

Western Instruments WD-Series DC Magnetizing Coils WDV 16 Coils Manual



Description

WDV-16 Coil is operated from 230 VAC (60 Hz) Power, which is inverted and induces a DC Magnetic Field in the ferrous material being tested. The Optional AC Feature, permits a fixed level for an AC field as well. As the unit conducts electricity in a circular fashion, it induces a Longitudinal Magnetic field in a Central Conductor. This device should be utilized within the parameters set by the operational specifications within this guide.

- 1. Coil Housing** – The Coil Housing is cast from a durable Urethane Rubber, which protects the Aluminum Wire Core. This Robust encapsulant is resistant to cracking and disbonding due to age or high/low temperatures, and is suitable for Dry or Wet Method media. Cast into the top inside portion of the Coil Housing are 7 nonferrous Connecting Rods, which are used to mount the Aluminum Control Panel Housing. These Connecting Rods are also used to mount optional ID Wear Bars, which protect the Urethane Encapsulant.

The WDV-16 is also equipped with 3 Nonferrous Connecting Rods, located on the bottom of the inside portion of the Coil. These Connecting Rods can be used for ID Wear Bars or for rigidly mounting the coil for auxiliary uses, such as a Coil Car used on a Custom Testing Fixture or Western's *Mini-Bench*.

- 2. Control Panel Housing** – The Control Panel Housing is used to mount the Solid State Electronic Controls of all WD-Series Coils. It is designed to protect the Control Components from damage due to the riggers of field or shop use. The reverse (or underside) of the Control panel acts as the mounting plate for all of the Control Components, while the top side is where all the operator controls are located. As indicated in promotional literature, the Variable Power Supply (WDV-Series) is equipped with adjustable amperage which is variable from 0 to 10,000 Ampere Turns output.

Variable Power Supply (WDV Coils)

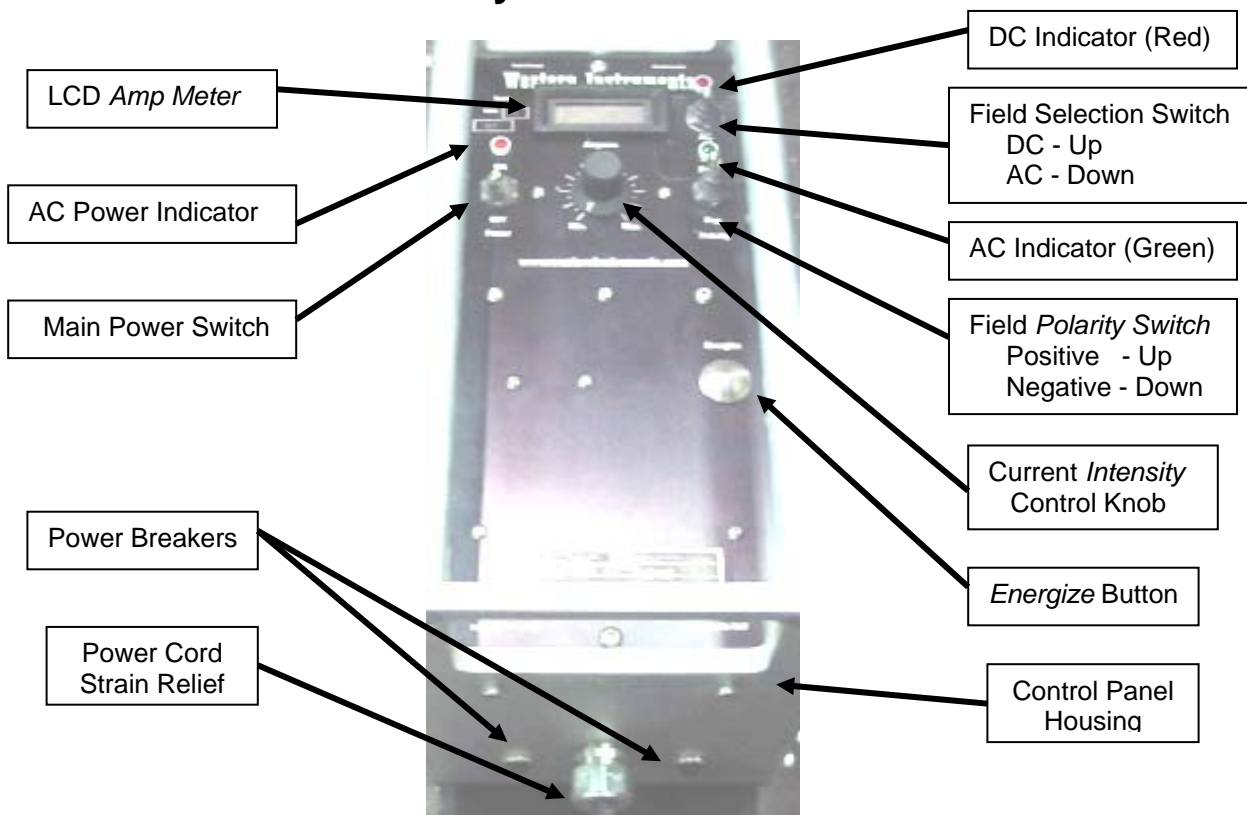
The Control Panel Housing used in the WDV Coils is slightly taller than that on the WDP Coils. The WDV panel is equipped with the following control components;

