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# DESCRIPTION

## TECHNICAL FIELD

[0001] The present invention relates to banded pipe systems for transfer of hazardous fluids and to fittings for use in such systems. More specifically, the invention relates to a method of installing a banded pipe system *in situ*.

## BACKGROUND

[0002] Pipe-in-pipe systems, otherwise known as banded pipe systems, are increasingly used for conveying fuel or other such hazardous and/or flammable liquids from storage tanks to dispensing pumps or appliances supplied with the liquid. The liquid is conveyed through an inner or primary pipe, and an outer or secondary pipe serves to protect the inner pipe so that in the event of fracture or other such breach of the inner pipe, liquid leaking from the inner pipe may be contained within the outer pipe. Further, when the interstitial space between the outer and inner pipes is closed or sealed, the pressure within the space may be monitored and any change in pressure may indicate the presence of a leak within the system. The pressure monitoring can be coupled to an alarm system which is triggered if the pressure drops. In that event, action may be taken to make the system safe and repair the breach in the inner pipe. As such, banded pipe systems offer an environmentally sound means for conveying hazardous liquids. For similar reasons, banded pipe systems may also be used to distribute gases.

[0003] While use of plastic banded pipework is known, for example high density polyethylene (HDPE) is commonly used in banded systems, due to the fact that such pipes would melt in the event of a fire allowing fuel or other hazardous fluid to leak out and potentially cause an explosion, plastic banded pipework is of limited application and generally for external use only. By contrast, steel pipes are able to withstand higher temperatures and hence are often specified for internal use in order to meet building fire safety requirements.

[0004] A problem exists however when pipe runs have to be altered, for example, during refurbishment of buildings where the appliances they are serving may be relocated. In such situations it is highly impractical and hence rare for the tanks themselves to be relocated; these can be substantial containers for accommodating several thousand litres of fuel. Similarly, use of temporary storage tanks is difficult due to space constraints and they are costly to install. Replacement and alteration of pipework may therefore need to take place whilst the fuel remains in the tanks, especially if part of a back-up generator system. As will be appreciated, installing or altering steel pipework on site while fuel is present in the vicinity would be extremely hazardous since this invariably has involved welding. Such hot works are not permitted around fuel. Welding is also an intrusive process due the creation of smoke, vapour and noise, and can be time consuming. Often, such work must be undertaken "out of hours" to

avoid any negative impact on the surrounding business.

**[0005]** While there are advantages in use of banded steel pipework, it is not a versatile system to work with when changes are required. Banded steel pipework cut by adopting hot works (potentially causing sparks and combustion) is hazardous and therefore the only truly safe way to modify a steel pipe run after installation and filling the system with fuel has been to drain and inert the fuel lines, along with the associated pumps and bulk storage tanks.

**[0006]** Occasionally some of this impact can be reduced by the use of flexible steel- in-steel pipes, but as these are not rigid pipes the pressure between the pipes cannot be accurately monitored for leakage, for example because the pipework does not have a fixed "interstitial" gap between the pipes where a pressure can be created. In addition, as the flexible steel pipework is typically in the form of braided steel hosing it still needs to be cut and measured before assembly on site. Once again, as detailed above, this is a costly process.

**[0007]** United States Patent No. 5,259,651 describes a double wall compression fitting for attachment to a double wall pipeline system made of extruded plastic. The fitting includes inner and outer housings and a separate compression connecting assembly. Joining of the pipes involves using screw threads on the pipes along with a connecting assembly to seal the pipes together in a mechanical joint via the mechanical tightening of the threads. In another embodiment, a connecting assembly is tightened onto pipes to be connected in a mechanical joint by the additional use of band clamp components.

**[0008]** United States Patent No. 5,141,161 describes a double containment pipe joint assembly with an inner pipe and an outer or containment pipe secured in concentric relation. The pipe joint assembly includes a fitting having end surfaces on concentric flanges which can be secured to a length of a primary and containment pipe at intervals along the pipeline wherein sections of the pipeline can be removed and repaired without the necessity of removing the whole pipeline. The concentric flanges are joined by a thickened divider ring which provides smooth fillets at its juncture with the flanges to reduce thermal stresses on the fitting.

**[0009]** United Kingdom Patent Application No. 2,493,545 describes a T-piece preformer' for forming a T-piece in a pipe-in-pipe pipeline for laying in a marine environment. The T-piece preformer comprises at least inner and outer longitudinal collars; one or more annular walls extending between the inner and outer collars; one or more cable apertures through each annular wall; and one or more guide points on the outer collar radially offset from the or each cable apertures, able to provide guidance for a hole into the T-piece preformer from outside the outer collar to within the inner collar.

**[0010]** Accordingly, it is an object of the present invention to provide an improved method of installing a banded pipe system for conveying hazardous fluids *in situ*. Alternatively, or in addition thereto, it is an object of the invention to provide a banded pipe system capable of *in situ* installation and adapted for interstitial monitoring for leak detection.

