

# *Stenca*



## **INSULATION PROCEDURE SPECIFICATION**

**FOR**

**PIPE INSULATION**

**CLASS 1, 2, 4, 6, 7, 8 AND 9**

COLD HEAT FIRE  
INSULATION  
ACOUSTICS PROJECTING  
ACCOMMODATION  
ADVISING

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COLD HEAT FIRE  
INSULATION  
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ADVISING

**INSULATION PROCEDURE**

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### 1. Purpose

The purpose of this procedure is to ensure that all pipe insulation is carried out in accordance with the project's insulation specification xxx-xxx-xxxx-xxxx.

Any deviations from this document must be documented through a deviation enquiry.

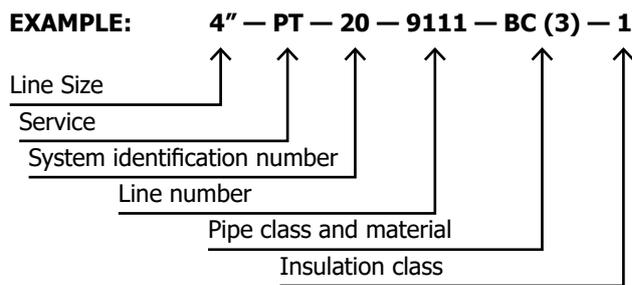
### 2. Scope

All pipe insulation of this project is subject to the requirements of this procedure.

### 3. In general

This chapter applies to the entire insulation procedure.

3.1 P&ID AND ISO MUST COMPLY WITH THE PROJECT SYSTEM Explanation of the most important codes of the P&ID's



### 3.2 GENERAL REQUIREMENTS FOR INSULATION

Pipes and fittings must be insulated in accordance with the insulation class, operating temperature and insulation thickness stated in P&ID and data sheet.

Stenca Pipe must be used for the insulation systems for thermal insulation and acoustical insulation.

#### VISUAL EXAMINATION

Insulation fitters are responsible for carrying out visual examination to ensure that surface protection and heating cable are installed as required before the insulation work is started. If this is not the case, insulation operators must report this to the foreman/supervisor.

All surface to be insulated must be clean, and any contaminants must be removed. Insulation should not be added until the mechanical certificate of completion for painting has been issued. Surfaces to be insulated must be treated in accordance with the Company Coating Specification, XXXXXX-XXXXX-XX

#### HEATING CABLES

Heating cables must be protected against sharp edges to avoid damage.

#### PERMANENT SEAL

A permanent seal must be added to prevent entry of water.

#### TERMINATIONS

Insulation at flanges, pipes and fittings must be terminated in a way that permits removal of bolts without damaging the insulation. The minimum available space from the flange to the closest part of the insulation must equal the bolt length + 25 mm. The termination must be watertight.

#### COVERING UP

Not completed insulation work must be covered up to prevent damage and entry of water to the insulation in order to keep it clean and dry.

#### DRAINAGE HOLE

Drainage hole  $\varnothing$  15 mm is drilled at the lowest point of the Stenca Pipe in accordance with the company's specifications.

#### WIDTH OF JOINTS

The width of joints between the Stenca Pipe elements varies depending on how well the Stenca Pipe elements are pressed together.

The recommended amount of Stenca Seal between the Stenca elements is a height of 3-4 mm and a width of 12-15 mm. Use soapy water to get a smooth surface on the joint.

If the amount of Stenca Seal exceeds the mentioned range, this is of no technical significance, the recommendations are given in consideration of later removal of insulation.

#### FLAT SURFACE BETWEEN THE STENCA ELEMENTS

When the Stenca Pipe is cut, the elements get a flat surface;

1. Minimum 5 mm of wavy stripe of Stenca Seal on one side
2. Press the Stenca elements thoroughly together
3. Use Stenca Strips to secure the installation
4. Place a stripe of at least 5 mm on the surface of the joint between the Stenca elements in order to achieve a waterproof and smooth surface

#### STENCA PIPE 4" - 12" CIRCULAR SHAPE

Stenca Pipe Straight in the sizes 4" - 12" can in some cases change their circular shape during drying/storage. The product has a visible longitudinal crack in the middle of the two sections constituting the Stenca Pipe.

The circular shape can be restored in the following way;

1. Place the Stenca Pipe properly on the pipe, and give it a knock
2. Press the Stenca elements thoroughly together
3. Continue according to the described procedure for gluing together the Stenca elements

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## 4.1 HEAT CONSERVATION MATERIAL

Material	Insulation class
Stenca Pipe	CL 1

CL 1 = Heat conservation insulation

### Definitions:

Stenca Pipe	40 mm Temperature range -50° C to +140° C
Stenca Pipe with spacer insulation	Stenca Spacers 40 mm Stenca Pipe Temperature range -50° C to +140° C
Stenca Pipe 180° C High temperature	Stenca Spacers 20 mm Stenca Mat 40 mm Stenca Pipe Temperature range +140° C to +180° C

## 4.2 CLASS 1: HEAT CONSERVATION $\leq 140^{\circ}\text{C}$

Drill a drainage hole of  $\varnothing 15\text{ mm}$  in the insulation in accordance with the company's specifications.

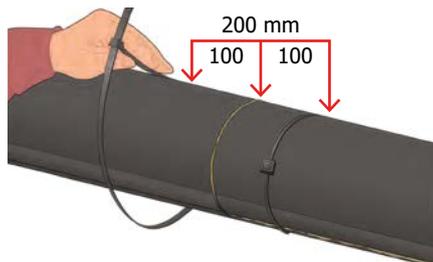
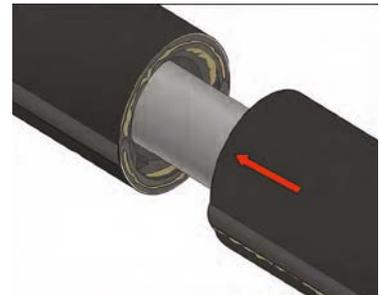
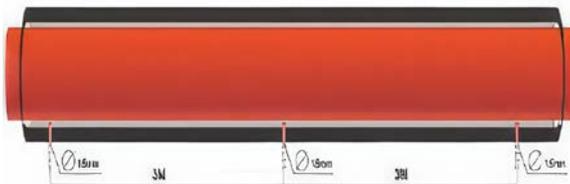
Apply Stenca Seal to the horizontal and vertical tongue and groove surfaces. Do the same with the next section of Stenca Pipe.

Mount Stenca Pipe on the pipe, and press the Stenca elements thoroughly together, use Stenca Strips to secure the installation. The Stenca Strips should be mounted 100 mm from each end of the Stenca element.

Place a stripe of at least 5 mm seal on the surface of the joint between the Stenca elements in order to achieve a waterproof and smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



## 4.3 CLASS 1: HEAT CONSERVATION, HIGH TEMPERATURE 140° C - 180° C

Stenca Pipe Class 1, high temperature, delivered ready for installation.

Place the spacers center to center (c.t.c) max 300 mm on the pipe, in the middle and at the transition to the next Stenca Pipe.

Drill a drainage hole of Ø 15 mm in the insulation in accordance with the company's specifications.

Use Stenca Seal on the horizontal and vertical tongue and groove surfaces. Do the same with the next section of Stenca Pipe.

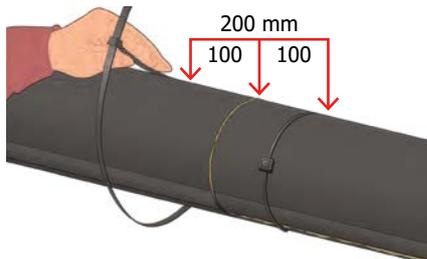
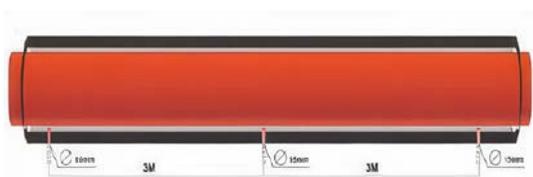
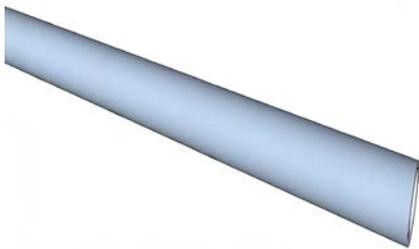
Mount Stenca Pipe on the steel pipe. Press the two parts firmly together, and use Stenca Strips to secure the installation.

