



POWERFLO
SOLUTIONS

VALVE SERVICE CAPABILITIES



INDEX

Powerflo Solutions Office Locations.....	2
Background.....	3
Equipment	4
Mobile Workshops.....	5
OVERHAUL & REPAIR OF SAFETY RELIEF VALVES	6
Quality Assurance	7
Safety Valve Overview	9
Scope of Work.....	10
OVERHAUL & REPAIR OF CONTROL VALVES	13
Control Valve Overview.....	14
Scope of Work.....	14
TECHNICAL COMMENTARY	17
Valve Identification	18
Painting	18
Valve Connections	18
Thread Patterns	18
Inspections	18
Contaminated Valves	18
Standards.....	19
SUMMARY OF PAST REPAIR WORK	20
SUMMARY OF PAST CONTROL VALVE REPAIR WORK.....	22
IMAGES	23

POWERFLO SOLUTIONS

**COMMISSIONING SUPERVISION,
OVERHAUL & REPAIR & TESTING
OF**

SAFETY RELIEF VALVES

CONTROL VALVES

REGULATORS

ISOLATION VALVES

2. BACKGROUND

Over the past 90 years, Powerflo Solutions has earned an Australia-wide reputation for engineering excellence. We are leading importers and manufacturers of a wide range of products – principally high quality Control Valves, Safety Relief Valves and Instruments – serving virtually every industry in which liquids or gases are controlled or measured.

While our Engineered Products are inevitably subject to the continual change necessary to meet the latest demands of industry – and often rapid advances in technology – our business philosophy remains the same as it was when our Company was established in 1911, ie *Quality, Service and Value*.

Powerflo Solutions has manufactured Consolidated Safety Relief Valves under licence to Dresser-Consolidated, in Australia for the last 40 years.

To further expand this capability, we acquired the name and assets of a Company known as 'Valve Service Company' in 1993. Valve Service Company was based in Sydney and specialised in the overhaul of Wedge and Parallel Slide Gate Valves, with its main customer base being the petro-chemical installations in New South Wales.

Suitable premises were purchased at Condell Park which would accommodate both the Manufacturing and Valve Service Operations. This facility allowed us to expand our business to suit the needs of our customers. We moved this facility to our Melrose Park Head Office Warehouse and Manufacturing complex in 1999.

Part of our expansion included the design and installation of a high pressure, high capacity air test facility. This Test Rig is unique in Australia. It has sufficient volume to accurately set Valve blowdown. Digital measuring instruments allow us to measure and record both the valve set pressure and blowdown settings in accordance with the Australian Standard AS1271.

We are the only MARC (Masoneilan Accredited Repair Centre) in Australia supporting Masoneilan Control Valves and Level Controllers. As well, we maintain extensive stocks of new Control Valves and spare parts to suit our wide Customer base operating within the Oil and Gas, Power, Mineral Processing and Petrochemical markets, to name a few.

1. EQUIPMENT

MELROSE PARK FACILITY

IDENTIFICATION No.	DESCRIPTION
VM 01	Kasto BSM 253 power hacksaw
VM 02	Okuma LB 1511 CNC lathe
VM 03	Hitachi Seiki 3NE300 CNC mill
	Colchester Centre Lathe with taper turning attachment
VM 04	Hitachi Seiki VA50 CNC milling machine
VM 05	Hafco BM-20E manual vertical mill
VM 06	Herbert WKT 41/25 four-post drill
VM 07	Dashin Prince manual lathe – 1 meter between centres
VM 08	Clemco BNP/300/RPC 1 blast cleaning machine
VS 01	Webster & Bennett vertical borer – 900mm x 600mm travel
VS 02	Denham lathe – 2 meters between centres
VS 04	Heald 25A rotary table grinder
VS 05	Hafco SBD20 pedestal bench drill
VS 06	Burwell shot blast cleaner
VS 07	Godfrey bead blast cleaner
VS 11	Snow ring grinder
VS 12	Ensign pedestal drill
VM 16	Clark 2-tonne fork lift
VS 13	B & G hydraulic press
VS 14	ESAB LTF150 TIG welder
VS 15	CIG oxygen / acetylene set
VS 16	High Pressure air compressor (21,000kPa)
VS 17	Servex air compressor (1600kPa)
Lapping Equipment	
VM 09	Lapmaster 14inch lapping machine
VS 03	August Hauerwas lapping machine – gate, Globe valves
	Lapmaster 22inch lapping machine
	14 inch cast iron lapping plate
	14 inch diamond impregnated lapping plate
	Optical flatness tester – (lightbands)
VM 10	Enerpac IPP-2532 pedestal press
	Spray Paint booth – air extraction.
Testing Stations	
VS 18	APS pressure test rig for control valves (air)
VM 13	APS safety relief valve test rig (high capacity)
VS 19	APS pressure test rig for Low Pressure/vacuum vent valves (air / vacuum)
VM 11	APS safety relief valve test rig (low capacity)
VM 12	APS safety relief valve test rig (low capacity)
VM 14	APS Hydro test rig (water) – 70,000kPa
VM 15	APS Hydro test rig (water) – 20,000kPa
	All pressure gauges NATA certified

