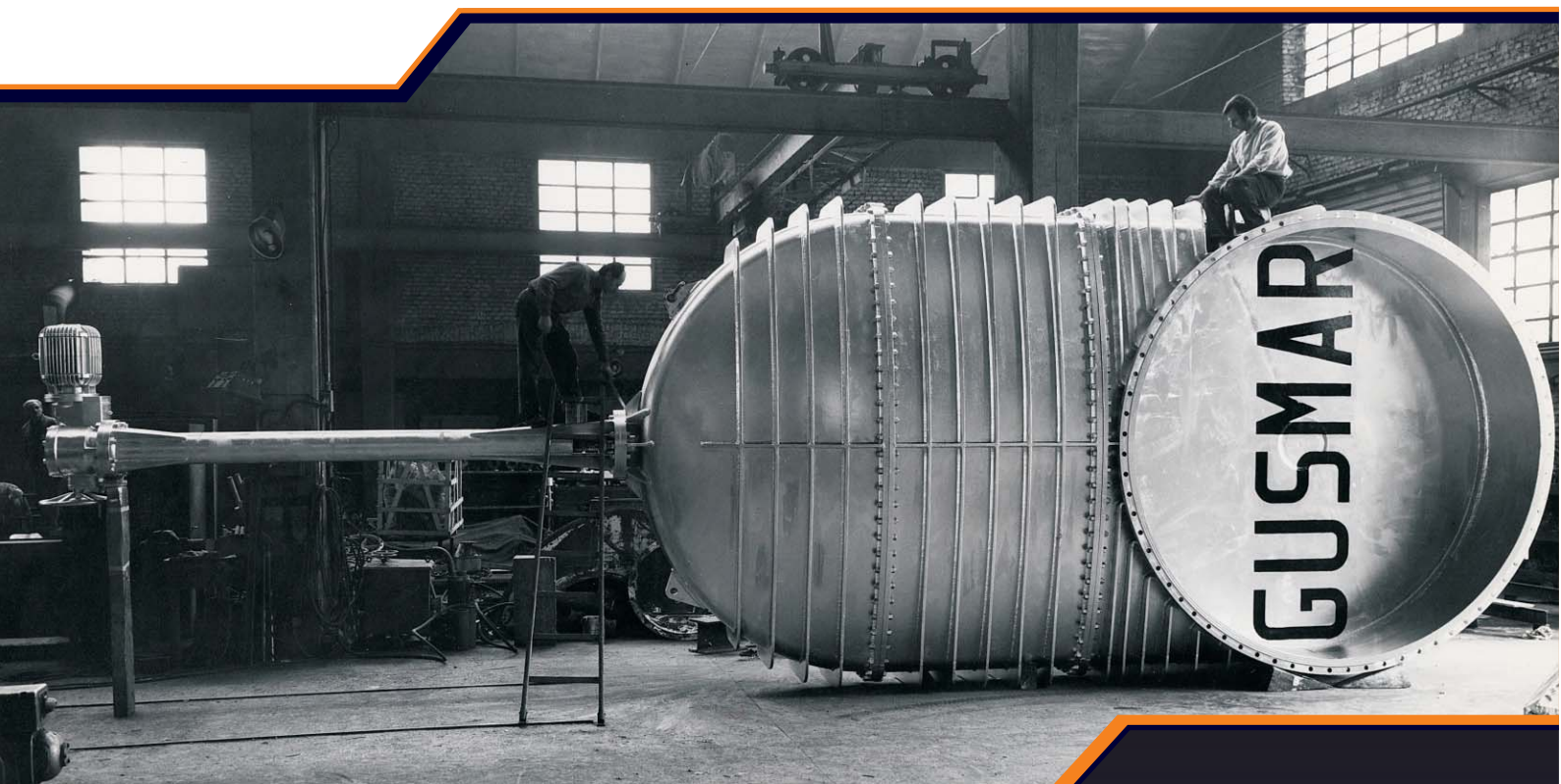


PROUDLY MADE IN ITALY



**GUSBERTI MARCELLO**

VALVES SINCE 1904



**WWW.GUSMAR.IT**



# GUSBERTI MARCELLO

Gusberti Marcello, company established in 1904, for over 100 years has been designing, manufacturing and selling with GUSMAR brand industrial valves for different applications (oil, water, steam, sea water, chemical, petrochemical, food, power generation, gas...). Gusberti Marcello produces also SELLA valves, and their spare parts, as in 80's bought also all know-how, drawings, patterns and stock of SELLA company. The company is highly regarded on the Italian and international market, especially for quality, reliability of products, and flexibility of production. Gusberti Marcello prides itself on the ability to produce ANSI and DIN valves according to the individual needs of each customer on specific requirements most than on mass production. Production covers valves size from 1/2" to 80" in Steel, Stainless Steel, Duplex, Superduplex, Alu-Bronze, Nickel based alloys and others alloyed steels.