The steel strip should be mounted 100 mm from each end of the Stenca element.

Place a stripe of at least 5 mm seal on the surface of the joint between the Stenca elements to create a waterproof and smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips
4. Stenca Spacers



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## 4.4 COLD MEDIUM CONSERVATION MATERIAL

Material	Insulation class
Stenca Pipe	CL 2

CL 2 = Cold medium conservation

**Definitions:**

Stenca Pipe                      40 mm  
Temperature range -50° C to +140° C

## 4.5 CLASS 2: COLD MEDIUM CONSERVATION, 40 MM STENCA PIPE

Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces. Do the same with the next section of Stenca Pipe.

Mount Stenca Pipe on the steel pipe. Press the two Stenca elements together, and use a steel strip to secure the installation.

Place Stenca Strips 100 mm from each end.

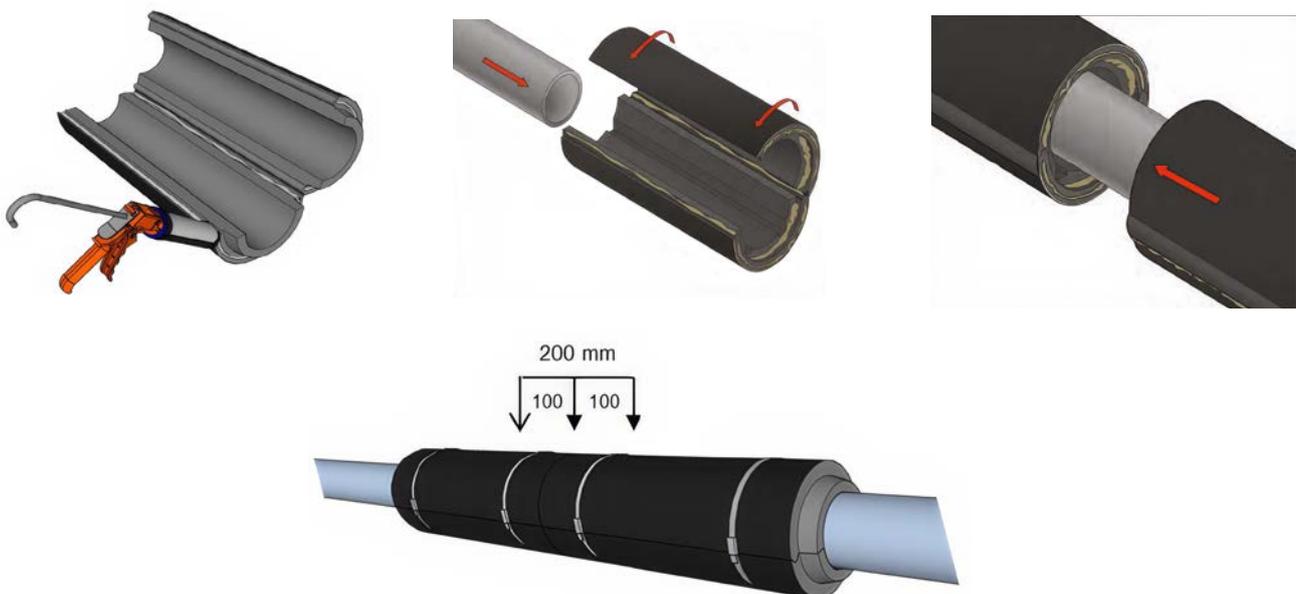
Use Stenca Seal to create a waterproof finish, create a smooth surface where Stenca Seal has been used.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips

DN	Operation temperature ° C			
	-50	-30	-10	0
20	40	40	40	40
25	40	40	40	40
32	40	40	40	40
50	40	40	40	40
65	40	40	40	40
80			40	40
100			40	40
150			40	40
200				40
250				40
300				40
350				40
400				40
450				40

Stenca Pipe thicknesses in mm



## 4.6 CLASS 2: COLD CONSERVATION, 80 MM STENCA PIPE

Use Stenca Seal on the horizontal and vertical tongue and groove surfaces. Do the same with the next section of Stenca Pipe.

Mount Stenca Pipe on the steel pipe. Press the two parts firmly together, and use reinforced fibreglass tape 100 mm from each end to secure the installation.

Offset the next layer of Stenca Pipe to place half the Stenca Pipe in the middle of the joint to the next Stenca Pipe. Press the two sections firmly together, and place the Stenca Strips 100 mm from each end.

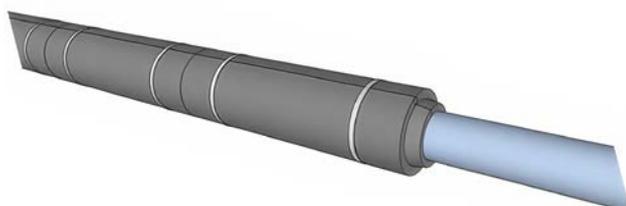
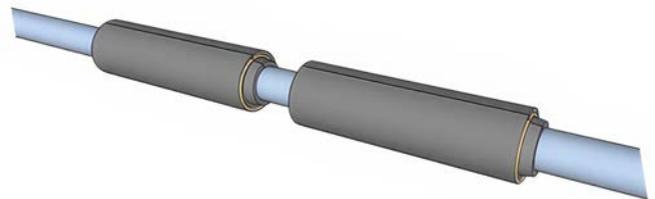
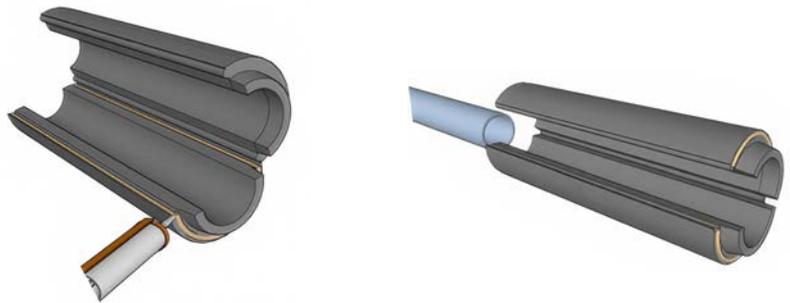
Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Reinforced fibreglass tape
4. Stenca Strips

DN	Operation temperature ° C		
	-50	-30	-10
80	80	80	
100	80	80	
150	80	80	
200	80	80	80
250	80	80	80
300	80	80	80
350	80	80	80
400	80	80	80
450	80	80	80
500	80	80	80
600	80	80	80

Stenca Pipe thicknesses in mm



## 4.7 FROST PROTECTION MATERIAL

Material	Insulation class
Stenca Pipe	CL 4

CL 4 = Frost conservation insulation

### Definitions:

Stenca Pipe	30 or 40 mm Temperature range -50° C to +140° C
Stenca Pipe with Stenca Spacers	Stenca Spacers 40 mm Stenca Pipe Temperature range -50° C to +140° C

### 4.8 CLASS 4: FROST PROTECTION

Drill a drainage hole of  $\varnothing$  15 mm in the insulation in accordance with the company's specifications.

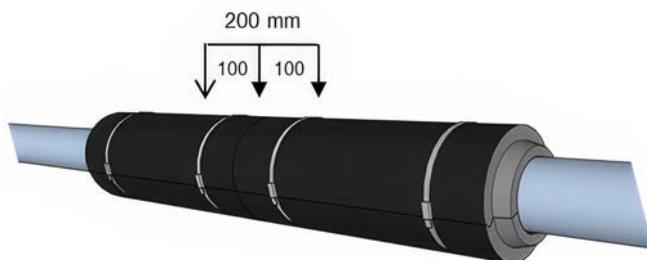
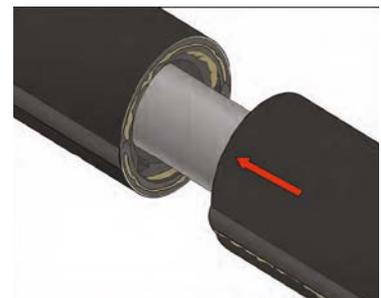
Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces. Do the same with the next section of Stenca Pipe. Mount Stenca Pipe on the pipe. Press the sections firmly together, and use Stenca Strips to secure the installation.