- a) Power On/Off**, controls the AC power to the Coil's Control Components. This switch is protected by two 15 Amp Breakers located on the Power Cord Side Plate of the Coil, these will kick out if the current draw exceeds 30 Amps. The red indicator shows the operator that the AC power is turned on.
- b) Intensity Current Control Knob** allows the operator to control and monitor the DC amperage to the coil. The Amp Meter may not be completely linear, with respect to the knob position while the unit is not activated, but will indicate the actual current when the coil is energized. The Amperage, with respect to the knob position, is always indicated

whenever the Main Power Switch is activated. The scale engraved on the control panel is not calibrated and is only used as a reference point for the operator.

- c) Calibrated LCD *Amp Meter* is 3 digits, and also indicates if the applied field is positive (+) or negative (-). The Display only indicates DC Current and is off in AC Mode.
- d) **+/-** *Field Polarity Switch* requires the operator to pause between positive and negative fields, as the existing field in the coil needs to collapse prior to the opposite polarity being applied. The Field direction is switched from positive to negative to demagnetize a work piece or to enhance a residual magnetic field.
- e) Field Selection Switch allows the Operator to Select a DC (up) or AC (down) Field.
- f) Push Button *Energize* switch is located adjacent to the Polarity Switch, and while depressed allows current to flow through the coil.

Do not press the Energize Push Button when changing the Field Polarity or Field Selection Switch.



Note: These Operating Instructions also apply to Separate Power Supplies provided as retrofits to other manufacturers Coil Assemblies. Western Instruments makes no claims or warranties when used with other manufactures Coils.

3. Duty Cycle – The Duty Cycle (maximum duration) for periodic operation is set to avoid overheating of the Internal Aluminum Wire Coil. Warm (or hot) Core Wires have an increased resistance, and will reduce the overall Ampere Turn output of the Coil.

WDV Models should not be activated, using the Field Activation Switch, for more than 2 minutes at a time When in DC Mode. The activation time should be followed by an equal or longer cool down (or off) cycle. This 50% duty cycle is set to protect the Core and Control Components from overheating. If the operator has any concern about the actual or planned

operation of the Coil, Western Instruments or the Distributor should be consulted. No matter if the Coil is equipped the Thermo-Protection Switch or not, duty cycles must be observed.

The Duty Cycle of the unit while in AC mode is 75%, which means the unit can be operated for extended periods of time without overheating the Core. This time should not exceed 5 minutes on, followed by a 2 ½ minute cool down cycle.

- 4. Field Characteristics;** – WD-Series Coils are classified as DC units and are designed to induce a Longitudinal Field in a Work Piece positioned though the Centerline of the Coil. A Transverse Field may be introduced, if the Work Piece is short enough, by placing it perpendicular and inside the Coil's inside surface. WD-Series Coils are designed to comply with specifications requiring Residual or Active Fields.

AC Option is designed to convert the Output Field from DC to AC. When configured to operate in *AC Mode*, the output of the coil is a minimum of 4000-Ampere Turns, but is size and input voltage dependent. The AC Option is only available where coils have been specifically manufactured with is capability.

Do not press the Energize Push Button when changing the Field Polarity or Field Selection Switch.

- 5. Operation;** - The Coil is either placed on the Work Piece, such as a threaded end of a pipe, or if the Work Piece is small it can be held within the inside of the coil. If held and if it is short enough to be rotated within the coil, a longitudinal or transverse field can be induced into the Work Piece. Application of particles, depending on the specification and skill of the operator, are applied during (Active Field) or after the field is set-up in the Work Piece (Residual Field). Active Field Inspection requires less skill by the operator in the application of the particles, while in Residual Field Inspection there is no particle migration and greater skill and care must be taken in media application.