**SUMMARY OF THE INVENTION**

**[0011]** From a first aspect, the invention resides in a method of installing a banded pipe system for transfer of hazardous fluids, the method comprising:

providing one or more fittings for terminating or splitting pipes in a banded steel pipe run, each said fitting comprising an inner tubular steel member for joining to an end of the inner steel pipe of a banded pipe and an outer tubular steel member at least partially surrounding the inner tubular member and spaced therefrom for joining to the outer steel pipe of the banded pipe, each end of the inner tubular steel member of the fitting extending beyond the corresponding end of the outer tubular steel member;

joining the inner tubular steel member to the inner tubular pipe of a banded pipe; and joining the outer tubular steel member to the outer pipe of the banded pipe;

wherein the inner and outer tubular steel members are joined respectively to the inner and outer banded pipes *in situ* in a cold process by inserting an end portion of each pipe into an end portion of each tubular steel member, or vice versa, to provide a male-female coupling and applying pressure at a plurality of points around the female coupling where it overlaps with the male coupling to compress the female coupling against the male coupling to form a crimped seal therebetween.

**[0012]** By means of the invention, it is possible to install pipe runs of a banded pipe system *in situ* without application of heat, specifically by crimping. Thus the method avoids the hazards associated with hot processes, such as welding. Further, the resulting crimped seal is a nonmechanical joint, requiring no additional components, such as adhesives or band clamps. The method therefore also allows the jointing to be achieved in one fluid motion without the need for mechanical assembly or tightening of components. In this way, this process can be carried out on site in a rapid, efficient and, importantly, safe manner.

**[0013]** The term "installing" as used herein is intended to include modification and repair of existing banded pipe systems, as well creating installing new banded pipe systems from scratch at a new facility, such as a fuel storage facility. Evidently, the method of the invention is especially advantageous when utilised to alter or repair an existing facility where hazardous fluids may already be present in the system.

**[0014]** The term "cold process" as used herein refers to a process in which heat is not applied, thus it is a process that is performed under ambient temperature.

**[0015]** In the method of the invention, the application of pressure around the female coupling may conveniently be provided by means of a compression tool, for example, a hand held crimping tool. Such crimping tools are known and may be powered by hydraulic or pneumatic

means. In a preferred method, the pressure may be applied via a collar placed around the female coupling. Upon exerting pressure around the female coupling, the female coupling is deformed and compressed onto the underlying male coupling, resulting in a crimped seal.

**[0016]** From another aspect, the invention resides in a pipe connector for joining *in situ* to a banded pipe run of a banded pipe system for transfer of hazardous fluids, the fitting comprising an inner multi-way steel pipe connector comprising a plurality of ends for joining to a plurality of inner pipes by crimping to combine or split a fluid flow through said pipes and an outer multi-way steel pipe connector of the same configuration as the inner connector and integrally banded therewith and comprising a plurality of ends for joining to a plurality of outer pipes by crimping, the dimensions of the outer connector being greater than the dimensions of the inner connector to provide an interstitial gap between the inner and outer connectors and between the inner and outer pipes when fitted to the respective connectors for enabling pressure monitoring between the inner and outer pipes when the gap between the inner and outer pipes forms part of a closed system. One or more O-rings are carried within one or more of the ends for joining by crimping, and one or more of the ends for joining by crimping are flared for ease of insertion of the pipe to be joined.

**[0017]** In a preferred arrangement, the pipe connector fitting may be a T-shaped fitting or a Y-shaped fitting, more preferably a T-shaped fitting.

**[0018]** The inner connector may be manufactured with the desired connector arm length, or may be produced by attaching a requisite length of pipe to an off-the-shelf steel connector. As the inner connector is likely to be fabricated off-site, the additional length of pipe fitted to provide a desired crimping portion may be joined to the basic connector by compression jointing, crimping or welding.

**[0019]** In order that the interstitial gap between the inner and outer connectors remains constant, thereby avoiding pressure fluctuations caused by relative movement between the connectors which may inadvertently trigger a leak alarm system, the banded fitting preferably further comprises a spacer member for fixing the position of the inner connector with respect to the outer connector.

**[0020]** Preferably, the spacer member has an outer diameter the same as or substantially similar to the inner wall diameter of the outer connector arm where it is to be fitted, and an inner diameter the same as or substantially similar to the outer wall diameter of the inner connector arm at the same fitting position. In particular, it is preferred that the spacer members are precision cut, such as by laser means, to provide inner and outer diameters of an exact size to grip both the inner and outer connectors for retaining the inner and outer connectors at the desired spacing. It will be appreciated that the each of the connector arms of the inner and outer connectors respectively may not share the same diameter, for example, multi-way pipe connectors are frequently used to connect pipes of different diameters. A range of spacers may be provided to cater for the different pipe diameters and the resulting gap. The spacers are preferably shaped to enable air or other pressurising gas, and leaking fluid to flow through

the interstitial gap. For example, the spacers may comprise annular members provided with apertures therethrough, or one or both of the inner or outer circumferences may be castellated.

