

(No Model.)

J. C. BAYLES.
STRAKE WELD PIPE.

No. 470,738.

Patented Mar. 15, 1892.

Fig. 1.

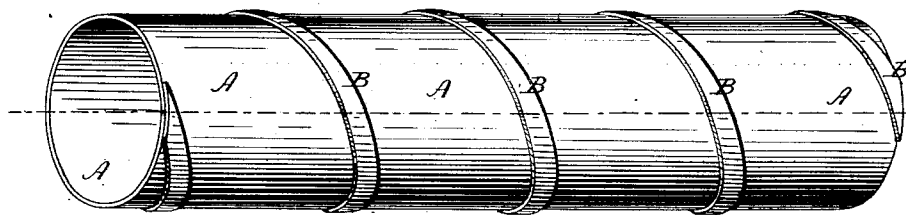


Fig. 2.

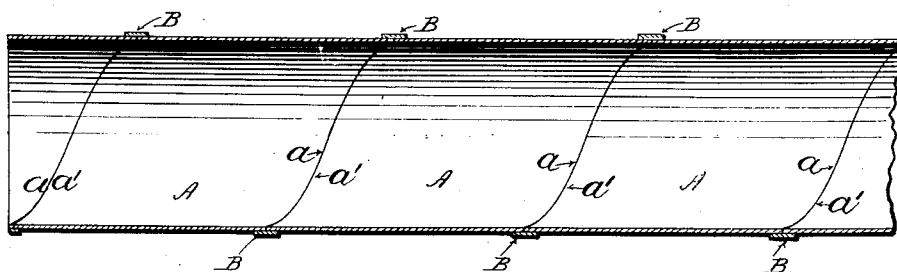
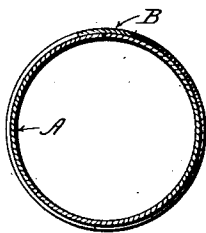


Fig. 3.



Witnesses:
J. E. Burns.
A. M. Jones.

Inventor:
James C. Bayles.
Per Edw. E. Quincy
Atty.

UNITED STATES PATENT OFFICE.

JAMES C. BAYLES, OF EAST ORANGE, NEW JERSEY.

STRAKE-WELD PIPE.

SPECIFICATION forming part of Letters Patent No. 470,738, dated March 15, 1892.

Application filed February 25, 1891. Serial No. 382,804. (No model.)

To all whom it may concern:

Be it known that I, JAMES C. BAYLES, of East Orange, New Jersey, have invented a certain Improvement in Strake-Weld Pipes, of which the following is a specification.

This invention consists of a spirally-wound strip of weldable sheet metal having the contiguous edges of its successive convolutions secured to each other by the welding thereto of an overlapping spiral strake of weldable metal. There is thus produced a spirally-welded pipe the interior of which is substantially smooth by reason of the absence therefrom of the inwardly-projecting spiral shoulder which is present when the meeting edges of the successive convolutions of a spirally-wound strip are overlapped and welded directly to each other.

The accompanying drawings of a section of spirally-welded pipe containing the improvement are as follows:

Figure 1 is an isometrical perspective. Fig. 2 is a transverse section. Fig. 3 is a longitudinal section.

The drawings represent a spirally-welded pipe, the greater portion of the shell of which is composed of a spirally-wound strip A, of sheet metal, having the meeting edges *a* and *a'* of its successive convolutions in contiguity but not necessarily in actual contact with each other. The successive convolutions of the strip A are secured to each other by having the portions of the metal adjoining their meeting edges welded to a spirally-superimposed metallic strake B. The pipe is thus made by uniting two originally-separate strips of sheet metal, a relatively wide strip, and a

relatively narrow strip or strake. The spiral joint or seam is composed of three members—to wit, the overlapping strip B and the metal adjoining the meeting or contiguous edges *a* and *a'* of the successive convolutions of the spirally-wound strip A. In producing this pipe the members of the seam will usually be separately heated and brought into suitable juxtaposition and welded by a machine substantially the same as that heretofore used in manufacturing spiral-weld pipe from a single strip of sheet metal wound spirally, with the meeting portions of its successive convolutions overlapped and welded directly to each other.

What is claimed as the invention is—

1. A spirally-welded pipe composed of a spirally-wound relatively wide strip of sheet metal, with a relatively narrow spiral strip or strake of sheet metal superimposed upon and welded to the metal adjoining the contiguous edges of the successive convolutions of said relatively wide strip.

2. The herein-described strake-weld sheet-metal pipe, the welded seam of which is composed of three members, two of which members consist, respectively, of the portions of metal adjoining the contiguous edges of the successive convolutions of a spirally-wound relatively wide strip of sheet metal and the third of a spirally-superimposed relatively narrow strip or strake of sheet metal.

JAMES C. BAYLES.

Witnesses:

ALEXANDER DEVINE,
J. E. BURNS.