When to Coil is placed over the Work Piece and the Field Intensity is set by the operator with the Current Control Knob, the Coil is Energized (a "Shot") with the Push Button Energizing Switch. A positive or negative field is induced, followed by an Active or Residual Field Inspection.

To demagnetize the Work Piece;

1. The operator places the coil back over the work piece, reduces the Current Control Knob by approximately 20% from the magnetization current selected.
2. Knob by approximately 20% from the magnetization current selected.
3. The field is activated, in the opposite direction from the magnetization shot, for a slightly shorter duration of time.
4. The Current Control Knob is again reduced by approximately 20%, and the field is activated, in the same direction as the magnetization shot, again for a slightly shorter duration.
5. Steps 1 through 3 are repeated until the final shot at 0 amps. The number of Demag shots may be decreased or increased depending on; the amount of field induced during magnetization; the size; and the magnetic permeability of the Work Piece.

Caution: The energy flowing through the internal Coil, in either AC or DC Modes, produces a great amount of stored energy, taking at least one second to dissipate after the power has been turned off.

5. Maintenance: After extended use, WD-Series Coils should be cleaned with a mild soap solution. The unit should be visually inspected regularly for any damage that could cause harm to the operator, or the material being inspected. Special attention should be paid to the; control switches/boots; Current Control Knob; and the power cord (cable). Any potential problems to these assemblies must be reported to the distributor or Western Instruments for instructions on corrective action.

Other than routine maintenance, the operator can expect a longer service life. Depending on the Industry or in-house specification utilized, and the type of service (field or shop) the amp meter assembly should be calibrated at regular intervals. Furthermore, during calibration the field produced by the coil should be tested to ensure there is no reduction in the performance of the unit.

The distributor or Western Instruments should be contacted for any specific instructions on maintenance, due to the specific environment of operation. Repairs, that need to be carried out on the product, should be performed by an authorized service depot or Western Instruments.

Wiring

W-Series 230 Volt Models, are designated by a "K" placed after the Serial Number and the Model number (e.g. WC-6K), are shipped without an AC Power Plug as there is no international standardization. When installing an AC Power Plug onto the AWG 18-3 Power Cord, the following is the identity of the 3 Color Coded Conductors;

- Green – Ground
- White - Neutral
- Black – Live

Care must be taken to insure the proper installation of an AC Power Plug, and if there is any question, contact your distributor or Western Instruments. If an AC Plug is not installed before use, any warranty is void.

Calibration

WD-Series Coils should have their Amperage Meter Calibrated annually or after control repairs have been made (power cords and plugs are not considered "Controls"). However, the customer's Quality Manual or a Reference Specification may require more frequent Calibrations. North American customers can have calibrations made at an Authorized Service Centre. International customers may not have a Service Centre located in their region, so a qualified company must be found. A company that repairs Industrial Electrical Controls should have the necessary expertise to perform a calibration. If Western Instruments is provided appropriate documentation, the Calibration Procedure can be provided to such a company.

Warranty: Western Instruments warrants all WD-Series Coils against defects in materials and workmanship for a period of 1 year from receipt by the end user. Consumable items are warranted against defects in materials and workmanship for 30 days form receipt by the end user. If Western Instruments receives notice of such defects during the warranty period, Western Instruments will either, at its option, repair, replace, or condemn products that prove to be defective.

Any warranty is void if the unit has been modified in any way, mistreated, or if it has been repaired by an unauthorized agency. The end user agrees that any equipment's disposition, when returned for warranty work, is at the full discretion of Western Instruments as to whether a claim is under warranty or due to misuse. Western Instruments warranty shall overlook normal wear, however does not include operation outside the environmental specification of the product. Any warranty work is FOB western Instruments, and any returned units shall include a written description, by the end user, of the fault.

Western Instruments makes no other warranty, either expressed or implied, with respect to this product. Western Instruments specifically disclaims any liability arising form the use of this equipment. For the correct use of Western Instruments W-Series Coils refer to the Operating Instructions, furthermore we recommend instructional training to CGSB or ASNT qualifications. Western Instruments highly recommends the end user exercises all possible safety precautions, including the use of protective equipment, while operating this or other industrial equipment.