MOBILE WORKSHOPS

40ft Container

- High capacity air test stand up to 15000kpa, valve sizes from 15mm to 300mm (under construction)
- Low capacity high pressure air and water test stand up to 35000 kpa air & 50,000kpa water, valve sizes from 15mm to 400mm
- Pressure and vacuum test stand for tank vent valves, valve size ranging from 50mm to 450mm.
- Lapping plates
- Centre lathe
- Spray booth
- Pedestal drill
- Wire wheel & polishing wheel
- Over head crane
- Compressors
- Grit blaster
- Hand tools

20ft Container

- Centre lathe
- Low capacity high pressure air and water test stand up to 35000 kpa air & 50,000kpa water, valve sizes from 15mm to 400mm (under construction)
- Wire wheel & polishing wheel
- Lapping plates
- Grit blaster

2 x Mobile 4WD

- Specifically designed for the Origin Contract.

OVERHAUL & REPAIR

OF

SAFETY RELIEF VALVES

2. QUALITY ASSURANCE

Powerflo's Valve Service has achieved Accreditation to ISO9001:2008 for manufacture and repair of Safety/Relief valves overhaul and servicing of industrial valves. A copy of Certificate No. 201531 is attached.

BUREAU VERITAS
Certification



Certification

Awarded to

POWERFLO SOLUTIONS PTY LTD

1 MARY STREET

MELROSE PARK, NEW SOUTH WALES, AUSTRALIA

Bureau Veritas certify that the Management System of the above organisation has been audited and found to be in accordance with the requirements of the management system standards detailed below

STANDARD

AS/NZS ISO 9001:2008

SCOPE OF SUPPLY

DESIGN, DEVELOPMENT, MODIFICATION, REFURBISHMENT, SERVICE IN-FIELD REPAIRS, TECHNICAL SUPPORT, MANUFACTURE AND SUPPLY OF SMALL, MEDIUM AND LARGE PRESSURE RELIEF VALVES, INDUSTRIAL AND CONTROL VALVES, REGULATORS AND ACTUATORS FOR A RANGE OF INDUSTRY SECTORS INCLUDING OIL AND GAS, PETROLEUM, GAS TURBINE AND POWER GENERATION, WATER AND MINING OPERATIONS. SUPPLY, SERVICE AND CALIBRATION OF PRESSURE AND VACUUM GAUGES AND MANUFACTURE OF PROCESS INSTRUMENTATION.


Original Approval Date : **07 JANUARY 1996**

Subject to the continued satisfactory operation of the organisation's Management System,
this certificate is valid until : **17 MARCH 2017**

To check the validity of this certificate please call : **Bureau Veritas Australia Pty Ltd**

Further clarification regarding the scope of this certificate and the applicability of the management system requirements may be obtained by consulting the organisation

Certificate Number: **AUS14000080**


Andrew Mortimore
General Manager - Bureau Veritas Certification

Date: **15 April 2014**

Managing office: Bureau Veritas Pty Ltd, 3/435 Williamstown Road,
Port Melbourne, Victoria, 3207

Issuing office: Bureau Veritas Pty Ltd, 3/435 Williamstown Road,
Port Melbourne, Victoria, 3207



3. SAFETY VALVE OVERVIEW

Our High Capacity Test Rig is unique in Australia. It ensures accurate set pressure with full valve lift. This Test Rig also has sufficient volume to accurately set the valve blowdown. The Heise Digital Pressure Gauge read out allows us to record accurately the valve set pressure and blowdown setting.