**[0021]** Spacers may also be used in conjunction with the banded steel pipes to fix the position of the inner pipe within the outer pipe, this also being advantageous to avoid pressure fluctuations caused by relative movement between the inner and outer pipes.

**[0022]** Also described herein is a process of making a banded multi-way connector for use in the installation method, the process comprising providing a first multi-way steel pipe connector for joining to a plurality of inner pipes to combine or split a fluid flow through said pipes and a second multi-way steel connector having the same configuration as but dimensions greater than the first connector, wherein the second connector is cut along the intersection where each connector arm of the second connector meets an adjoining arm, separating the resulting cut pieces to permit the arms of the first connector to be inserted into the separated arms of the second member, bringing the cut pieces together so that they are in contact with each other along the intersections and welding the re-assembled second connector along the intersections to capture the arms of the first connector within the arms of the second connector.

**[0023]** When the banded multi-way connector provides a T-fitting or a Y-fitting, the second steel connector is cut into three sections. In the case of a T-shaped connector, the second connector is cut twice, the first cut severs the arm that is at 90° to the remaining two arms, and the remaining two arms are severed by cutting normal to the first cut. Cutting in this order is preferred as it is easier to hold the T-fitting in a vice whilst both cuts are made. Cutting in the reverse order is however possible.

**[0024]** In a preferred arrangement, the connector arms of the first connector are extended, such as by joining pipe lengths to the distal end of the connector arms, such that once the extended arms are inserted into the separated arms of the second connector and the separated arms are rejoined, the extended arms project beyond the distal ends of the arms of the second connector. Joining the pipe lengths to the first connector to extend the arm lengths may be performed by compression jointing, crimping or welding, or by any other suitable method.

**[0025]** When spacers are used to fix the interstitial gap between the first and second connectors, these may be fitted over the outer diameters of the first connector arms prior to inserting the arms into the separated arms of the second connector.

**[0026]** Following manufacture, the multi-way banded steel connector may be tested to ensure compliance with requisite standards. Such testing preferably includes one or all of (i) a visual inspection to check for any defects in the manufacturing process, (ii) a pressure test, typically carried out at a vacuum of 20mB, to ensure the connector's integrity, and (iii) an ultrasonic thickness test to ensure that the welds in the outer connector are consistent and substantially

even across the full length of the weld. When the connectors are deemed to meet the standards, a 10-year warranty may be issued.

**[0027]** From yet another aspect, the invention resides in a pipe finisher fitting for use in the method according to the first aspect, the pipe finisher fitting comprising an inner steel tube having a first end for joining to an inner steel pipe of the banded system by crimping, to convey fluid from a fluid store through the tube and a second end for joining to a steel delivery pipe by crimping to convey the fluid from the tube to a delivery destination, the pipe finisher further comprising an outer steel reducing tube having a first end for joining to an outer steel pipe of the banded system by crimping and a second end of reduced diameter relative to the first end and sealed around the inner steel tube for closing the banded system where the fitting is installed to enable pressure monitoring of the interstitial gap between the inner and outer pipes. One or more O-rings are carried within one or more of the ends for joining by crimping; and one or more of the ends for joining by crimping are flared for ease of insertion of the pipe to be joined.

**[0028]** By means of this further aspect of the invention, it is possible to terminate banded steel pipe runs to create a sealed, banded system. Such a pipe finisher is connected to the end of a pipe run by crimping. Thus even though a pipe finisher may need to be installed at an end of a pipe run, including adjacent to a fuel storage tank or a tank containing other hazardous fluids, the connection can be made safely using a cold process.

**[0029]** In a preferred arrangement, the first end of the inner steel tube of the pipe finisher extends beyond the first end of the outer reducing tube to facilitate joining of the finisher using a crimping process. In particular, the projecting first end of the inner tube is readily accessible for crimping to the inner pipe in a banded pipe run.

**[0030]** Consistent with the multi-way connector as hereinbefore described, the interstitial gap present between the inner and outer steel tubes may be fixed by means of one or more spacer members. Accordingly, the spacer members referred to hereinbefore may be included as part of the pipe finisher.

**[0031]** The outer reducing tube of the pipe finisher fitting may comprise a section of a conventional reducing fitting used to take a larger pipe down to a smaller bore pipe. Such a conventional fitting comprises a wider bore section and a narrower bore section with a section of tapering cross-section in between. Accordingly, the outer reducing tube may comprise the wider bore section and the tapering section, the narrower bore section having been severed therefrom, with the end of the tapering section being welded to the inner tube.