Specifications:

Model: WDV-16
Voltage: 230 VAC 60 Hz
Current: DC – 17 Amps
AC – 20 Amps
Capacity: DC - 0 to 16,000 Amp Turns (Minimum)
AC - 4,000 Amp Turns (Fixed)
Size: 16" (406mm) Inside Diameter.
Weight: 107 Pounds (49kg)



Western Instruments WD-Series DC Magnetizing Coils WDV 16 Coils Manual



Description

WDV-16 Coil is operated from 230 VAC (60 Hz) Power, which is inverted and induces a DC Magnetic Field in the ferrous material being tested. The Optional AC Feature, permits a fixed level for an AC field as well. As the unit conducts electricity in a circular fashion, it induces a Longitudinal Magnetic field in a Central Conductor. This device should be utilized within the parameters set by the operational specifications within this guide.

- 1. Coil Housing** – The Coil Housing is cast from a durable Urethane Rubber, which protects the Aluminum Wire Core. This Robust encapsulant is resistant to cracking and disbonding due to age or high/low temperatures, and is suitable for Dry or Wet Method media. Cast into the top inside portion of the Coil Housing are 7 nonferrous Connecting Rods, which are used to mount the Aluminum Control Panel Housing. These Connecting Rods are also used to mount optional ID Wear Bars, which protect the Urethane Encapsulant.

The WDV-16 is also equipped with 3 Nonferrous Connecting Rods, located on the bottom of the inside portion of the Coil. These Connecting Rods can be used for ID Wear Bars or for rigidly mounting the coil for auxiliary uses, such as a Coil Car used on a Custom Testing Fixture or Western's *Mini-Bench*.

- 2. Control Panel Housing** – The Control Panel Housing is used to mount the Solid State Electronic Controls of all WD-Series Coils. It is designed to protect the Control Components from damage due to the riggers of field or shop use. The reverse (or underside) of the Control panel acts as the mounting plate for all of the Control Components, while the top side is where all the operator controls are located. As indicated in promotional literature, the Variable Power Supply (WDV-Series) is equipped with adjustable amperage which is variable from 0 to 10,000 Ampere Turns output.

Variable Power Supply (WDV Coils)

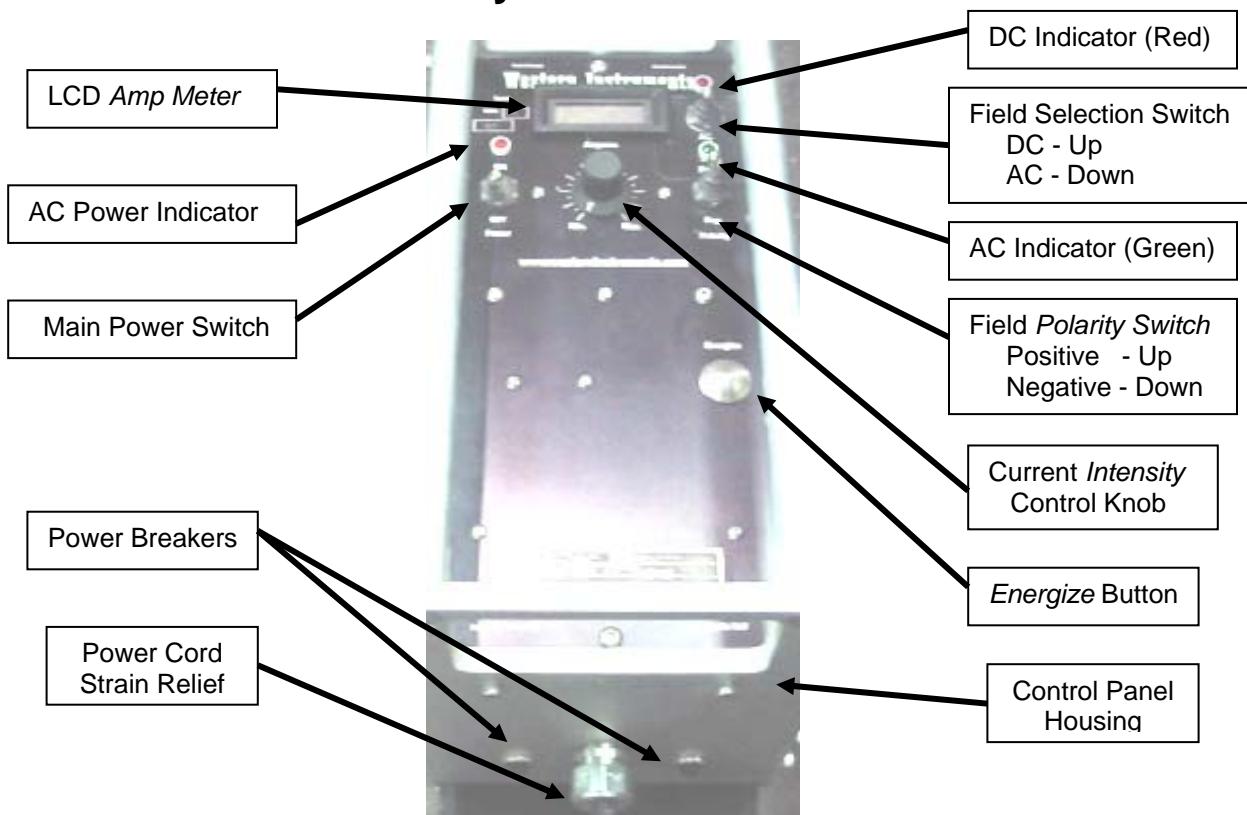
The Control Panel Housing used in the WDV Coils is slightly taller than that on the WDP Coils. The WDV panel is equipped with the following control components;

