to ASTM, hence different value	ϵ_{WRW}	Recovery after reduction in gasket stress from 50 N/mm ² to 1 N/mm ²
"y" factor	Minimum gasket stress in psi		

The percentage changes in thickness of ϵ_{KSW} , ϵ_{KRW} , ϵ_{WSW} and ϵ_{WRW} are relative to the initial thickness.

Gasket factors of SIGRAFLEX® HOCHDRUCKPRO according to DIN EN 13555

L	PN	e _{G0}	Q _{min/L}	Q _{Smin/L}				e _{G0}	Q _{min/L}	Q _{Smin/L}			
				Q _{A=20}	Q _{A=40}	Q _{A=60}	Q _{A=80}			Q _{A=20}	Q _{A=40}	Q _{A=60}	Q _{A=80}
10 ⁻¹	10	2	< 10	< 10	< 10	< 10	< 10	3	< 10	< 10	< 10	< 10	< 10
10 ⁻¹	16	2	< 10	< 10	< 10	< 10	< 10	3	< 10	< 10	< 10	< 10	< 10
10 ⁻¹	25	2	< 10	< 10	< 10	< 10	< 10	3	< 10	< 10	< 10	< 10	< 10
10 ⁻¹	40	2	< 10	< 10	< 10	< 10	< 10	3	< 10	< 10	< 10	< 10	< 10
10 ⁻²	10	2	< 10	< 10	< 10	< 10	< 10	3	< 10	< 10	< 10	< 10	< 10
10 ⁻²	16	2	11	< 10	< 10	< 10	< 10	3	12	< 10	< 10	< 10	< 10
10 ⁻²	25	2	13	< 10	< 10	< 10	< 10	3	14	< 10	< 10	< 10	< 10
10 ⁻²	40	2	16	< 10	< 10	< 10	< 10	3	17	< 10	< 10	< 10	< 10

Relaxation ratio P_{QR}

P _{QR}	e _{G0}	RT		150 °C		300 °C	
		2	3	2	3	2	3
30		0.97	0.98	0.95	0.93	0.91	0.91
50		0.98	0.98	0.96	0.97	0.96	0.94
200/200/200		1.00		0.99		0.99	
200/200/180			1.00		0.99		0.98

Max. permissible gasket stress Q_{Smax}

Q _{Smax}	e _{G0}	RT	150 °C	300 °C
		2	3	2
2		> 200	> 200	> 200
3		> 200	200	180

Secant unloading modulus E_G





E _G	e _{G0}	RT		150 °C		300 °C	
		2	3	2	3	2	3
20		364	382	419	398	406	371
30		518	562	585	606	560	584
40		832	889	776	868	805	766
50		957	1148	1099	1121	1055	1109
60		1432	1287	1247	1246	1275	1325
80		1600	1760	1649	1983	1524	1621
100		2029	2649	1700	2231	2043	1939
120		2629	3123	2855	2828	2277	2878
140		3200	3057	3026	2872	2484	3354
160		3117	3464	2934	3327	2967	3185
180		3318	3764	3096	3958	2787	3208
200		3344	4428	3087	4768		



Definitions

E _G	[MPa]	Secant unloading modulus of the gasket
e _{G0}	[mm]	Gasket thickness
L	[mg/(s·m)]	Leakage class
PN	[bar]	Nominal pressure
Q _A	[MPa]	Gasket assembly stress
P _{QR}		Relaxation ratio for stiffness C = 500 kN/mm
Q _{min/L}	[MPa]	Minimum gasket assembly stress
Q _S	[MPa]	Gasket stress
Q _{Smin/L}	[MPa]	Minimum gasket stress in service
Q _{Smax}	[MPa]	Maximum permissible gasket stress before damage occurs
RT		Room temperature
Further values on request.		

Product overview

Product		Characteristics	Recommended applications
SIGRAFLEX® FOIL F.....C/Z/APX	▲	Flexible, continuous	-250°C to approx. 550°C; for compressed packings, spiral-wound and kammprofile gaskets
SIGRAFLEX® STANDARD L.....CI	■	Unreinforced, impregnated	Raised-face flanges; enamel or glass flanges; highly corrosive media
SIGRAFLEX® ECONOMY V.....C4	■ ▲	Reinforced with bonded s/s** foil	Pumps; fittings; gas supply; waste gas pipelines
SIGRAFLEX® UNIVERSAL V.....C2I	■	Reinforced with tanged s/s** foil, impregnated	Pipework and vessels in the petro-/chemical industries and in power stations
SIGRAFLEX® UNIVERSAL PRO V.....C2I-P 	■	Reinforced with tanged s/s** foil, impregnated	For TA Luft* applications; for pipework and vessels in the petro-/chemical industries and in power stations
SIGRAFLEX® SELECT V16010C3I 	●	High-integrity s/s** foil reinforcement, impregnated	For TA Luft* applications; raised-face flanges; pipework in the chemical and petrochemical industries
SIGRAFLEX® HOCHDRUCK V.....Z3I	■	High-integrity multilayer laminate, impregnated	Universal sealing sheet, also for solving sealing problems in pipework, process equipment, tongue-and-groove flanges and non-standard joints in the petro-/chemical industries and in power stations
SIGRAFLEX® HOCHDRUCK PRO V.....Z3I-P 	■	High-integrity multilayer laminate, impregnated	Universal sealing sheet for TA Luft* applications, also for solving sealing problems in pipework, process equipment, tongue-and-groove flanges and non-standard joints in the petro-/chemical industries and in power stations
SIGRAFLEX® MF V.....Z2MF 	●	High-integrity laminate made of graphite, s/s** and PTFE	Maximum requirements for sealability (TA Luft*), safety, chemical resistance and process hygiene; sealed joints in the chemical and petrochemical, pharmaceutical and food industries
SIGRAFLEX® EMAIL V.....Z3E	■	High-integrity s/s** foil reinforcement	PTFE-envelope gaskets in enameled pipework, vessels, stub connections, etc.

Forms supplied: ▲ roll or tape ■ sheet material ● gasket with inner eyelet, for applications requiring TA Luft approval

* TA Luft: German Clean Air Act ** s/s: stainless steel

® registered trademark of SGL Group companies

07 2008/1 2NÄ Printed in Germany

This information is based on our present state of knowledge and is intended to provide general notes on our products and their uses. It should therefore not be construed as guaranteeing specific properties of the products described or their suitability for a particular application. Any existing industrial property rights must be observed. The quality of our products is guaranteed under our "General Conditions of Sale".

Expanded Graphite

SGL TECHNOLOGIES GmbH

Werner-von-Siemens-Str. 18
86405 Meitingen/Germany
Phone +49 8271 83-2276
Fax +49 8271 83-2419
expandedgraphite@sglcarbon.de
www.sigraflex.de

www.sglcarbon.com