**[0032]** Advantageously, the second end of the inner steel tube of the pipe finisher also projects beyond the second, reduced diameter end of the reducing tube. Again, by means of the extended portion, joining of the finisher to a further pipe run, for example, to convey fluid to a delivery point outside of the banded system is facilitated.

**[0033]** Pipe finisher fittings according to the invention may be installed at both ends of a banded pipe run thereby providing a closed system in which the interstitial gap can be pressurised. Such a closed system makes it possible to monitor pressure in the interstitial gap and hence detect possible leaks in the system when the pressure changes.

**[0034]** In another embodiment, the outer reducing tube of the pipe finisher comprises a sealable port for introducing a pressurising gas to enable detection of a leak in a banded pipe run when the finisher is in use in a banded system.

**[0035]** The sealable port may be created in the severed reducing fitting, for example, by cutting an aperture through the outer reducing tube, preferably along a tapering portion thereof, and welding a female threaded socket into the aperture. The socket then provides a sealable entry point for allowing gas to be pumped into the interstitial gap when the pipe finisher is in use in a banded system. More particularly, the gas can be pressurised and the pressure maintained by sealing the port. Such a pipe finisher is typically manufactured off-site but fitted *in situ* by crimping.

**[0036]** When in use in a banded system, the system and/or method preferably includes installing a pressure monitor and linking the monitor to an alarm, whereby pressure within the interstitial gap may be monitored and a warning issued in the event that the monitor detects a change in pressure within the gap. The alarm may be activated when the pressure change exceeds a certain predetermined value, indicating that there is potentially a leak within the banded system.

**[0037]** It will be appreciated that within a banded system two pipe finishers may be included, one fitted at either end of a banded pipe run. It is not necessary for both finishers to carry a test port however.

**[0038]** Also described herein is a method of making a pipe finisher fitting for installation in a banded pipe system, comprising providing an inner steel tube having a first end for joining to an inner pipe of a banded pipe by crimping, and a second end, providing an outer steel reducing tube having a first end for joining to an outer steel pipe of the banded pipe by crimping, and a second end of reduced diameter, sealing the second end of the outer reducing tube around the inner steel tube adjacent the inner tube second end.

**[0039]** When the outer steel tube is derived from a conventional reducing fitting having a wider bore section and a narrower bore section with a section of tapering cross-section in between, the method of the invention preferably comprises severing the narrower bore section prior to sealing, such as by welding, the narrower end of the tapering around the inner steel tube.

**[0040]** Advantageously, the method further comprises providing a sealable aperture through the outer steel tube.

**[0041]** From yet another aspect, the invention resides in a kit of parts for installing a banded

steel pipe system comprising at least one steel pipe finisher fitting as hereinbefore described and at least one multi-way steel connector as hereinbefore described, and a crimping tool.

#### **BRIEF DESCRIPTION OF THE DRAWINGS**

**[0042]** Aspects of the present invention will now be described, by way of example only, with reference to the accompanying drawings in which:

Figures 1a and 1b show alternative end finishers, each with a test port and spacers, in accordance with an aspect of the invention;

Figure 2 shows an end finisher without a test port in accordance with another aspect of the invention;

Figure 3 shows a T-shaped pipe connector in accordance with another aspect of the invention;

Figure 4 illustrates the cutting of a T-shaped fitting for providing the outer multi-way connector of a pipe connector as shown in Figure 3;

Figure 5 illustrates the separated elements of the fitting of Figure 4;

Figure 6 illustrates the re-assembled elements of the fitting of Figure 4 when fitted over an extended inner T-shaped steel connector;

Figure 7 illustrates manufacture by cutting of an outer reducing steel tube for a pipe finisher as shown in Figure 2;

Figure 8 illustrates the separated outer reducing steel tube after cutting; and

Figure 9 illustrates an assembled steel pipe finisher using the separated reducing steel tube of Figure 8 and an inner steel tube.

#### **DETAILED DESCRIPTION**

**[0043]** The accompanying drawings describe three fittings for use in the present invention. These are an integrally bundled T-piece, an integrally bundled end fitting and an integrally bundled end fitting with a test port. The "end" fittings enable reduction down from pipe-in-pipe to a single pipe. On the end fitting with the test port, the test port is added to the finisher so that the interstitial gap can be pressurised thereby enabling the pipework to be pressure tested constantly (for leak detection purposes).

**[0044]** Figure 1a illustrates an embodiment of the invention showing an internal end finisher (10) comprising an inner steel tube or pipe (20) (e.g. a 28mm diameter pipe) having a first end

(21) for joining to an inner pipe of a banded pipe by crimping, and a second end (22), for joining to a non-banded pipe system, and also comprising an outer steel reducing tube (30) having a first end (31) for joining to an outer steel pipe of a banded pipe system by crimping, and a second end of reduced diameter (32), sealing the second end of the outer reducing tube around the inner steel tube adjacent the inner tube second end. The first end of the inner pipe (21) extends beyond the end of the first end (31) of the outer reducing pipe (30) to facilitate joining to the inner pipe of a banded pipe system by crimping.