- a) Power On/Off**, controls the AC power to the Coil's Control Components. This switch is protected by two 15 Amp Breakers located on the Power Cord Side Plate of the Coil, these will kick out if the current draw exceeds 30 Amps. The red indicator shows the operator that the AC power is turned on.
- b) Intensity Current Control Knob** allows the operator to control and monitor the DC amperage to the coil. The Amp Meter may not be completely linear, with respect to the knob position while the unit is not activated, but will indicate the actual current when the coil is energized. The Amperage, with respect to the knob position, is always indicated

whenever the Main Power Switch is activated. The scale engraved on the control panel is not calibrated and is only used as a reference point for the operator.

- c) Calibrated LCD *Amp Meter* is 3 digits, and also indicates if the applied field is positive (+) or negative (-). The Display only indicates DC Current and is off in AC Mode.
- d) **+/-** *Field Polarity Switch* requires the operator to pause between positive and negative fields, as the existing field in the coil needs to collapse prior to the opposite polarity being applied. The Field direction is switched from positive to negative to demagnetize a work piece or to enhance a residual magnetic field.
- e) Field Selection Switch allows the Operator to Select a DC (up) or AC (down) Field.
- f) Push Button *Energize* switch is located adjacent to the Polarity Switch, and while depressed allows current to flow through the coil.

Do not press the Energize Push Button when changing the Field Polarity or Field Selection Switch.



Note: These Operating Instructions also apply to Separate Power Supplies provided as retrofits to other manufacturers Coil Assemblies. Western Instruments makes no claims or warranties when used with other manufactures Coils.

3. Duty Cycle – The Duty Cycle (maximum duration) for periodic operation is set to avoid overheating of the Internal Aluminum Wire Coil. Warm (or hot) Core Wires have an increased resistance, and will reduce the overall Ampere Turn output of the Coil.

WDV Models should not be activated, using the Field Activation Switch, for more than 2 minutes at a time When in DC Mode. The activation time should be followed by an equal or longer cool down (or off) cycle. This 50% duty cycle is set to protect the Core and Control Components from overheating. If the operator has any concern about the actual or planned

operation of the Coil, Western Instruments or the Distributor should be consulted. No matter if the Coil is equipped the Thermo-Protection Switch or not, duty cycles must be observed.

The Duty Cycle of the unit while in AC mode is 75%, which means the unit can be operated for extended periods of time without overheating the Core. This time should not exceed 5 minutes on, followed by a 2 ½ minute cool down cycle.

- 4. Field Characteristics;** – WD-Series Coils are classified as DC units and are designed to induce a Longitudinal Field in a Work Piece positioned though the Centerline of the Coil. A Transverse Field may be introduced, if the Work Piece is short enough, by placing it perpendicular and inside the Coil's inside surface. WD-Series Coils are designed to comply with specifications requiring Residual or Active Fields.

AC Option is designed to convert the Output Field from DC to AC. When configured to operate in *AC Mode*, the output of the coil is a minimum of 4000-Ampere Turns, but is size and input voltage dependent. The AC Option is only available where coils have been specifically manufactured with is capability.

Do not press the Energize Push Button when changing the Field Polarity or Field Selection Switch.

- 5. Operation;** - The Coil is either placed on the Work Piece, such as a threaded end of a pipe, or if the Work Piece is small it can be held within the inside of the coil. If held and if it is short enough to be rotated within the coil, a longitudinal or transverse field can be induced into the Work Piece. Application of particles, depending on the specification and skill of the operator, are applied during (Active Field) or after the field is set-up in the Work Piece (Residual Field). Active Field Inspection requires less skill by the operator in the application of the particles, while in Residual Field Inspection there is no particle migration and greater skill and care must be taken in media application.

