

SIGRAFLEX® HOCHDRUCK

Multilayer high-strength sealing sheet made from natural graphite with stainless steel foil reinforcement for extreme conditions



SIGRAFLEX HOCHDRUCK 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 special 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 allows end users in the process industry to cover almost their entire gasket requirements with a reliable and safe product.



↑ Cross-section

Applications

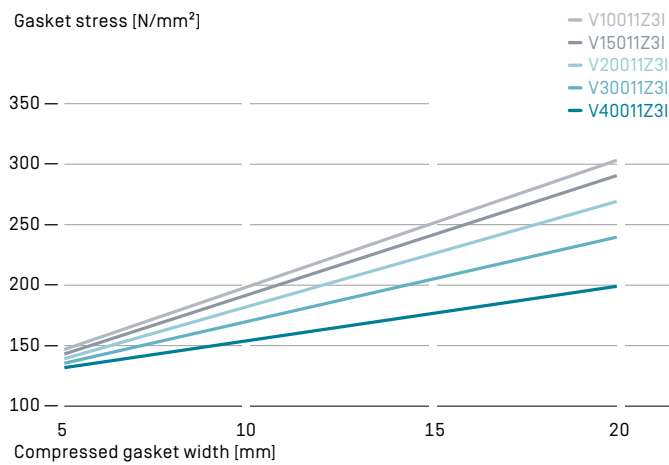
- For difficult and mechanically highly stressed sealed joints (in tongue-and-groove and flanges with special dimensions, process equipment, heat exchangers, etc.); also suitable for all common pipework and vessel flange designs
- For one-piece gasket designs up to an outside diameter of 1500 mm; for diameters above 1500 mm, for example two-layer structures with segmented sections and staggered joints are recommended
- For operating pressures from vacuum up to 250 bar
- For corrosive media
- Operating temperatures range from -250°C up to 550°C depending on chemical resistance. Life time might be limited at high temperatures. Consult the manufacturer when application temperatures exceed 450°C . Please refer to our technical guideline regarding thermal stability.
- Chemical, petrochemical, refinery and nuclear industries
- Steam pipework and boilers in power generation plants
- Heat transfer oils and heating equipment
- Inspection glasses, pumps, fittings and valves
- Existing plants

Properties

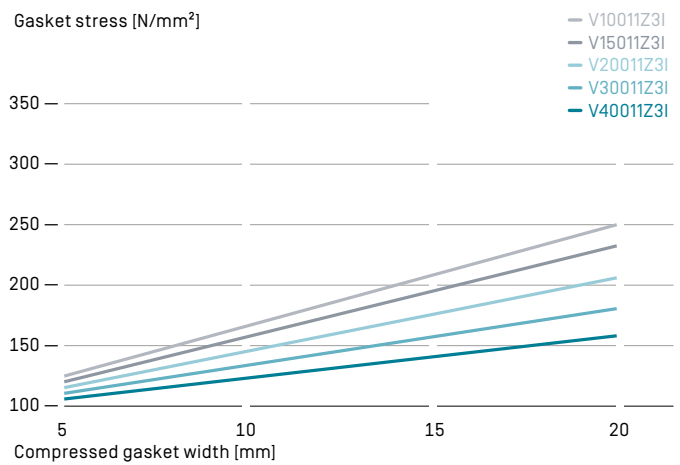
- Reduction in fugitive emissions due to high leak-tightness
- Outstanding maximum permissible gasket stress
- High operational reliability, increased plant availability
- Excellent oxidation resistance
- Very high blow-out resistance and mechanical strength
- Very high fault tolerance during assembly and operation
- Good chemical resistance
- Long-term stability of compressibility and recovery, even under fluctuating temperatures

- Good scratch resistance and antistick properties due to special impregnation
- No measurable cold or warm flow characteristics up to the maximum permissible gasket stress
- No aging or embrittlement (no adhesives or binders)
- Ease of processing
- Asbestos-free (no associated health risks)