Mount Stenca Strips 100 mm from each end of the Stenca Pipe.

Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



## 4.9 CLASS 4: FROST PROTECTION WITH HEATING CABLE

Drill a drainage hole of  $\varnothing$  15 mm in the insulation in accordance with the supplier's specifications

Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces. Do the same with the next section of Stenca Pipe. Mount Stenca Pipe on the pipe. Press the sections firmly together, and use Stenca Strips to secure the installation.

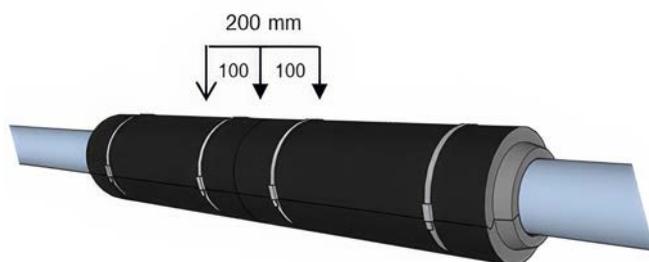
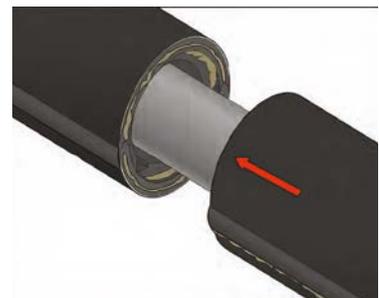
Mount Stenca Strips 100 mm from each end of the Stenca Pipe.

Ensure that Stenca Seal is used on all contact surfaces.  
Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips

Stenca Pipe is delivered with increased internal diameter, adapt the size of the heating cable.



## 4.10 CLASS 4: FROST PROTECTION WITH HEATING CABLE AND SPACERS

Drill a drainage hole of  $\varnothing$  15 mm in the insulation in accordance with the supplier's specifications

Place the Stenca Spacers center to center (c.t.c) max 300 mm on the pipe, in the middle and at the transition to the next Stenca Pipe.

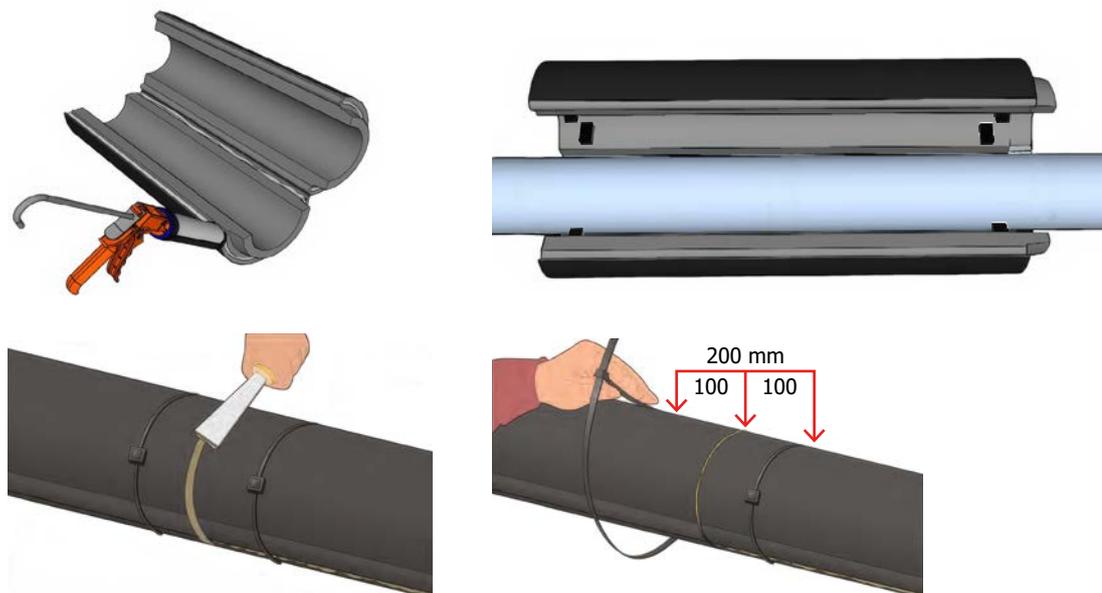
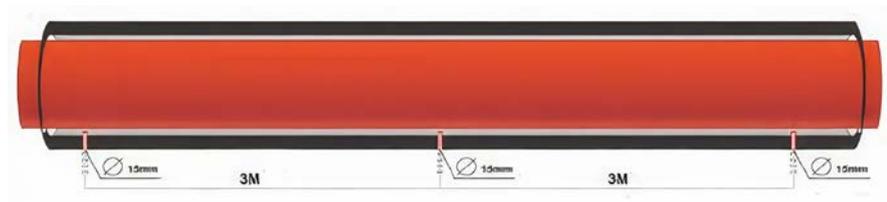
Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces. Do the same with the next section of Stenca Pipe. Mount Stenca Pipe on the pipe. Press the sections firmly together, and use Stenca Strips to secure the installation.

Mount Stenca Strips 100 mm from each end of the Stenca Pipe.

Ensure that Stenca Seal is used on all contact surfaces.  
Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Spacers
3. Stenca Seal
4. Stenca Strips



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## 4.11 ACOUSTICAL INSULATION CLASSES 6 AND 7

Material	Insulation class
Stenca Pipe	CL 6
Stenca Pipe	CL 7

CL 6 = Acoustical insulation (A)

CL 7 = Acoustical insulation (B)

### Definitions:

Stenca Pipe

40 mm

Temperature range -50° C to +140° C

Stenca Pipe Class 6/7 LoT

Low Temperature

Stenca Spacers – 3 mm Sound Barrier Mat – 40 mm Stenca Pipe

Temperature range -50° C to +100° C

Stenca Pipe Class 6/7 HiT

High Temperature

Stenca Spacers – 20 mm Stenca Mat – 40 mm Stenca Pipe

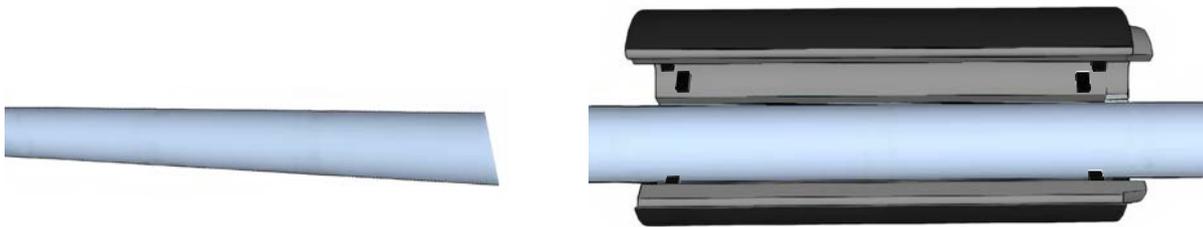
Temperature range -50° C to +180° C

## 4.12 CLASS 6 – 7: ACOUSTICAL INSULATION

Stenca Pipe classes 6 and 7 are delivered ready for installation, with acoustical structure inside the Stenca Pipe.

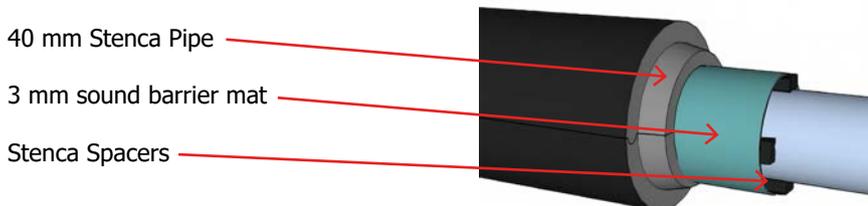
Note:

1. Insulation type: Stenca Pipe
2. Stenca Spacers
3. Sound Barrier Mat or Glass Needle Mat
4. Stenca Seal
5. Stenca Strips



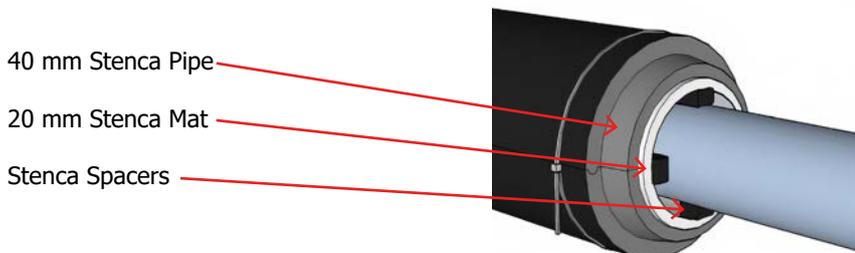
### NORSOK CLASS 6 - 7 · (A and B)

Temperature < 100° C



### NORSOK CLASS 6 - 7 · (A and B)

Temperature < 180° C



## 4.13 CLASS 6 – 7: ACOUSTICAL INSULATION

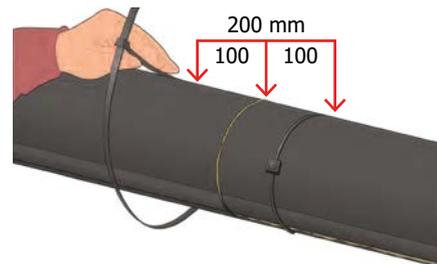
Drill a drainage hole of  $\varnothing$  15 mm in the insulation in accordance with the company's specifications.

Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces. Do the same with the next section of Stenca Pipe. Install Stenca Pipe on the spacers. Press the two Stenca elements together, and use Stenca Strips to secure the installation. Place the Stenca Strips 100 mm from each end.

Make sure that Stenca Seal is used on all contact surfaces to Stenca Pipe. Use Stenca Seal to create a waterproof finish, create a smooth surface where Stenca Seal has been used.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Spacers
3. Sound Barrier Mat or Glass Needle Mat
4. Stenca Seal
5. Stenca Strips



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### 4.14 ACOUSTICAL INSULATION CLASSES 8

Material	Insulation class
Stenca Pipe	CL 8

CL 8 = Acoustical insulation

**Definitions:**

Stenca Pipe Class 8 (C)

Stenca Spacers – 20 mm Stenca Mat – 3 mm Sound Barrier Mat  
– 40 mm Stenca Pipe  
Temperature range -50° C to +150° C

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### 4.15 CLASS 8: ACOUSTICAL INSULATION

Stenca Pipe class 8 is delivered ready for installation, with acoustical structure inside the Stenca Pipe.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Spacers
3. Glass Needle Mat
4. Sound Barrier Mat
5. Stenca Seal
6. Stenca Strips



#### NORSOK CLASS 8 · (C)

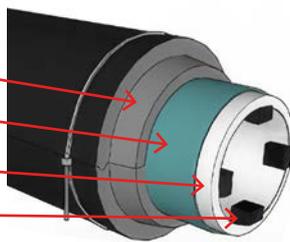
Class < 150° C

40 mm Stenca Pipe

3 mm Sound Barrier Mat

20 mm Stenca Mat

Stenca Spacer



## 4.16 CLASS 8: ACOUSTICAL INSULATION

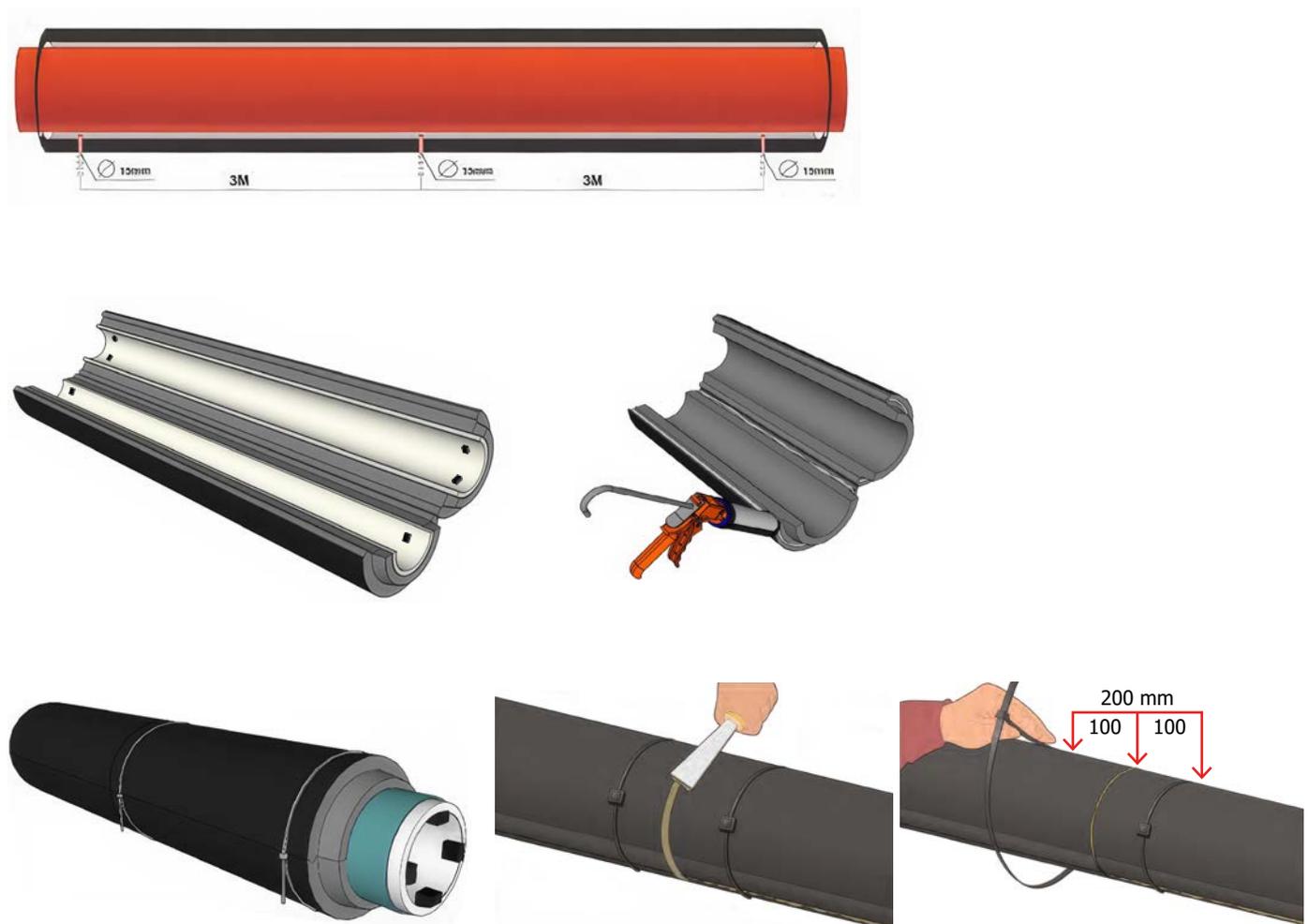
Drill a drainage hole of  $\varnothing$  15 mm in the insulation in accordance with the company's specifications.

Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces. Do the same with the next section of Stenca Pipe. Install Stenca Pipe on the spacers. Press the two Stenca elements together, and use Stenca Strips to secure the installation. Place the Stenca Strips 100 mm from each end.

Make sure that Stenca Seal is used on all contact surfaces to Stenca Pipe. Use Stenca Seal to create a waterproof finish, create a smooth surface where Stenca Seal has been used.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Spacers
3. Glass Needle Mat
4. Sound Barrier Mat
5. Stenca Seal
6. Stenca Strips



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## 4.17 EXTERNAL CONDENSATION AND ICING PROTECTION MATERIAL

Material	Insulation class
Stenca Pipe	CL 9

CL 9 = External condensation and icing protection

### Definitions:

Stenca Pipe                      40 mm  
Temperature range -50° C to +140° C

### 4.18 CLASS 9: EXTERNAL CONDENSATION AND ICING PROTECTION

Make sure that the installation is sealed tight!

Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces. Do the same with the next section of Stenca Pipe.

Mount Stenca Pipe on the steel pipe.

