

# WL Plastic ASTM D2513 GAS-NR Pipe



JANA attests that WL Plastics is using best practices in producing quality pipe that is in conformance with ASTM D2513-09a.

JANA, from its inception, has been specifically focused on supporting the piping industry in understanding and ensuring the long-term performance of piping products in critical and demanding applications. JANA's engineering personnel have over 335 years of experience in PE product design, extrusion, testing, lifetime forecasting and technical service. JANA's 15-year history operating a pipe testing laboratory provides unique insights into piping quality, performance and related issues.

In order to safely and reliably deliver gas to customers, gas distribution companies must actively maintain their pipeline infrastructure. Poor quality of an installed pipeline leads directly to higher risks and costs due to a higher frequency of emergency inspections, unexpected or premature replacement costs and, potentially, catastrophic failure. Poor quality can be introduced anywhere in the pipeline lifecycle, from the design and selection of components through to the installation of the distribution system. To reduce the risk of poor quality on a pipeline system, selection of a quality vendor is of paramount importance.

JANA conducted a holistic and detailed assessment of WL's extrusion process, including a comprehensive quality system review and an in-plant inspection, based on the following *Fundamentals of Pipe Quality*:

Quality Compounds	Material Handling	Extrusion Practice	Quality Control	Traceability	Quality System	Service
<ul style="list-style-type: none"> <li>• State-of-the-Art Materials</li> <li>• Required Approvals</li> </ul>	<ul style="list-style-type: none"> <li>• Material Verification</li> <li>• Contamination Controls</li> </ul>	<ul style="list-style-type: none"> <li>• State-of-the-Art Equipment</li> <li>• Operator Competency</li> </ul>	<ul style="list-style-type: none"> <li>• Inline Control</li> <li>• Offline Control</li> </ul>	<ul style="list-style-type: none"> <li>• Materials</li> <li>• Process &amp; QC History</li> </ul>	<ul style="list-style-type: none"> <li>• Documented System</li> <li>• Verification</li> </ul>	<ul style="list-style-type: none"> <li>• Commercial</li> <li>• Technical</li> </ul>

## Quality Compounds

WL uses only industry-leading, high density, *bimodal* PE4710 compounds.

Manufacturer	Grade	Cell Class.	Density (g/cc)	HLMI (g/10 min)	PENT (h)	RCP Critical Pressure	73°F HDB (psi)	140°F HDB (psi)
INEOS	TUB 121	445574C	0.949	8.5	>10,000	>10 bar	1,600	1,000
LyondellBasell	L4904	445574C	0.949	7	>2,000	>10 bar	1,600	1,000

## Contamination Control & Material Handling

As a result of a detailed audit, JANA has concluded that WL employs best-in-class practices, including hopper car delivery for resin and masterbatch, PE4710 dedicated silos/blenders/conveying and excellent housekeeping. No regrind is used in GAS-NR pipe and any plant produced regrind is properly segregated. Incoming material QC is appropriate and includes density, MI and carbon black.

## Extrusion Practices

As a result of a detailed audit, JANA has concluded that WL's facilities are outfitted with modern state-of-the-art extrusion equipment, which ensures uniform output without degrading the compounds. Equipment includes gravimetric feeders, grooved barrel extruders, long screw L/D, static mixers, melt filtration, basket dies and long cooling lines.

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## Quality Control

In-line INOEX ultrasonic scanners verify uniform wall thickness and can detect contamination or pipe flaws. Calibrated laboratory equipment and in-plant QC procedures exceed ASTM D2513 Appendix A1 requirements.

## Traceability

JANA verified that WL procedures and practices provide appropriate traceability of pipe through the manufacturing process back to the resin and masterbatch lots. WL's pipe markings include ASTM D2897 bar coding.

## Quality System

WL maintains ISO 9001 (2008) and NSF-14 certifications. Plants are audited and pipe is regularly tested by NSF to demonstrate compliance to ASTM D2513 and CSA B137.4.

## Service

By operating a decentralized Customer Service and plant-based shipping teams, WL is able to provide fast and accurate responses to customer inquiries. WL personnel actively participate and contribute to piping standards and concerns at AGA, GPTC, ASTM, PPI and ASME.

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## About WL Plastics Corporation ("WL")



WL manufactures high performance High Density Polyethylene (HDPE) pressure pipe for regulated gas, oil & gas gathering, mining, industrial and municipal water and wastewater markets. A leading manufacturer of plastic pipe, WL has 7 state-of-the-art plants, representing a capacity of over 500 million pounds per year of PE pipe capacity. WL is exclusively focused on the production of high quality bimodal HDPE pipe for pressure service.

With a mission to "strive to be the North American supplier of choice in the markets we serve by building strong relationships with our customers and suppliers," WL is committed to essential business fundamentals that enable superior customer service:

- Safely produce high-quality HDPE pipe products efficiently
- Maintain the latest, state-of-the-art manufacturing extrusion equipment
- Produce to strict quality control standards
- Communicate in a timely and concise manner with customers
- Manage production schedules to meet customer needs



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