**[0045]** This embodiment additionally comprises spacers (40, external for illustration) located internally between the inner (20) and outer (30) steel tubes to fix the position of the inner tube with respect to the outer tube. These spacers are profiled to enable air or other pressurising gas, and leaking fluid to flow through the interstitial gap.

**[0046]** Located on the end finisher (10), on the wider bore section, is a sealable test port (50) which allows the introduction of a pressurising gas to enable detection of a leak in a banded pipe run when the finisher is in use in a closed banded system. This port (50) may be connected to a pressure monitor (not shown) to detect change of pressure in the interstitial space of a banded pipe system, and activate an alarm when the change in pressure exceeds a predetermined value. Suitably, this port may be a ¼" BSP ("British Standard Pipe") threaded female socket.

**[0047]** Figure 1b illustrates an alternative end finisher (11) of the invention consisting of an inner pipe (e.g. a 54mm diameter pipe) with test port (50) located on the tapering section of the reducing tube (30). Features analogous to those shown in Figure 1a are denoted by use of the same reference signs.

**[0048]** Figure 2 illustrates a further alternative end finisher (12) of the invention, with features analogous to those shown in Figures 1a and 1b. However, in this embodiment a pressurising port is not included.

**[0049]** Another embodiment of the invention is shown in Figure 3 which illustrates an internal T-piece multi-way connector (60) for connecting pipes in a banded system, comprising a first inner T-shaped multi-way steel pipe connector (70, internal, see also Figure 6) for joining to a plurality of inner pipes of a banded system by crimping, to combine or split a fluid flow through said pipes, and a second multi-way steel connector (80) having the same configuration as but dimensions greater than the first connector, for joining to the outer pipes of a banded system by crimping. These inner and outer connectors are separated by spacers (40) to maintain the size of the interstitial space between the inner and outer connectors.

**[0050]** The ends of the inner connector (70) are extended (71), such as by joining pipe lengths to the distal end of the connector arms (see also Figure 6), such that the extended arms project beyond the distal ends of the arms of the second (outer) connector.

**[0051]** This and other embodiments include adaptations of the ends of the pipes of the

connectors shown to facilitate joining of these pipes to pipes of a banded system by crimping. For example, the ends can be flared (90) in order to make easier insertion of the pipe to be joined, and/or an O-ring (91) can be carried within the connecting end to improve the seal made on compression of the joint during crimping. The O-ring may be made of any suitable elastomeric material.

**[0052]** Figures 4, 5 and 6 schematically illustrate the process of manufacturing the T-Piece fitting shown in Figure 3. The outer T-piece (100) is cut twice to offer three pieces (81, 82, 83) and separated (see Figure 5). The first cut (101) severs the arm which is at 90° to the others, and the second cut (102) separates the remaining arms.

**[0053]** Lengths of pipe (71), to extend the inner pipe to offer sufficient pipe to crimp onto when used in the method of the invention, are then jointed to the inner T piece by compression jointing, crimping or welding, or by any other suitable method. The inner T-piece is inserted into the outer T-piece and the outer T-piece is then re-assembled over the inner T and joined back together with a welding joint (103).

**[0054]** Figures 7, 8 and 9 show the process of manufacturing the finisher. The integrally banded finisher is manufactured using a reducing fitting (110) available on the open market (to take a larger bore pipe down to a smaller bore pipe). The reducing fitting (110) is cut once (104) to offer two pieces (111, 112) which are separated (Figures 6 and 7). The larger pipe section (112) thus has an end with a larger bore and an end with a smaller bore. This pipe section (112) is placed over a length of straight pipe (120). The larger outer pipe section (112) is then welded (103) onto the straight pipe length to offer a fitting with features analogous to those in Figures 1a, 1b and 2, as shown (Figure 9).

**[0055]** Once the finisher has been made a threaded entry or flange may be compression fitted onto the inner pipe to terminate (Figure 9).

**[0056]** To manufacture a finisher with a test port as shown in Figures 1a and 1b, the finisher is cut, welded and re-assembled as per the standard finisher detailed above. In order to add the test port to this finisher a threaded female socket (e.g. ¼" BSP ("British Standard Pipe")) is cut and welded onto the outer pipe. The socket goes fully through the outer pipe and a seal is created. This then provides a sealed entry to allow gas to be introduced between the inner and outer pipes (the interstitial gap). This gas is then pressurised throughout the length of the pipe run. An alarm system is added to the line and the gas pressure is monitored. If the monitoring system detects a drop in line pressure then the alarm is triggered to indicate a potential leak on the line.

**[0057]** Although variations to the system and fittings have been described above, other modifications may be made without departing from the inventive concept, as defined by the claims.