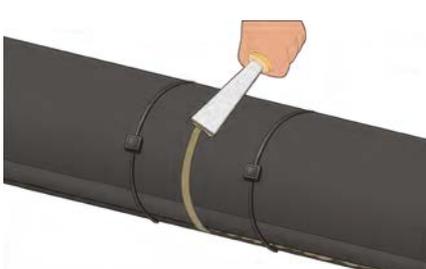
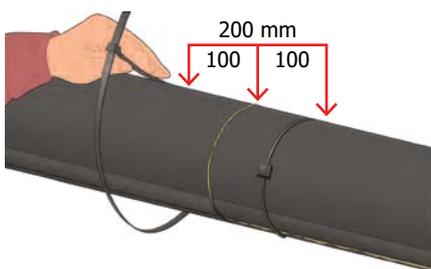
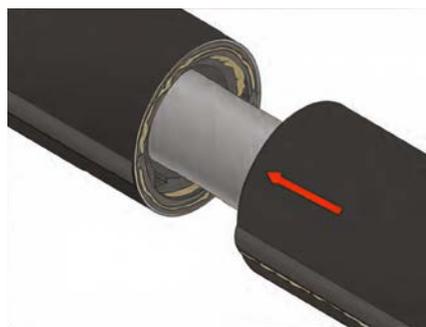
Press the Stenca elements firmly together, and use Stenca Strips to secure the installation.

Place the Stenca Strips 100 mm from each end.

Use Stenca Seal to create a waterproof finish, create a smooth surface where Stenca Seal has been used.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



### 5.1 END PIECE / TERMINATION AT FLANGE

Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces.

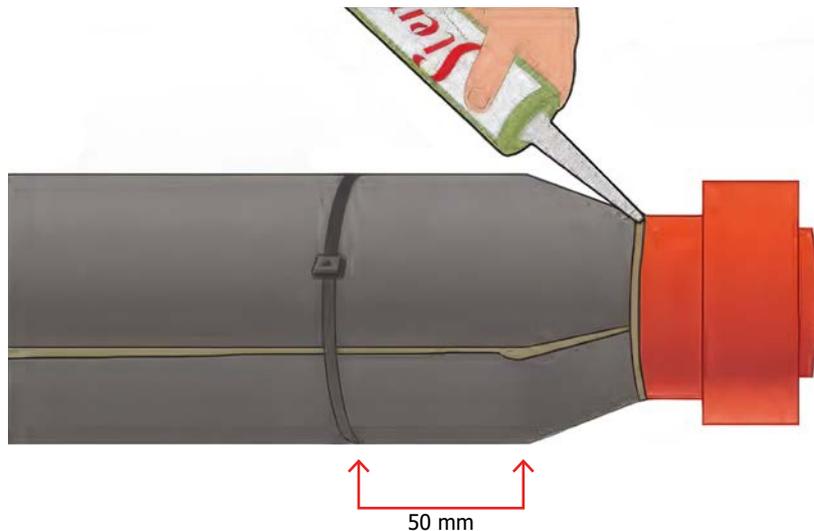
Do the same with the next section of Stenca Pipe.

Mount Stenca Pipe on the steel pipe. Press the two sections firmly together, and use Stenca Strips to secure the installation.

Place a Stenca Strip 50 mm before the end piece/termination at the flange. Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



## 5.2 DECREASE / CONCENTRIC DECREASE

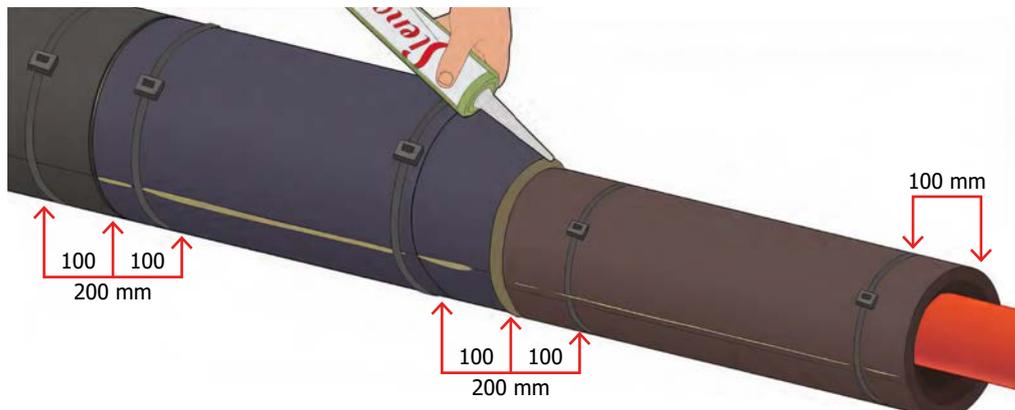
Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces.

Do the same with the next section of Stenca Pipe. Mount Stenca Pipe on the steel pipe. Press the two elements together, and use Stenca Strips to secure the installation. Place the Stenca Strips (4 pcs.) on the decrease element / concentric decrease, 100 mm from each end – see illustration.

Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



### 5.3 PIPE TEE

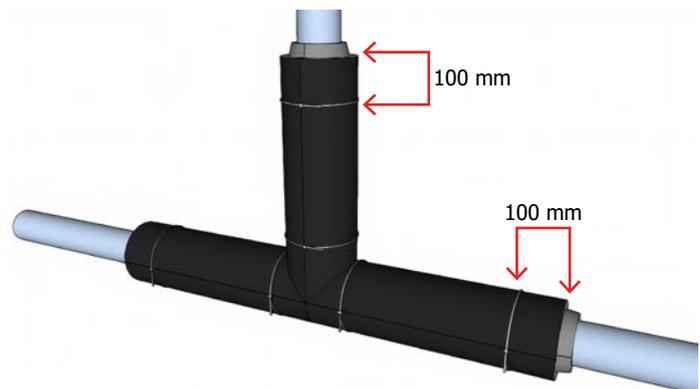
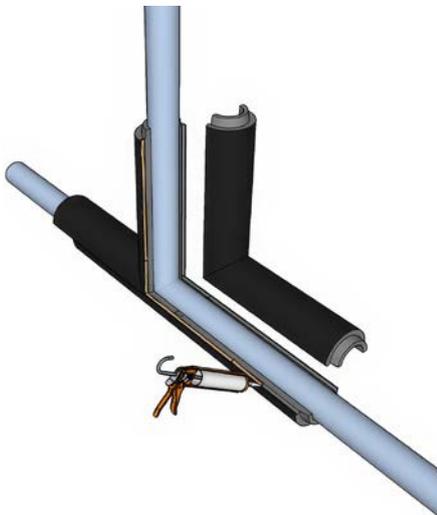
Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces. Install the pipe tee on the steel pipe.

Press the sections firmly together, and use Stenca Strips to secure the installation. Place the Stenca Strips (6 pcs.) 100 mm from the ends of the pipe tee, see illustration.

Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



### 5.4 45°/90° BEND

Use Stenca Seal on the horizontal and vertical tongue and groove. Do the same with the next section of Stenca Pipe.

Install Stenca Pipe bend on the steel pipe, and press the two sections firmly together.

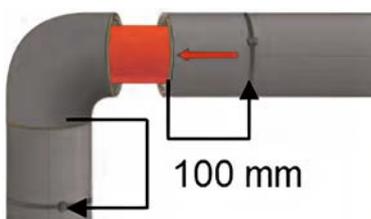
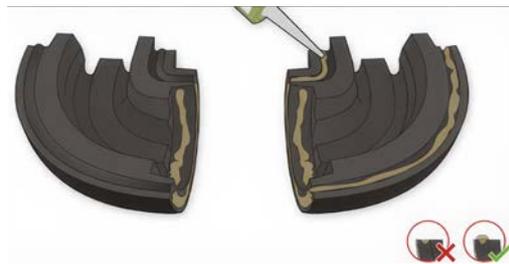
Use Stenca Strips to secure the installation, place Stenca Strips at each end of 45°/90°.

Use Stenca Seal to create a waterproof finish, create a smooth surface where Stenca Seal has been used.