Other repairers that offer on-site Facilities, cannot, by the use of nitrogen gas bottles, provide adequate volumes that would ensure that the Valve obtains a full lift. This gas bottle method provides at the very best a simmer point, not the lift pressure and thus cannot comply with AS1271 Set Pressure Accuracy.

With the Overhaul & Repair of Safety Relief Valves, we offer the following capabilities.

After repairing your valves we set them in accordance with Australian Standard AS1271, which requires the measuring of blowdown*. This can only be achieved by setting the valves on our test Rig or by lifting the valves and setting them on your plant which can obviously cause you noise, environmental problems and production losses.

As we manufacture and stock steel / bronze and stainless steel safety valves, we may be in a position to supply a new valve from stock in the event of a valve being unrepairable.

** Blowdown – The difference between set pressure and reseating pressure of a pressure relief valve, expressed as a percentage of the set pressure, or pounds per square inch gage.*

4. SCOPE OF WORK

- 1 Test check set pressure (pressure relief valves)
- 2 Strip valve totally, grit / bead blast and inspect
- 3 Machine end connections if required *
- 4 Machine body seat(s) if required *
- 5 Lap body seat(s)
- 6 Machine valve member seat(s) if required *
- 7 Lap valve member seat(s)
- 8 Hand-lap mating seat surfaces
- 9 Machine body / bonnet joint faces *
- 10 Machine and polish spindle if necessary
- 11 Pressure test pipeline valves; adjust and set pressure relief valves
- 12 Reassemble and paint
- 13 Complete documentation and prepare for despatch

* Additional work that will be quoted at time of repair.

**POWERFLO SOLUTIONS PTY LTD**

ENGINEERED CONTROL VALVES, SAFETY DEVICES & PROCESS INSTRUMENTATION

Page 1 of 2

Inspection and Test Report for Safety and Relief Valves

Customer:			
Sales Order No:		Work Order No:	
Cust P/O No:		Report No:	

SUBJECT:**TECHNICAL DATA**

Valve Serial No:		Make:	
Tag No:		Model:	
Customer Serial No/ Equipment No:		Style:	
Size:	Inlet	Gagged	
	Outlet	Date Last Test (On Tag):	
Class # :	Inlet	Last Set Pressure(On Tag):	
	Outlet	Required Set Pressure:	
Connections:		RF-FF-NPT-BSP	Test Medium:
Service:			

PRE-TEST RESULTS

Test	Result (kPa) 1 st	Result (kPa) 2 nd	Date dd/mm/yy	Comment
Pop Pressure				
Reseat Pressure				
Leak Test Pressure				

FINAL TEST RESULTS

Test	Final Result (kPa)	Final Reseat (kPa)	Date dd/mm/yy	Comment
Pop Pressure				
Leak Test Pressure				

TEST GAUGE IDENTIFICATION**NOTES/COMMENTS**

Gauge Identification:		
Calibration Date:		

Tested in accordance with API 576, API 527 and Australian Standard 1271.

Service Technician		Approved Signatory:	
Signature:		Signature	
Date:		Date	
GTC Accreditation		GTC Accreditation	

Head Office: Private Mailbag 56, Milrose, NSW 2114, Australia

National Hotline: (61) 1800 658 701

Website: www.powerflo.com.au

QUALITY ASSURANCE FORM

F 035AA

REV 5

Updated 24/05/13


POWERFLO SOLUTIONS PTY LTD

ENGINEERED CONTROL VALVES, SAFETY DEVICES & PROCESS INSTRUMENTATION

Page 2 of 2

Inspection and Test Report for Safety and Relief Valves

Customer:			
Sales Order No:		Work Order No:	
Cust P/O No:		Report No:	

Valve Tag Plate:

--

Manufactures Tag Plate:

--

As Received Condition:

--

Final Photograph of Valve:

--

Service Technician		Approved Signatory:	
Signature:		Signature	
Date:		Date	
GTC Accreditation		GTC Accreditation	

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 Website: www.powerflo.com.au

QUALITY ASSURANCE FORM

F 035AA

REV 5

Updated 24/05/13

OVERHAUL & REPAIR

OF

CONTROL VALVES

5. CONTROL VALVE OVERVIEW

We are the Australian MARC Repair Agents of Masoneilan Control Valves. We stock both spare parts and new valves; in the event of a valve being unrepairable we will be able to replace it with a new valve in most instances.