## **REFERENCES CITED IN THE DESCRIPTION**

This list of references cited by the applicant is for the reader's convenience only. It does not form part of the European patent document. Even though great care has been taken in compiling the references, errors or omissions cannot be excluded and the EPO disclaims all liability in this regard.

**Patent documents cited in the description**

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- US5141161A [0008]
- GB2493545A [0009]

## PATENTKRAV

1. Fremgangsmåde til installering af et dobbeltvægget rørsystem til overførsel af farlige fluider, hvilken fremgangsmåde omfatter:

5 tilvejebringelse af én eller flere fittings (10, 11, 12, 60) til afslutning eller opdeling af rør i et dobbeltvægget stålrørsforløb, hvor hver fitting omfatter et indvendigt rørstålelement til samling med en ende af det indvendige stålrør af et dobbeltvægget rør, og hvor et udvendigt rørstålelement mindst delvist omgiver det indvendige rørelement og er adskilt derfra for samling med det udvendige stålrør af det dobbeltvæggede rør, hvor hver ende af fittingens (21, 71) indvendige rørstålelement strækker sig ud over den tilsvarende ende af det udvendige rørstålelement;

10 samling af det indvendige rørstålelement med det indvendige rørformede rør af et dobbeltvægget rør; og

samling af det udvendige rørstålelement med det udvendige rør af det dobbeltvæggede rør;

15 kendetegnet ved, at de indvendige og udvendige rørstålelementer henholdsvis samles med de indvendige og udvendige dobbeltvæggede rør *in situ* i en kold proces ved indføring af en endedel af hvert rør i en endedel af hvert rørstålelement, eller omvendt, for at tilvejebringe en han-hund-sammenkobling og påføring af tryk på en flerhed af punkter omkring hun-sammenkoblingen, hvor den overlapper han-sammenkoblingen for at komprimere hun-sammenkoblingen mod han-sammenkoblingen for at danne en krympet tætning derimellem.

2. Fremgangsmåde ifølge krav 1, der endvidere omfatter tilvejebringelse af ét eller flere afstandselementer (40) installeret mellem det indvendige og udvendige rørstålelement for at fikser positionen af det indvendige element i forhold til det udvendige element.

25 3. Fremgangsmåde ifølge krav 1 eller krav 2, hvor den tilvejebragte fitting omfatter en rørafslutning (10, 11, 12) til lukning af den mellemliggende spalte af dobbeltvægget system i anvendelse for at gøre det muligt at sætte spalten under tryk.

4. Fremgangsmåde ifølge krav 3, der endvidere omfatter at forsyne det udvendige rørstålelement af rørafslutningen med en åbning (50), der kan tætnes, for indføring af gas under tryk i den mellemliggende spalte.

30 5. Fremgangsmåde ifølge et hvilket som helst foregående krav, hvor den tilvejebragte fitting omfatter en flervejsforbinder, såsom en T-formet forbinder (60), til samling med en flerhed af indvendige rør for at kombinere eller opdele en fluidstrøm.

6. Fremgangsmåde ifølge et hvilket som helst foregående krav, der endvidere omfatter tilvejebringelse af trykmonitoreringsmiddel til monitorering af tryk i den

mellemliggende spalte af det dobbeltvæggede system, når fittingerne er samlet med det dobbeltvæggede rørs og systemet er lukket, og forbindelse af trykmonitoreringsmidlet med det dobbeltvæggede rørsystem.

7. Fremgangsmåde ifølge krav 6, hvor trykmonitoreringsmidlet er forbundet med et alarmsystem, der udløses af en ændring i det monitorerede tryk, hvilket alarmsystem er placeret stødende op til og/eller væk fra det dobbeltvæggede rørsystem.

8. Rørtilslutningsfitting (60) til samling *in situ* med et dobbeltvægget rørforløb af et dobbeltvægget rørsystem til overførsel af farlige fluider, hvilken fitting omfatter:

en indvendig flervejsstålrørsforbinder (70), der omfatter en flerhed af ender til samling med en flerhed af indvendige rør ved krympning for at kombinere eller opdele en fluidstrøm gennem rørene og

en udvendig flervejsstålrørsforbinder (80) af den samme konfiguration som den indvendige forbinder og integralt dobbeltsidet dermed, der omfatter en flerhed af ender til samling med en flerhed af udvendige rør ved krympning,

hvor dimensionerne på den udvendige forbinder (80) er større end dimensionerne på den indvendige forbinder (70) for at tilvejebringe en mellemliggende spalte mellem de indvendige og udvendige tilslutninger og mellem de indvendige og udvendige rør, når den er monteret på de tilsvarende forbindere for at muliggøre trykmonitorering mellem de indvendige og udvendige rør, når spalten mellem de indvendige og udvendige rør udgør en del af et lukket system;

kendetegnet ved, at:

én eller flere O-ringe (91) er båret inde i én eller flere af enderne til samling ved krympning; og

én eller flere af enderne til samling ved krympning svajer udefter for lettere indføring af røret, der skal samles.