Same procedure for top, bottom and horizontal bend.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Tape
4. Stenca Strips



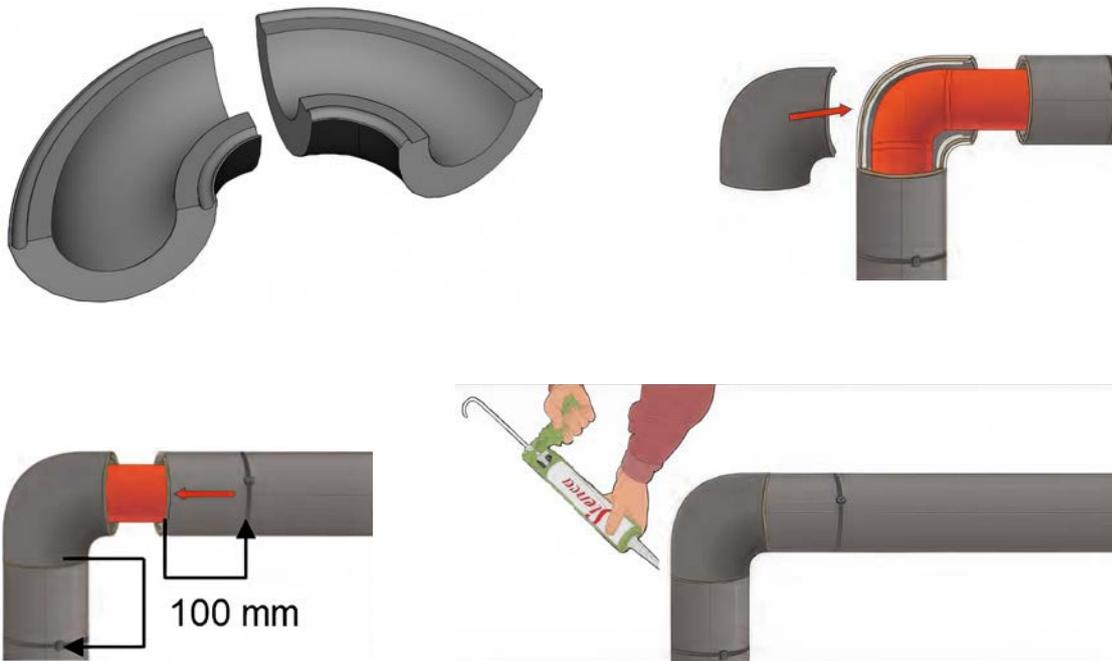
### 5.5 45°/90° SEGMENT BEND WITH CLOTH

Apply minimum 5 mm of wavy stripe of Stenca Seal on one side. Press the Stenca elements firmly together, and use Stenca Strips to secure the installation.

Place a stripe of minimum 5 mm on the surface of the joint between the Stenca elements to create a waterproof and smooth surface. Same procedure for top, bottom and horizontal bend.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



### 5.6 INSULATION IN NARROW LOCATIONS

Measure and mark the Stenca Pipe area to be removed.

Remove cloth from the area of the Stenca Pipe where it is to be cut out.  
Cut out marked area.

Use Stenca Seal to glue the cloth back on the Stenca Pipe.

Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces.

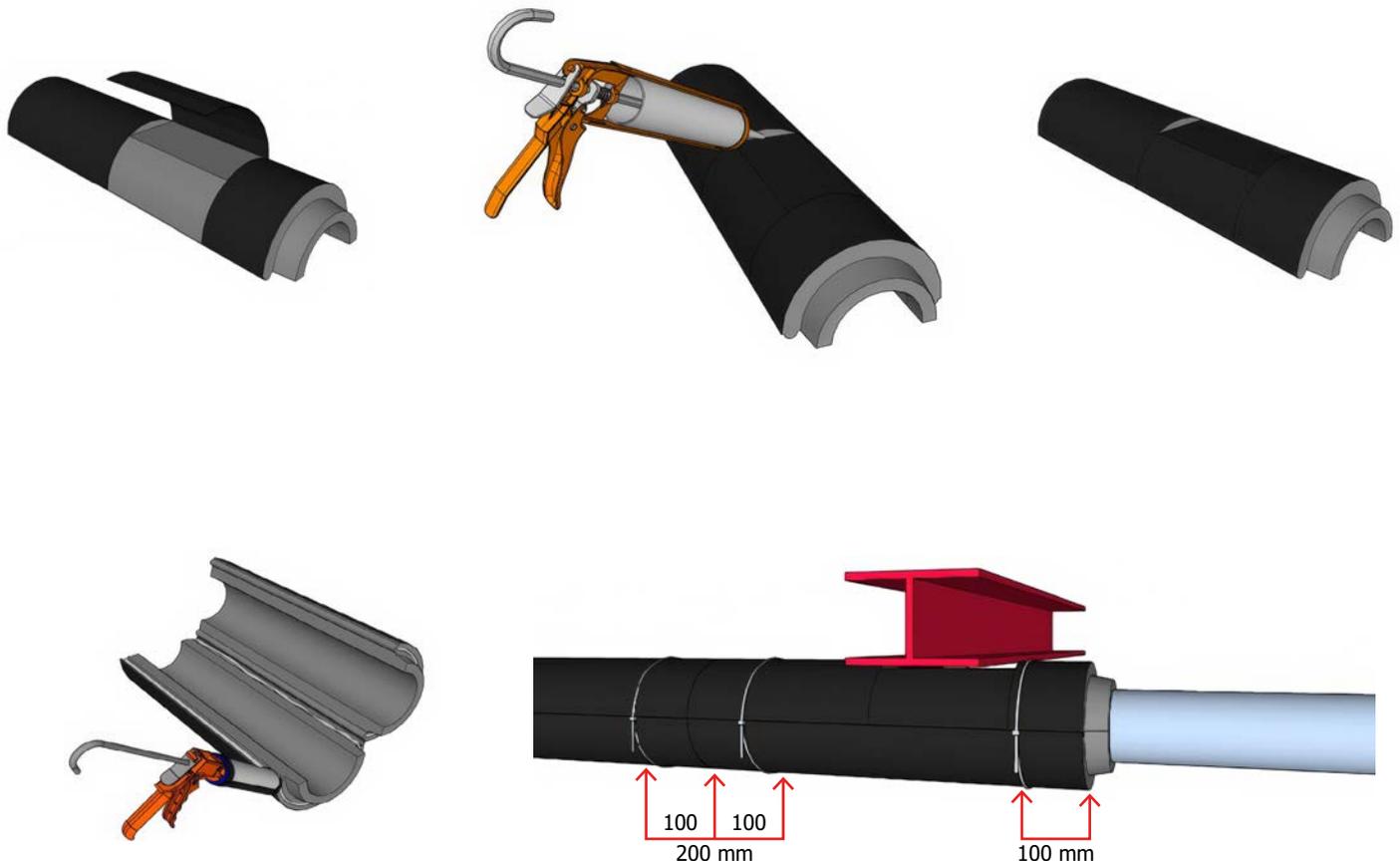
Mount Stenca Pipe on the steel pipe.

Press the two elements together, and use Stenca Strips to secure the installation.  
Place the Stenca Strips 100 mm from each end.

Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



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### 5.7 INSULATION AROUND A U-BOLT

Measure and mark the Stenca Pipe area to be removed. Remove cloth from the area to be cut out.  
Cut out marked area.

If necessary, use a spoon knife to make room for the U-bolt. Use Stenca Seal to glue the cloth back on the Stenca Pipe.  
Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces.