## Gate Valves

Size range: 1/2" to 54"  
Pressure Class Range: 150 to 2.500



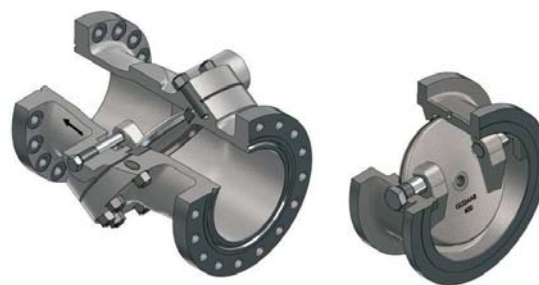
## Globe Valves

Size range: 1/2" to 20"  
Pressure Class Range: 150 to 2.500



## Swing Check Valves

Size range: 1/2" to 48"  
Pressure Class Range: 150 to 2.500

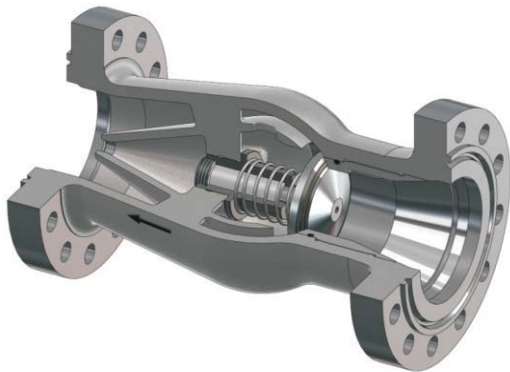


## Tilting Check Valves

Size range: 2" to 36"  
Pressure Class Range: 150 to 2.500

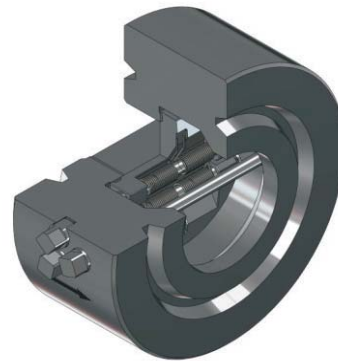






### Nozzle Check Valves

Size range: 2" to 36"  
Pressure Class Range: 150 to 2,500



### Dual Plate Check Valves

Size range: 2" to 36"  
Pressure Class Range: 150 to 2,500



### Bellow Sealed Valves

Size range: 1/2" to 24"  
Pressure Class Range: 150 to 300



### Cryogenic Valves

Size range: 1/2" to 24"  
Pressure Class Range: 150 to 2,500



### Pressure Seal Valves

Size range: 2" to 24"  
Pressure Class Range: 600 to 2,500



# PROCESS: from Design to Delivery

## Design

Gusberti Marcello's design process is performed with traditional methods by a team of skilled engineers with many years of experience in valves environment. Design is strictly based on compliance to standards.

During the past years, know how is accurately maintained, structured and enriched by production feed-back. In fact one of key point of Gusberti Marcello's design department is the strong interaction with production department, as the "PROGRAM manager" has responsibility of the whole result during all over the process, included the production process till the final control.

Design characteristics are settled up to suit the working conditions, provide a high safety factor and prolonged, efficient service, as old customers can appreciate.

## Pattern Fitting

Gusberti Marcello assigns to this activity strong attention, as it is considered the base of a good result of the valve casting. Construction of patterns is in accordance with the most up-to-date requirements of good practice of casting. In fitting an old or in building a new pattern, this preliminary activity is realized by Gusberti itself or by specialized suppliers

The company has a stock of hundreds of models of valves.

## PRODUCTION PROCESS

### In-Coming Controls

Our suppliers are historically tested and developed, but anyway Gusberti Marcello performs in-coming controls on every product to check the compliance of the supply to the order.

### Components Machining

Casting and bars for critical components are completely worked inside the plant. Working components are run out on tooling machine both traditional then CNC. The company plant has got about 30 machines everyone of high reliability, included ADVANCED MACHINING CENTERS suitable for working of big body valves till DN 1400, working on 6 axes, which have very high performance on precision, timetable production and on set up flexibility.