When to Coil is placed over the Work Piece and the Field Intensity is set by the operator with the Current Control Knob, the Coil is Energized (a "Shot") with the Push Button Energizing Switch. A positive or negative field is induced, followed by an Active or Residual Field Inspection.

To demagnetize the Work Piece;

1. The operator places the coil back over the work piece, reduces the Current Control Knob by approximately 20% from the magnetization current selected.
2. Knob by approximately 20% from the magnetization current selected.
3. The field is activated, in the opposite direction from the magnetization shot, for a slightly shorter duration of time.
4. The Current Control Knob is again reduced by approximately 20%, and the field is activated, in the same direction as the magnetization shot, again for a slightly shorter duration.
5. Steps 1 through 3 are repeated until the final shot at 0 amps. The number of Demag shots may be decreased or increased depending on; the amount of field induced during magnetization; the size; and the magnetic permeability of the Work Piece.

Caution: The energy flowing through the internal Coil, in either AC or DC Modes, produces a great amount of stored energy, taking at least one second to dissipate after the power has been turned off.

5. Maintenance: After extended use, WD-Series Coils should be cleaned with a mild soap solution. The unit should be visually inspected regularly for any damage that could cause harm to the operator, or the material being inspected. Special attention should be paid to the; control switches/boots; Current Control Knob; and the power cord (cable). Any potential problems to these assemblies must be reported to the distributor or Western Instruments for instructions on corrective action.

Other than routine maintenance, the operator can expect a longer service life. Depending on the Industry or in-house specification utilized, and the type of service (field or shop) the amp meter assembly should be calibrated at regular intervals. Furthermore, during calibration the field produced by the coil should be tested to ensure there is no reduction in the performance of the unit.

The distributor or Western Instruments should be contacted for any specific instructions on maintenance, due to the specific environment of operation. Repairs, that need to be carried out on the product, should be performed by an authorized service depot or Western Instruments.

Wiring

W-Series 230 Volt Models, are designated by a "K" placed after the Serial Number and the Model number (e.g. WC-6K), are shipped without an AC Power Plug as there is no international standardization. When installing an AC Power Plug onto the AWG 18-3 Power Cord, the following is the identity of the 3 Color Coded Conductors;

- Green – Ground
- White - Neutral
- Black – Live

Care must be taken to insure the proper installation of an AC Power Plug, and if there is any question, contact your distributor or Western Instruments. If an AC Plug is not installed before use, any warranty is void.

Calibration

WD-Series Coils should have their Amperage Meter Calibrated annually or after control repairs have been made (power cords and plugs are not considered "Controls"). However, the customer's Quality Manual or a Reference Specification may require more frequent Calibrations. North American customers can have calibrations made at an Authorized Service Centre. International customers may not have a Service Centre located in their region, so a qualified company must be found. A company that repairs Industrial Electrical Controls should have the necessary expertise to perform a calibration. If Western Instruments is provided appropriate documentation, the Calibration Procedure can be provided to such a company.

Warranty: Western Instruments warrants all WD-Series Coils against defects in materials and workmanship for a period of 1 year from receipt by the end user. Consumable items are warranted against defects in materials and workmanship for 30 days from receipt by the end user. If Western Instruments receives notice of such defects during the warranty period, Western Instruments will either, at its option, repair, replace, or condemn products that prove to be defective.

Any warranty is void if the unit has been modified in any way, mistreated, or if it has been repaired by an unauthorized agency. The end user agrees that any equipment's disposition, when returned for warranty work, is at the full discretion of Western Instruments as to whether a claim is under warranty or due to misuse. Western Instruments warranty shall overlook normal wear, however does not include operation outside the environmental specification of the product. Any warranty work is FOB western Instruments, and any returned units shall include a written description, by the end user, of the fault.

Western Instruments makes no other warranty, either expressed or implied, with respect to this product. Western Instruments specifically disclaims any liability arising from the use of this equipment. For the correct use of Western Instruments W-Series Coils refer to the Operating Instructions, furthermore we recommend instructional training to CGSB or ASNT qualifications. Western Instruments highly recommends the end user exercises all possible safety precautions, including the use of protective equipment, while operating this or other industrial equipment.