9. Rørafslutningsfitting (10, 11, 12) til samling *in situ* med et dobbeltvægget rørforløb af et dobbeltvægget rørsystem til overførsel af farlige fluider, hvilken fitting omfatter:

et indvendigt stålrør (20) med en første ende (21) til samling med et indvendigt stålrør af det dobbeltvæggede system ved krympning for at lede fluid fra et fluidlager gennem røret og en anden ende (22) til samling ved krympning med et stålleveringsrør for at lede fluidet fra røret til en leveringsdestination, og et udvendigt stålreduktionsrør (30) med en første ende (31) til samling ved krympning med et andet stålrør af det dobbeltvæggede system og en anden ende (32) af reduceret diameter i forhold til den første ende og tætnet omkring det indvendige stålrør for lukning af det dobbeltvæggede system, hvor fittingen er installeret for at muliggøre

trykmonitorering af den mellemliggende spalte mellem de indvendige og udvendige rør;

kendetegnet ved, at

én eller flere O-ringe (91) er båret inde i én eller flere af enderne til samling ved krympning; og

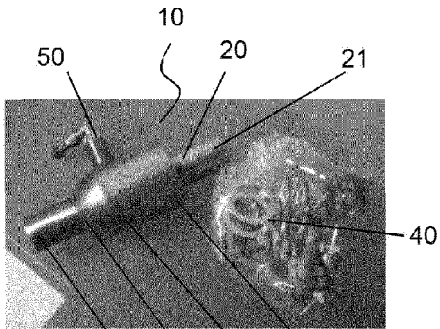
5           én eller flere af enderne til samling ved krympning (90) svajer udefter for lettere indføring af røret, der skal samles.

10.   Rørafslutningsfitting (10, 11, 12) ifølge krav 9, der endvidere omfatter en åbning (50), der kan tættes, til indføring af en gas under tryk i den mellemliggende spalte.

10   11.   Rørtilslutningsfitting (60) ifølge krav 8, eller en rørafslutningsfitting (10, 11, 12) ifølge krav 9, der endvidere omfatter et afstandsselement (40) installeret mellem det indvendige og udvendige rørstålelement for at fiksere positionen af det indvendige element i forhold til det udvendige element.

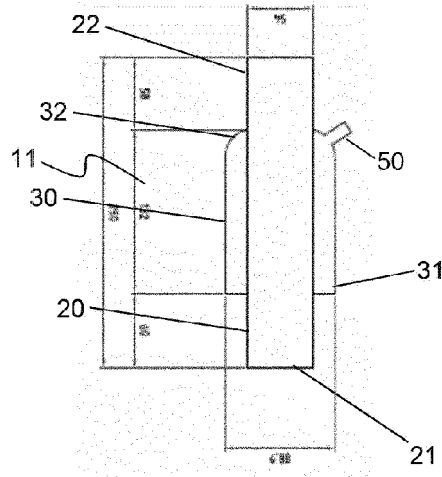
15   12.   Kit af dele til installation af et dobbeltvægget rørsystem i en facilitet til overførsel af farlige fluider, hvilket kit omfatter én eller flere af en rørtilslutningsfitting (60) ifølge krav 8 og en rørafslutningsfitting (10, 11, 12) ifølge krav 9 eller krav 10 og et krympningsredskab.