6. SCOPE OF WORK

For Control Valves

Control Valve Sub-Assembly:

- 1 Components marked to ensure correct orientation upon reassembly, and are tested, to reflect an 'as received' condition.
- 2 Complete disassembly.
- 3 Grit Blast and inspect all pressure containing components.
- 4 Supply written inspection report.
- 5 Recut, polish and Lap seat angles.
- 6 Hone Packing bore area to ensure no leakage through packing box.
- 7 Remachine flange gasket surfaces.
- 8 Replace all soft parts and hard parts as required.
- 9 Reassemble.
- 10 Test and Calibrate.
- 11 Paint.

Actuator & Associated Instrumentation

- 12 Complete disassembly and replace soft parts and hard parts as needed.
- 13 Reassemble.
- 14 Set Bench Range and calibrate.
- 15 Paint.

Re-Assembly

- 16 Remount all accessories.
- 17 Replace all tubing and fittings with stainless steel tube/fittings.
- 18 Test and calibrate valve assembly, including accessories.
- 19 Install new name tag with Work Order No. and other pertinent information.
- 20 Prepare Test Certificate for the Customer and register in Valve Keep.



Main Address: 1 Mary Street, Melrose Park
NSW, Australia, 2114
Head Office Tel. No.: (02) 9877-8100
National Toll Free: 1300 658 701
ABN 71 000 004 884

CONTROL VALVE TEST SHEET

P&ID NO.: _____ Order no.: _____

Line No.: _____ File No.: _____

Customer:					W/O No.:					Date:									
Manufacturer:					Actuator Type:					Diaph		Piston		Elect		Hyd			
Model No.:					Stroke:					Bench Set:									
Serial No.:					Fail Safe Action:					Close		Open		Last					
Tag, No.:					Flow Direction:					To Close			To Open						
Type:	Ball	Plug	Globe	Butterfly	Positioner Model:														
Packing	Braid	V-Ring	PTFE	Graphite	CV:														
Body Size:			Body Rating:		Characteristic:														
Plug Material:					Seat Material:														
AS FOUND/DATA										ACTUATOR									
VALVE					Good	Dirty	Worn	Scored	Damaged	ACTUATOR					Good	Dirty	Worn	Scored	Damaged
Valve Body										Actuator									
Inlet Flange										Bush									
Outlet Flange										Actuator Yoke / Bracket									
Bonnet										Casing									
Studs & Nuts										Seals / O-rings									
Plug / Ball										Nuts & Bolts									
Seat										Diaphragm									
Stem / Shaft										Diaphragm Plate / Piston									
Bearings										Spring									
Seals / O-rings										Actuator Stem / Shaft									
Packing Flange										Adjusting Screw									
TEST DETAILS					TEST RESULTS					Yes	No	Good	Bad						
Test Rig:		Test Fluid:			Pre-test														
Test Gauge Calibration Date:					Did the valve leak?														
Gauge ID:					Is the inlet & outlet clean?														
					What is actual external valve condition?														