Specifications:

Model: WDV-16

Voltage: 230 VAC 60 Hz

Current: DC – 17 Amps

AC – 20 Amps

Capacity: DC - 0 to 16,000 Amp Turns (Minimum)

AC - 4,000 Amp Turns (Fixed)

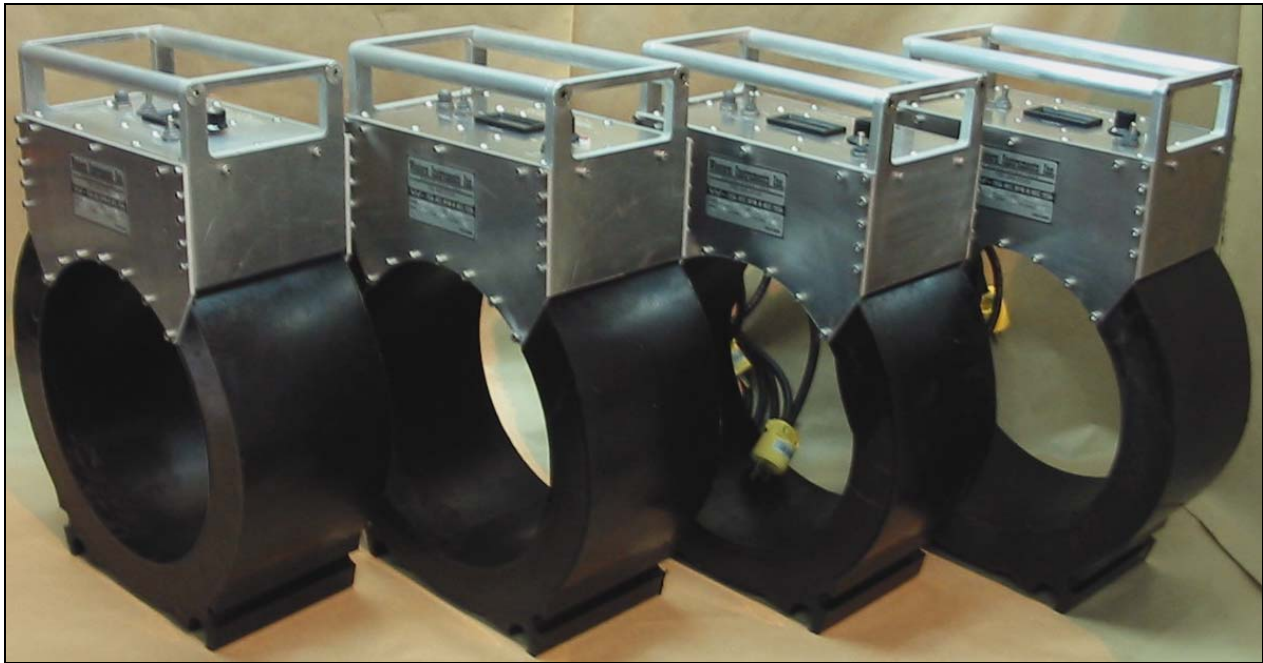
Size: 16" (406mm) Inside Diameter.

Weight: 107 Pounds (49kg)



Western Instruments WD-Series DC Magnetizing Coils - WD Coils Ref

This write-up hopes to aid the reader to understand the rationale behind *Multi-Turn, Low Amperage* Coils. WD-Series Coils have become an Industry Standard for the inspection of Threaded Connections used on Drill Pipe, and other Oil Well Drilling Tools.



The science of Drilling Oil and Gas Wells has advanced tremendously over the last 30 years, to where the Drill Stem does not rotate, but the Drill Bit is driven by a ‘Mud Motor’ fashioned after a Progressive Cavity Pump. This technology has allowed Drillers to Steer the Drill Stem, to where a well might only have a vertical drop of 200 meters, but continues horizontally for over 1000 meters. When this type of Horizontal Well is being drilled, the crew is given accurate telemetry by Monitoring While Drilling (MWD) Instrumentation. This Instrumentation requires the area around the Drill Bit to be free of Magnetism, as the MWD Instrumentation uses the Earth’s Magnetic Field as a reference. WD-Series Coils are renowned for their portability and effectiveness in the Demagnetization of Bottom Hole Assemblies (BHA’s).

Magnetic Particle Inspection Coils are available in two forms;

1. Traditional High Amperage *Mobile Power Packs* (3-6000 Amps), with a few (3 to 5) wraps of heavy 4/0 cable.
2. *Multi-Turn, Low Amperage Coils* with between 1000 and 2000 Turns of small gauge wire, supplied from a Low Amperage Power Supply.