**DRAWINGS**

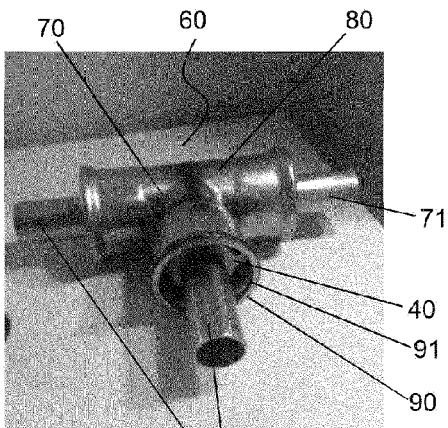


**Figure 1a**

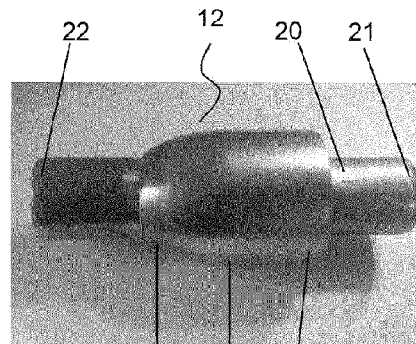
22 32



**Figure 1b**



**Figure 3**



**Figure 2**

32 30 31

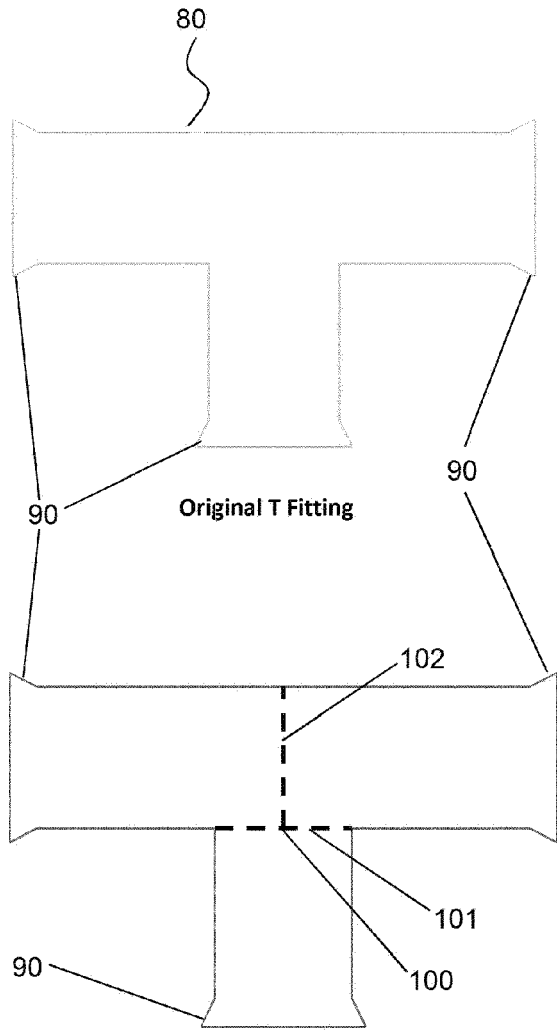


Figure 4

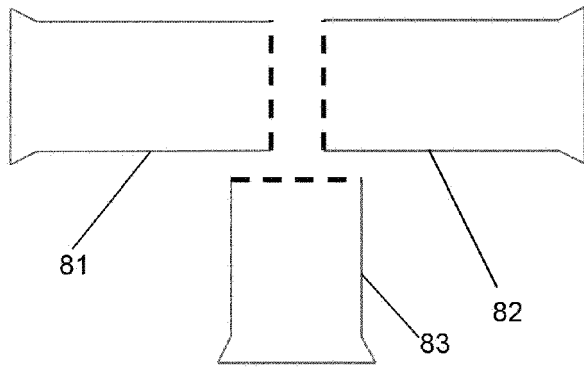


Figure 5

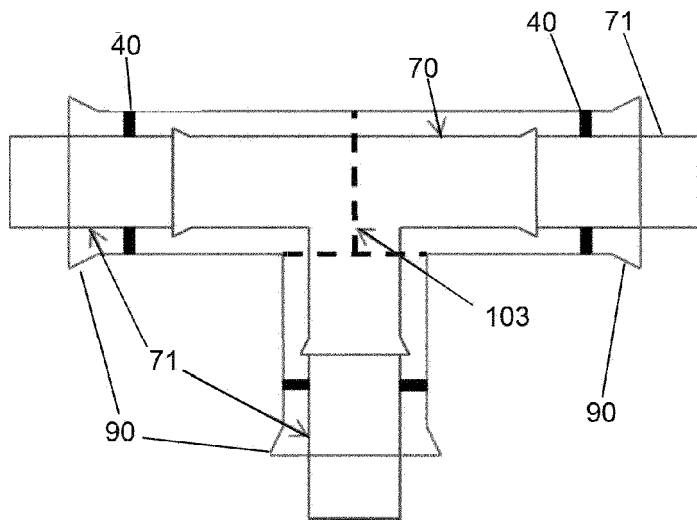


Figure 6

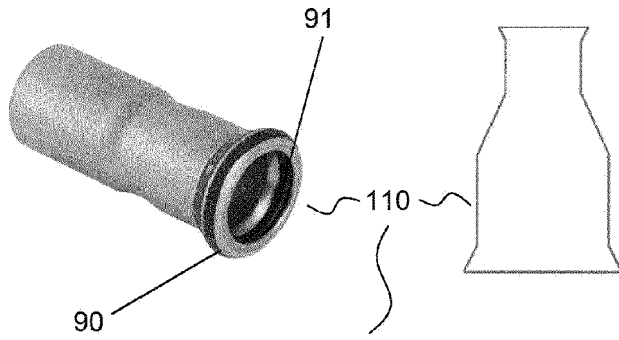


Figure 7

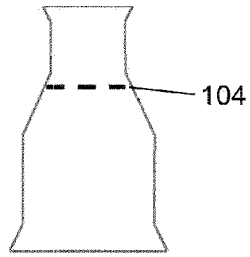


Figure 8

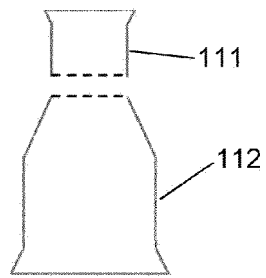


Figure 9