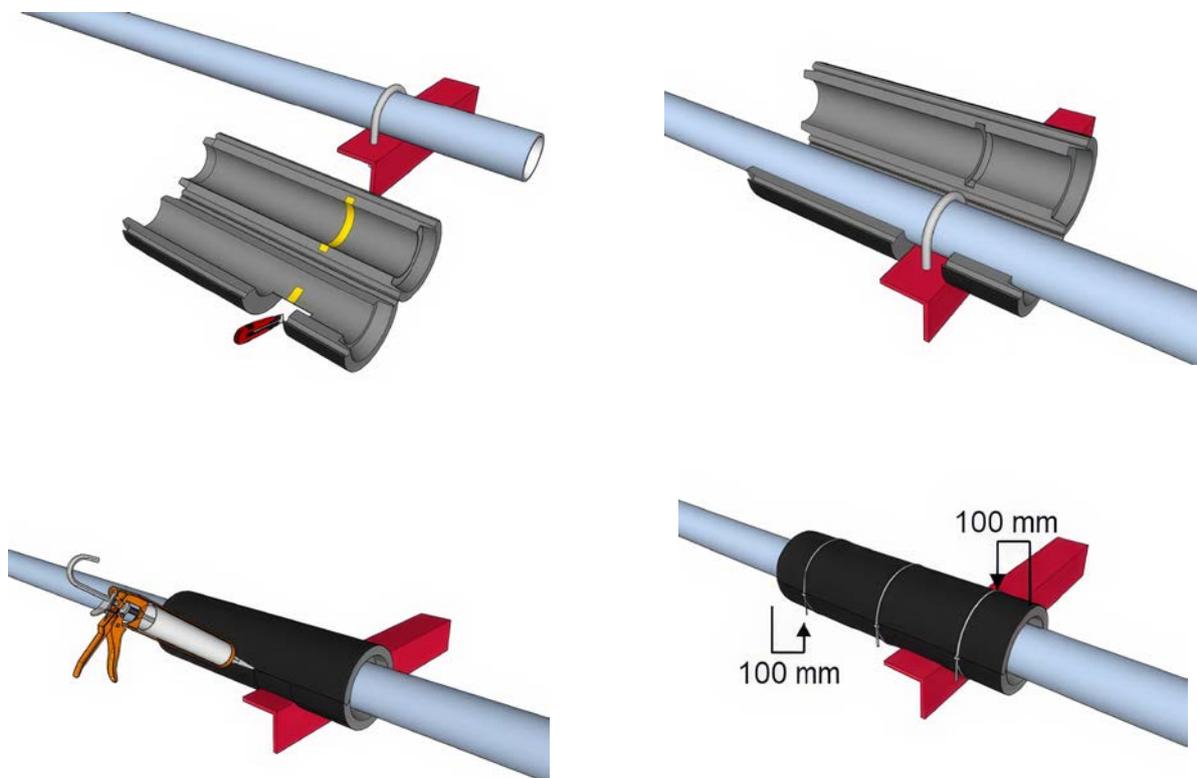
Mount Stenca Pipe on the steel pipe.  
Press the two elements together, and use Stenca Strips to secure the installation.  
Place the Stenca Strips 100 mm from each end.

Make sure that Stenca Seal is used on all contact surfaces to Stenca Pipe and U-bolt.

Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



### 5.8 STENCA PIPE WITH STENCA SPACERS

Place the Stenca Spacers center to center (c.t.c) max 300 mm on the pipe, in the middle and at the transition to the next Stenca Pipe.

Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces.

Do the same with the next section of Stenca Pipe.

Install Stenca Pipe on the Stenca Spacers.

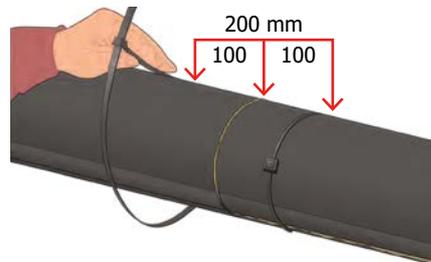
Press the two parts firmly together, and use Stenca Strips to secure the installation.

Place the Stenca Strips 100 mm from each end.

Use Stenca Seal to create a waterproof finish, create a smooth surface where Stenca Seal has been used.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



## 5.9 GLUING STENCA PIPE TOGETHER WITHOUT TONGUE/GROOVE IN JOINTS

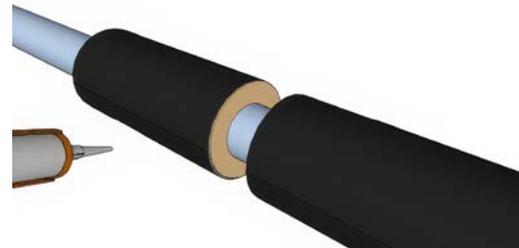
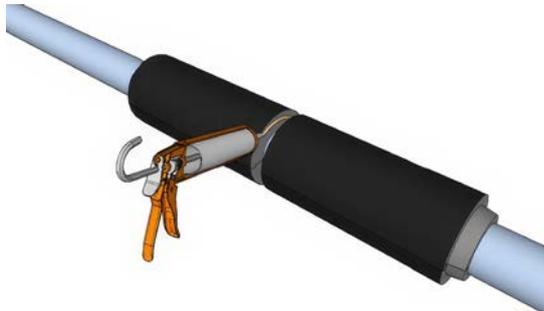
Stenca Pipe is delivered with tongue and groove in the joints. When Stenca elements are cut, they get a smooth surface. Stenca segment bend is delivered with flat joints.

Apply minimum 5 mm of wavy stripe of Stenca Seal on one side. Press the Stenca elements firmly together, and use Stenca Strips to secure the installation. Place the Stenca Strips 100 mm from each end.

Place a stripe of minimum 5 mm on the surface of the joint between the Stenca elements to create a waterproof and smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



## 5.10 END PIECE WITH AND WITHOUT STENCA SPACERS

When using Stenca Spacers, place the last Stenca Spacers max 100 mm from the bottom of the end.

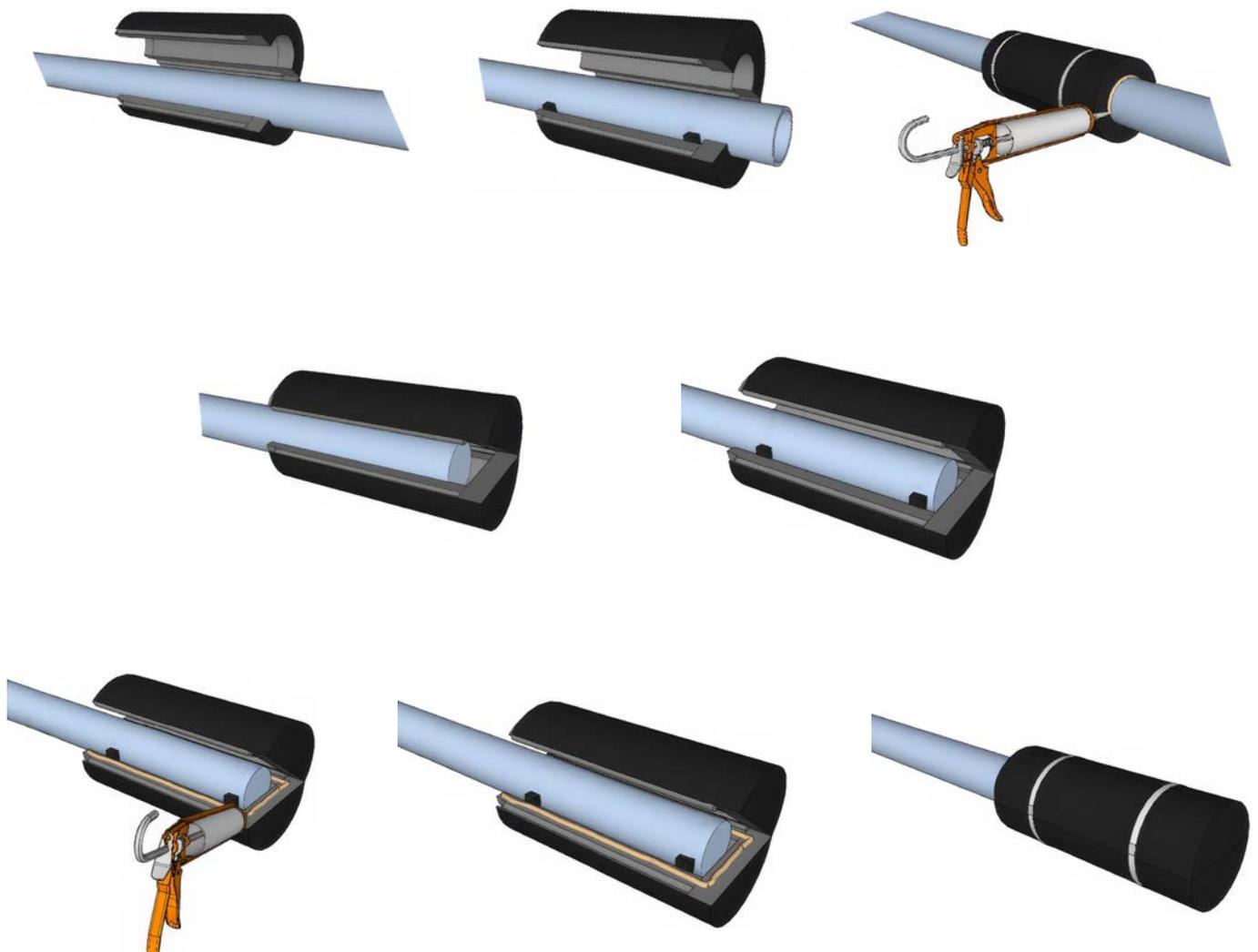
Apply Stenca Seal to the horizontal and vertical (tongue and groove) surfaces.