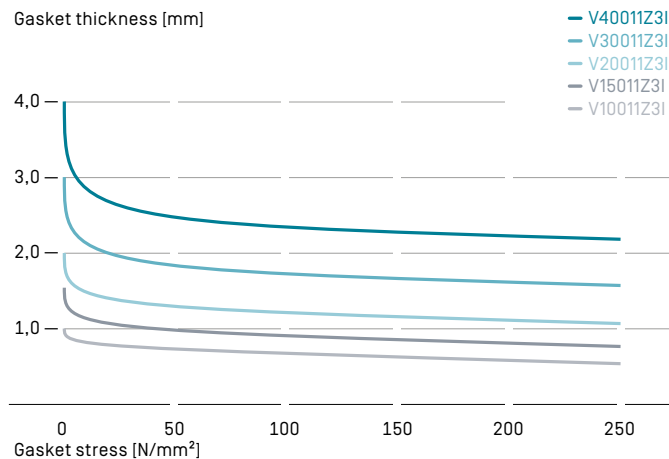
Typical maximum permissible gasket stress of SIGRAFLEX HOCHDRUCK at 20 °C



Typical maximum permissible gasket stress of SIGRAFLEX HOCHDRUCK at 300 °C



Compressibility of SIGRAFLEX HOCHDRUCK



Approvals/Test reports

Please see www.sigraflex.com/downloads for details

- TA Luft (VDI 2440/VDI 2200) with inner eyelets in various designs; for tongue and groove flanges without eyelets
- Fire safe according to BS 6755-2 and API 607
- Blow-out resistance (TÜV at 2.5 times the nominal pressure)
- BAM oxygen
- BAM ethylene oxide/propylene oxide
- Germanischer Lloyd
- US Coastguard
- DVGW (DIN 3535-6)
- TRD 401
- Evaluation for compliance with food Legislation requirements (TÜV Rheinland)
- Hot Relaxation Tightness (HORT)

Assembly instructions

Our detailed assembly instructions are available on request.

Material data of SIGRAFLEX® HOCHDRUCK

Typical properties		Units	V10011Z3I	V15011Z3I	V20011Z3I	V30011Z3I	V40011Z3I	
Thickness		mm	1.0	1.5	2.0	3.0	4.0	
Dimensions		m	1.5 x 1.5 1.0 x 1.0	1.5 x 1.5 1.0 x 1.0	1.5 x 1.5 1.0 x 1.0	1.5 x 1.5 1.0 x 1.0	1.5 x 1.5 1.0 x 1.0	
Bulk density of graphite		g/cm ³	1.1	1.1	1.1	1.1	1.1	
Ash content of graphite (DIN 51903)		%	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.15	
Purity		%	≥ 99.85	≥ 99.85	≥ 99.85	≥ 99.85	≥ 99.85	
Total chloride content		ppm	≤ 10	≤ 10	≤ 10	≤ 10	≤ 10	
Total halogen content		ppm	≤ 40	≤ 40	≤ 40	≤ 40	≤ 40	
Total sulphur content		ppm	< 300	< 300	< 300	< 300	< 300	
Oxidation rate in air at 670 °C (TGA)		%/h	< 4	< 4	< 4	< 4	< 4	
Oxidation inhibitor			yes	yes	yes	yes	yes	
Passive corrosion inhibitor (ASTM F 2168-13)			yes	yes	yes	yes	yes	
Reinforcing steel sheet details			Smooth stainless steel foil					
	ASTM material number		316 (L)	316 (L)	316 (L)	316 (L)	316 (L)	
	Thickness	mm	0.05	0.05	0.05	0.05	0.05	
	Number of sheets		1	2	3	5	7	
Residual stress (DIN 52913)	$\sigma_{D16h, 300^\circ C, 50 N/mm^2}$	N/mm ²	≥ 48	≥ 48	≥ 48	≥ 48	≥ 48	
Gasket factors (DIN E 2505/DIN 28090-1)								
Gasket width $b_0 = 20$ mm at an internal pressure of								
	$\sigma_{VU/0,1}$	10 bar	N/mm ²	10	10	10	12	14
		16 bar	N/mm ²	10	12	14	17	18
		25 bar	N/mm ²	10	14	16	20	22
		40 bar	N/mm ²	13	16	18	25	28
	m			1.3	1.3	1.3	1.3	1.3
	σ_{V0}		N/mm ²	305	290	270	240	200
	$\sigma_{B0 at 300^\circ C}$		N/mm ²	250	230	210	180	160
Gasket factors (DIN EN 13555)			see www.gasketdata.org					
Compression factors (DIN 28090-2)								
Compressibility	ϵ_{KSW}	%	35	35	35	35	35	
Recovery at 20 °C	ϵ_{KRW}	%	5	5	5	5	5	
Hot creep	ϵ_{WSW}	%	< 3	< 3	< 3	< 3	< 3	
Recovery at 300 °C	ϵ_{WRW}	%	4	4	4	4	4	
Young's modulus at 20 N/mm ² (DIN 28090-1)		N/mm ²	750	750	750	750	750	
ASTM	„m“-factor		2.5	2.5	2.5	2.5	2.5	
	„y“-factor	psi	3000	3000	3000	3000	3000	
Compressibility (ASTM F36)		%	35	35	35	35	35	
Recovery (ASTM F36)		%	15	15	15	15	15	
The gasket factor conversion formulas as per AD Merkblatt B7 are as follows					$k_0 \times K_D = \sigma_{VU} \times b_0$ $k_1 = m \times b_0$			