Overlay process, where necessary, are carried out by ASME section IX qualified operators, both on automatic and manual welding machine.

### Production Controls

On all over the previous stages, production department conduces rigid inspections of dimensions, finishing, fitting of the valve parts, welding process results with the production responsible supervision. Where required casting can be subjected to Non-Destructive Test, including magnetic particle, liquid penetrant and radiographic examination. The gauge employed for measurement and test are manometers, thickness meter UT, durometer, micrometers for internal and external, comparators, sliding gauges, everyone periodically verified by calibration procedure.

## Supply and Job Management

The supply process (materials and equipment) is set by the "JOB manager". Gusberti Marcello's suppliers panel is composed by Italian suppliers for most part of components. Most critical supply are casting and steel bars. As casting suppliers Gusberti Marcello buys from Italian and European foundries with accreditation ISO 9001 and with big experience in the area of valves casting, each one specialized in particular kind of steel. All the foundries are provided by a test laboratory to carry out the whole panel of tests requested by the 3.1 certification according to UNI EN 10204, and more (e.g. radiographic controls)

Inspections of rough casting are carried out to ensure soundness and uniformity. The compliance of materials to the orders are strictly checked, physically and chemically.

Relating to steel bars Gusberti Marcello buys from biggest producers selected for type of steels; all the materials bought are provided by a 3.1 certificate according to UNI EN 10204.



### Pre-Assembly and Assembly

In the different steps of production working components are controlled to obtain a correct coupling between the parts as critical components are co-worked a pre-assembled. Final assembly is carried out by experienced operators.

### Final Inspection

Final inspections are conducted by qualified operators on 100% of valves before painting (where required) and include dimensional, visual, but especially strict hydraulic pressure tests of all seating surfaces, according to prescriptions and acceptance criteria of required specification. Hydraulic tests are performed on specific test machines that allow to test the seals, and the body of the valve.

All the instruments for the tests are periodically controlled by the specific calibration procedure.







## Warehouse

We have a 9000 m<sup>2</sup> warehouse provided of thousands of inventoried valves through electronic procedures that allow the constant traceability of the product in addition to an automatic replenishment of stocks in order to guarantee a mix of materials always available. Our stock is composed mainly by carbon steel gate, globe and check valves till NB 24" but also a good availability of stainless steel valves till NB 12"; furthermore we have a big inventory of various semi-finished components ready for assembly that allow us to fulfill in short time orders with special requirements.



## Quality

The **main quality controls** carried out by Gusberti Marcello s.r.l. are:

### Dimensional inspection

All necessary equipment in house

### Non-Destructive Testing

MT: Magnetic particles examination  
PT: Dye penetrant examination  
UT: Ultrasonic examination  
RT: Radiographic examination

### Pressure Test according to

API598 – ISO5208 – BS6755 – API6D  
ASME B16.34 – EN12266  
High Pressure Hydraulic Shell test  
High Pressure Hydraulic Back Seat test  
High Pressure Hydraulic Seat test  
Low Pressure Pneumatic Seat test  
Functional test

### Test equipments

- 2 Hydraulic & Pneumatic horizontal testing unit for valves DN 2" to 30" up to Class 2.500
- 3 Hydraulic & Pneumatic vertical testing unit for valves DN ½" to 8" up to Class 2.500
- 1 Hydraulic & Pneumatic vertical testing unit for valves DN 1½" to 12" up to Class 600
- 2 Hydraulic & Pneumatic vertical testing unit for valves DN ½" to 4" up to Class 600

### Chemical Analysis

PMI: Positive material identification  
Geometrically Optimized Large Area Drift Detector

### Mechanical Tests

Hardness test  
Charpy-V impact test

### Available also:

Fugitive emission test (helium/nitrogen)  
Cryogenic test  
Corrosion test  
Cleanliness for oxygen application  
Fire Safe test  
High pressure gas test  
Hyperbaric test for subsea application  
Torque test

# Certifications

ISO 9001:2015  
PED DIRECTIVE 2014/68/EU  
ATEX DIRECTIVE 2014/34/EU  
FIRE SAFE ISO 10497  
FIRE SAFE API 6FD  
FUGITIVE EMISSION API 624  
FUGITIVE EMISSION ISO 15848-1/2

## Our Brands



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