Mount the end piece on the steel pipe, and press the sections firmly together. Place the Stenca Strips 100 mm from the ends to secure the installation – see the illustration.

Use Stenca Seal to create a waterproof finish and a smooth surface.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Spacers
3. Stenca Seal
4. Stenca Strips



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### 5.11 FLANGE BOXES

Stenca flange boxes are mounted directly on the Stenca Pipe insulation.

Apply Stenca Seal to the horizontal and vertical tongue and groove surfaces.

Place the flange box minimum 40 mm onto the Stenca Pipe insulation, and press the sections firmly together.

Place the Stenca Strips 100 mm from the ends to secure the installation – see the illustration.

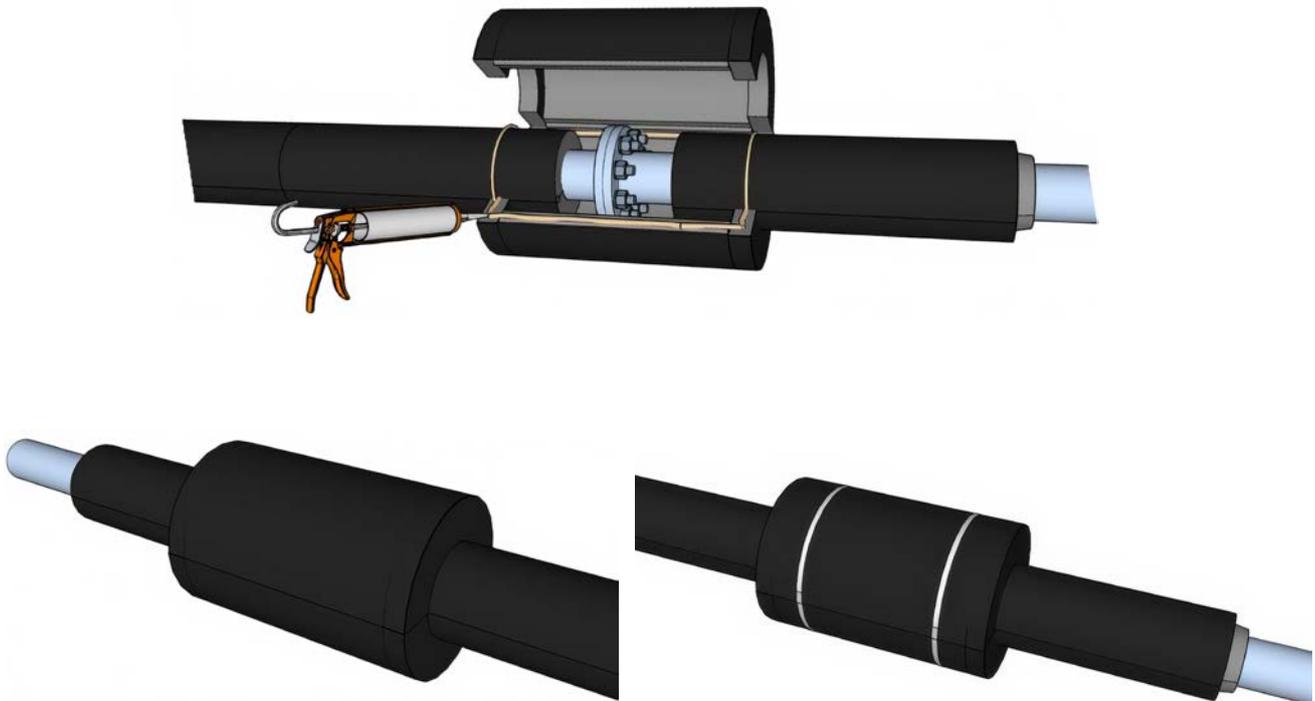
Apply Stenca Seal to the end of the Stenca Pipe, tongue and groove surfaces. Use Stenca Seal to create a waterproof finish and a smooth surface. Seal carefully when using Stenca Seal.

Seal the contact surface created between Stenca Pipe and Stenca flange box in order to prevent entry of water.

Standard Stenca flange boxes are 600 mm long, unless otherwise specified. The alignment can be adapted to the length of the flange box.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



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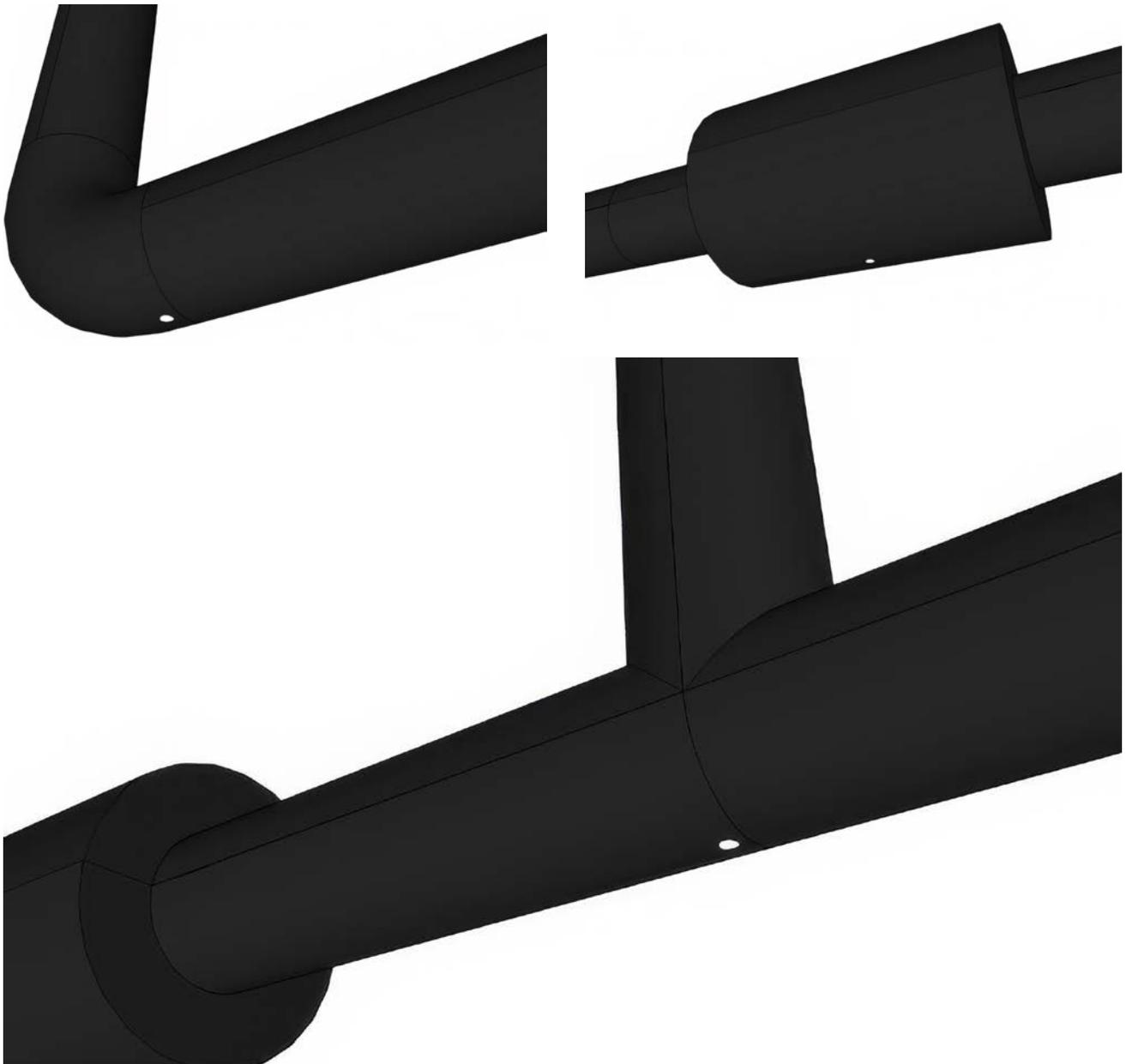
## 5.12 DRAINAGE HOLE

Drainage hole, 15 mm, is drilled at the lowest point of the Stenca Pipe in accordance with the company's specifications.

The first drainage hole after a bend is max 200 mm from the bend.

Note:

1. Insulation type: Stenca Pipe
2. Stenca Seal
3. Stenca Strips



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