The accepted *Rule of Thumb* for coils to inspect these BHA's is 1,200 Ampere Turns for every inch of Diameter, thus for an average 6 5/8" OD Threaded Connection, the operator requires almost 8000 Ampere Turns of a DC Field. This DC field permits both the Male Threads (Pin End) and Female Threads (Box End) to be full inspected. AC Fields, induced by a Coil, will not provide enough field to inspect Box Ends.

If a High Amperage Mobile Power Pack is used, it would have to be very close to the Workpiece, with perhaps 40 feet of 4-0 Cable (to achieve a 5 Turn Coil). The Amperage, with average losses, would be in the order of 3000 Amps. These Mobile Power Packs, have a high capital cost, and very high Switch Gear installation costs. For economical use, the Power Pack (not looking very mobile at this point) should be run from a 3 Phase supply of at least 440-480 Volts.

Most high performance testing is done with a DC field, but Power Packs become more expensive if they are Full Wave. *Multi-Turn, Low Amperage Coils* produce virtual DC (from full wave rectified voltage), as the Inductance of the 1000+ turn Coil results in a virtual *Full Wave* DC output.

It is recognized, in all industries where Demagnetization (Demag) is performed, that a Reversing and Decaying DC Field provides the best demagnetization. High Intensity AC will provide Demag on smaller parts, however on Heavy Workpieces, with a very strong residual field, an Alternating Current just simply doesn't work.

WD-Series Coils have quickly gained their popularity in the market, because they excel at *Demaging*, not to mention the relatively light weight and the convenience of the Integral Power Supply. With most specialized MPI testing, virtually all parts require a Controlled Field, and that normally means +/-3 Gauss after testing. This demagnetization is achieved manually, with the standard controls, by Reversing and Reducing the DC field between shots. In some cases WDV-Coils are used to introduce a specialized Magnetic Field, where both ends of a 11.3m (37') length of Casing have the same polarity, which produces a very heavy node, of the opposite polarity, in the middle.

Multi-Turn, Low Amperage Coils can have the field Reversed with the use of a Toggle Switch, and Reducing the Field is simply done by turning a knob. With new Coil Controls, the Output Amperage is constantly displayed, and is an unusual feature on a Mobile Power Pack. To reverse the Field on a Mobile Power Pack, both *Eitherend* Connectors on the 4/0 cable must be removed from their receptacles, and their positions reversed when they are plugged back in. Like a *Multi-Turn, Low Amperage Coil*, reversing the Amperage is done by turning a knob. In the end, a *Multi-Turn, Low Amperage Coil*, can perform a Demag Operation in approximately one-fifth the time of a Power Pack with a 5 Turn Coil.

Multi-Turn, Low Amperage Coils, developed by Walter Gunkle in the mid 1950's, are typically supplied from a Separate Power Supply that has an output of about 12 Amperes at 115Volts DC. These early Coils, which are still being manufactured in the same way, use an Aluminum Bobbin for the Coil form with a Separate Power Supply and remain virtually unchanged after more than 50 years. Unfortunately, little

development work was done with this type of Coil until Western Instruments introduced its first WDV-10 in early 2000.

MPI Equipment is not certified by Specification Issuing Organizations (ASTM, ASME, API, etc.), but must comply with the requirements as set out in their documents. The use of a Coil is referred to as *Indirect Magnetization* as the magnetic field is induced into the workpiece. *Multi-Turn, Low Amperage Coils* are also typically employed for *Localized Area* inspection, as described in ASTM E709, and more specifically are defined as *Air Core Coils*. Reference Specifications tend to use complex (and confusing) formulas for the calculation of the *Ampere Turns* required to magnetize a workpiece. These formulas are typically negated in favor of using the faster, more direct method of *Artificial Discontinuities* contained in devices such as a Pie Gauge or Slotted Shims (Castrol Strips or QQL's), which are also approved for *Verifying Systems Performance*.

Western's latest Development in this area is a Coil with the added feature of performing Automatic Reversing DC Demagnetization or *Automatic Ring-Down*®. With the simple press of a button, the Coil starts a series of Shots, with a reverse polarity and reduced amperage. The shots are repeated until the magnetic field is removed from even the heaviest workpiece.

Western currently produces 8, 10, 14, 16, 18, and 25" ID Coils. The jump from 18 to 25" ID, is extensive, where the two larger sizes are primarily designed to Demagnetize Pipeline Pipe prior to Welding. We regularly entertain the production of different ID sizes where the customer requires two units. This is why we produce 16, 18, and 25" Models, that were initially delivered within 8 weeks.