"AS FOUND" PRE OVERHAUL CALIBRATION DETAILS

Bench Range:	Travel/Rotation	KPa	Regulator Setting:	KPa
Position Range:	Travel/Rotation	KPa	Valve Travel Time:	
Valve Position as found:	OPEN	CLOSE	OTHERS	Details:
Allowable Leakage:	L/Min	Result:	L/Min	Test Pressure
Leakage Class:				KPa
Accessories:				PASS/FAIL



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Comments: _____

CONTROL VALVE TEST SHEET

P&ID NO.: _____ Order no.: _____

Line No.: _____ File No.: _____

WORK DONE						ACTUATOR					
VALVE	Good	Dirty	Worn	Scored	Replaced		Good	Dirty	Worn	Scored	Replaced
Valve Body						Actuator					
Inlet Flange						Bush					
Outlet Flange						Actuator Yoke / Bracket					
Bonnet						Casing					
Studs & Nuts						Seals / O-rings					
Plug / Ball						Nuts & Bolts					
Seat						Diaphragm					
Stem / Shaft						Diaphragm Plate / Piston					
Bearings						Spring					
Seal / O-rings						Actuator Stem / Shaft					
Packing Flange						Adjusting Screw					
TEST DETAILS						TEST RESULTS					
Test Rig:		Test Fluid:				Final Test	Yes	No	Good	Bad	
Test Gauge Calibration Date:						Did the valve leak?					
Gauge ID:						Is the inlet and outlet clean?					
						What is actual external valve condition?					

"AS LEFT" POST OVERHAUL CALIBRATION DETAILS

Bench Range:	Travel/Rotation	KPa	Regulator Setting:	KPa
Position Range:	Travel/Rotation	KPa	Valve Travel Time:	
Valve Position as found:	OPEN	Close	OTHERS	Details:
Input Signal:	0	25	50	75
Valve Position %:				

"AS LEFT" POST OVERHAUL VALVE DETAILS

Leakage Test Result:	L/min	Test Pressure:	KPa	PASS/FAIL
Leakage Class:				
Body Hydro Test Pressure Result:	PASS/FAIL	Test Pressure:	KPa	
Torque:		Calibration:		

Accessories: _____

Comments: _____



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TECHNICIAN:		CHECKED BY SUPERVISOR:	
DATE:		DATE:	

VALVE PHOTO'S

Valve Tag No.

Valve Initial Condition

Valve Overhauled and Tested

TECHNICAL COMMENTARY

7. VALVE IDENTIFICATION

All valves are tagged with metal (316 s/s) tags to show the set pressures (if applicable), date of testing and the contractor's name, and/or a lead seal fitted using stainless steel wire.

8. PAINTING

All valves are grit blasted to remove all rust, oil, grease etc.

We have included in our pricing one coat to be painted on all valves.

Stainless steel/brass/bronze body valves will be cleaned but left unpainted.

9. VALVE CONNECTIONS

All valve inlets and outlets of the valve will be sealed for shipment.

10. THREAD PATTERNS

All threads will be lubricated and sealed during painting so that paint does not clog thread patterns.

11. INSPECTIONS

Powerflo's Valve Service will be available for your personnel to inspect valves at any pre-arranged time at our premises.

12. CONTAMINATED VALVES

All valves to be overhauled must be de-contaminated and chemical data safety sheets supplied by the owner prior to shipment to our premises.

13. STANDARDS

Powerflo Valve Service is AS/NZS ISO9001:2008 Accredited and all repairs are in accordance to the Standards below where applicable.

AS 1271	Valves, water gauges and other fittings for boilers and unfired pressure vessels.
AS 2129	Flanges for pipes, valves and fittings
AS 3788	Boilers and pressure vessels – in service inspection
API 527/576	Commercial seal tightness of safety relief valves with metal to metal seals.
ANSI/FCI 70.2	Flanges for pipes, Valves and fittings seat leakage.