Definitions

$\sigma_{VU/0,1}$	Minimum gasket assembly stress needed to comply with leakage class L 0.1 (according to DIN 28090-1) Recommended gasket assembly stress: ≥ 20 N/mm ² up to σ_{B0}	k_0	in mm, factor for gasket assembly stress
σ_{BU}	Minimum gasket assembly stress in service, where σ_{BU} is the product of internal pressure p_i and gasket factor m for test and in service ($\sigma_{BU} = p_i \times m$)	k_1	in mm, factor for gasket stress in service
σ_{V0}	Maximum permissible gasket stress at 20 °C	K_D	in N/mm ² , max. gasket stress-bearing capacity under assembly conditions
$\sigma_{B0 at 300^\circ C}$	Maximum permissible gasket stress in service	ϵ_{KSW}	Compression set under a gasket stress of 35 N/mm ²
$m = \sigma_{BU}/p_i$		ϵ_{KRW}	Gasket recovery after reduction in gasket stress from 35 N/mm ² to 1 N/mm ²
„m“-factor	Similar to m , but defined acc. to ASTM, hence different value	ϵ_{WSW}	Gasket creep compression under a gasket stress of 50 N/mm ² at 300 °C after 16 h
„y“-factor	Minimum gasket stress in psi	ϵ_{WRW}	Recovery after reduction in gasket stress from 50 N/mm ² to 1 N/mm ²

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

Product overview

Products	Characteristics	Recommended applications
SIGRAFLEX FOIL F.../C/E/Z/APX/APX2	Flexible, continuous	- 250 °C to approx. 550 °C, for die-formed packing rings, 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 stainless steel foil	Pumps, fittings, gas supply and waste gas pipelines
SIGRAFLEX UNIVERSAL V...C2I	Reinforced with tanged stainless steel, impregnated	Pipework and vessels in the chemical and petrochemical industries and in power generation plants
SIGRAFLEX UNIVERSAL PRO V...C2IP	Reinforced with tanged stainless steel, impregnated	TA Luft applications, for pipework and vessels in the chemical and petrochemical industries and in power generation plants
SIGRAFLEX SELECT V16010C3I	Reinforced with stainless steel foil, adhesive-free, impregnated	TA Luft applications, raised-face flanges, pipework in the chemical and petrochemical industries
SIGRAFLEX HOCHDRUCK V...Z3I	Multilayer material, reinforced with stainless steel foil, adhesive-free, impregnated	Universal sealing sheet, also for solving sealing problems in pipework, process equipment, tongue-and-groove flanges and non-standard joints in the chemical, petrochemical and nuclear industries and in power generation plants
SIGRAFLEX HOCHDRUCK PRO V...Z3IP	Multilayer material, reinforced with stainless steel foil, adhesive-free, 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 chemical, petrochemical and nuclear industries and in power generation plants
SIGRAFLEX APX2 HOCHDRUCK V...W3	Multilayer material, reinforced with stainless steel foil, adhesive-free	Universal sealing sheet, also for solving sealing problems in high temperature applications in pipework, process equipment, tongue-and-groove flanges and non-standard joints in the chemical and petrochemical industries and in power generation plants
SIGRAFLEX MF V...MF	Adhesive-free laminate made of graphite, stainless steel and PTFE	Maximum requirements for sealability (TA Luft), safety and process hygiene; sealed joints in the chemical, petrochemical, pharmaceutical and food industries
SIGRAFLEX EMAIL V...Z3E	Reinforced with stainless steel foil, adhesive-free	PTFE-envelope gaskets for enameled pipework, vessels and stub connections, etc.



Additional information on our SIGRAFLEX
sealing materials can be found under
"Download Center" on our homepage.

www.sigraflex.com/downloads



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05 2018/0.5 E Printed in Germany

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