

## Advantages of Continuous Limpet Coil over the Conventional Limpet Coil

Sr. No.	Aspects	Conventional Technique	New Technique
1	Manufacturing Process	Press bending and welding of small pipe split-ups or plate segments to form complete limpet coil.	Continuous Limpet Coil formed by <b>Cold Roll Forming Technique</b>
2	Technical	Half coil ends are work hardened due to Impact de-forming resulting in to a lower strength weld joints with Equipment	Lesser work hardening of material due to stage wise forming process resulting in <b>better weld joint strength</b> with Equipment
3	Technical	Due to limitations of length of the press, number of butt joints are required. Strength of joints are lower than base material	Continuous coil with <b>Lesser or NO butt joints</b> along the reactor
4	Technical	TIG welding if done without purging of inert gas, may cause oxidation of material which is not allowed	No butt joints and thus no possibility of oxidation. Material's <b>Corrosion Resistant Property remains intact</b>
5	Reactor Life	Chance of leakage is higher due to localize work hardening at each butt weld and multiple butt welds along the coil. Reduces overall life of the reactor	<b>Longer life of the reactor</b> due to fewer weld joints
6	Time Saving	More time consuming	Less time consuming – up to <b>60-80% lesser time for tagging</b>
7	Wastage Reduction	Ends of each bent piece remains straight which are cut and scraped. Cutting and welding consumables required at each butt weld	Continuous duly bent limpet coil <b>saves wastage of base material and consumables</b>
8	Costing	High cost	<b>Saves labor cost, cutting/welding cost &amp; cost of wastage</b>
9	Aesthetics	Poor due to multiple butt welds and bending	<b>Better</b> due to continuous finish