Powerflo Solutions

Valve Services

Summary of Past Repair Work

<u>Contractor/Project</u>	<u>Product</u>	<u>Description</u>
S.E.C.V. Yallourn "W" Stage 1 Units 1 & 2	Crosby-JO-Series Farris Okano – Supero	Repairs and Overhaul complying with AS 3788 Deaerator steam, hot/cold Reheater Safety valves. Inlet connections 50mm-200mm
S.E.C.V. Hazelwood Power Station	Dresser-Dewrance	Repairs and overhaul. Boiler Color Port Water Level Gauges
B.H.P. Port Kembla	Dresser-Dewrance	Repairs and overhaul, complying with AS3788 Boiler-Superheater Drum Safety Valves
Yallourn "W" Power Station	Dresser-Dewrance	Repairs and overhaul 200mm Boiler Feed Pump Check Valves, Stellite depositing
Austa Electric QLD Callide "A" Power Station 4 Units	Dewrance Hopkinsons	Refurbishment 4 Boiler Feedheating Plant Units <ul style="list-style-type: none"> • 20 Boiler/Superheater Drum Safety Valves • 40 Feedheating Plant Relief Valves
ICI Botany Operations Alkatuff Plant	Various Brands of Safety Relief	Major Shut down – Chemical Plant <ul style="list-style-type: none"> • 122 Safety Relief Valves • Pressure/Vacuum Vents
Shell-Montell PPU No. 2 Unit Clyde, NSW	Consolidated Farris Crosby Fukui Safety Relief Valves Neles-Jamesbury Ball Valves	Major Shut down – Chemical Plant Safety Relief, Trunnion Mount Ball and Changeover Relief Valves, sizes 15mm through to 200mm

<u>Contractor/Project</u>	<u>Product</u>	<u>Description</u>
Department of Defence (Navy Supply)	Dewrance John	High Pressure, 900lb Class, Parallel Slide and Quick Acting Blow Down Valves
Transfield-NEPCO Joint Venture Smithfield, NSW Co-Generation Facility	Consolidated Crosby	Boiler and Process Plant Safety Relief Valves Inlet connections 80mm to 200mm
Queensland Nickel P/L Townsville, QLD	Consolidated	Boiler Drum Safety Valves
Clyde Babcock Hitachi ISIS and Macnade Sugar Mills QLD	Consolidated	On-site commissioning, Boiler/Superheater Safety Valves
Energy Developments Pine Creek Power Station QLD	Consolidated	On-site commissioning, Boiler/Co- Generation Safety Relief Valves

Powerflo Solutions

Valve Services

Summary of Past Control Valve Repair Work

<u>Contractor/Project</u>	<u>Product</u>	<u>Description</u>
Akzo	Masoneilan	Various Camflex II
Qenos	Various	<100 Masoneilan Globe valves up to ANSI 2500#. Also Fisher and Valtek Valves in the Surfactants Plant.
Minara Resources	HORA	30" 900# HORA Valves
Qenos	W&T	20" 2500# PRDS Valves
Nestles	Masoneilan	Camflex II
BHP	Various	ARCA, Valtek, Fisher
Uncle Ben's	Masoneilan	Camflex II and Samson
Manildra Ethanol	Various	Fisher, Samson, M/N
Visy Paper	Various	200 various Masoneilan Valves including Masoneilan, Fisher, Samson and HORA Power Plant Valves.
Yokogawa	Masoneilan	Many 35K and 21K Valves
Buchmann Laboratories	Masoneilan	Camflex II
Sammy's Road Service	Masoneilan	Camflex II
Bridgestone	Masoneilan	Camflex II
Berrivale Orchards	Masoneilan	Camflex II
Kimberley Clark	Masoneilan	Camflex II
S.A. Generation Corporation	Masoneilan	Varimax
Honeywell	Masoneilan	Camflex II
Q.U.F.	Masoneilan	Camflex II
Pinkenba Terminal	Masoneilan	Camflex II & Lincoln Log Valves up to 2500# Class 8" NB



<u>Contractor/Project</u>	<u>Product</u>	<u>Description</u>
Mauri Yeast	Masoneilan	Varipak 28000 Series
Kemcor OLEFINS	Masoneilan	All Types of Globe Valves





High Pressure / Capacity Air Test Stand
Ensures accurate set pressure and blow down adjustments complying AS1271



Control Valve Repair and Assembly Area



Pressure Relief Valve Assembly and Repair Area



40ft Mobile Workshop



40ft Mobile Workshop on site BHP Yabulu





20ft Mobile Workshop



Electronic Valve Testing Unit



Mobile Service Unit-4WD Truck



Powerflo Service Team at work on a Plant Outage



Brisbane Workshop



Miles Field Service Fleet Queensland



Units on Site Yellow Bank Gas Field



Unit in Operation Coal Seam Gas Field



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Head Office & Manufacturing

Safety & Relief Valve Manufacture & Service

FICO Instrument Manufacture & Service

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Valve Service

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