

# Controlled Bolting with Hydraulic Torque and Tensioning Training Course

20 – 24 December 2026
Muscat

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Training Center

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**Ref:** 1723_229435 **Date:** 20 – 24 December 2026 **Location:** Muscat **Fees:** 6500 Euro

## Overview

Controlled Bolting with Hydraulic Torque and Tensioning Training Course is a one-week course for maintenance, shutdown, inspection, and supervision teams, who leave with a Controlled Bolting Job Pack. Participants connect bolted-joint behaviour with method selection, safe hydraulic-tool setup, pressure and load calculations, flange alignment, tightening sequences, inspection, and traceable records. Simulated practice develops disciplined execution without granting authorization for unsupervised site work. Agile Leaders Training Center presents controlled bolting with hydraulic torque and tensioning.

## Who Should Attend

- Functions responsible for mechanical maintenance and pressure-boundary joint assembly
- Teams responsible for shutdown preparation, execution, and reinstatement
- Functions responsible for rotating-equipment flange integrity and leak prevention
- Teams responsible for bolting-tool selection, setup, calibration, and control
- Functions responsible for inspection, quality records, and work acceptance
- Supervisory teams responsible for safe controlled-bolting work

The course assumes participants already support industrial maintenance or bolted-joint work and leaves out equipment repair, live-plant authorization, independent competence certification, and unsupervised site qualification.

## Departments and Industries

The course supports departments and industries that assemble, maintain, inspect, or supervise critical bolted joints.

- Mechanical maintenance and reliability departments
- Shutdown, turnaround, and project-execution teams
- Oil, gas, petrochemical, and process operations
- Power generation, utilities, and renewable-energy assets
- Marine, heavy engineering, and industrial construction
- Quality assurance, inspection, and technical-services functions

## Learning Objectives

By the end of this course, participants will be able to:

- Analyze preload, relaxation, friction, and load-loss behaviour
- Compare hydraulic torque wrench operation with hydraulic bolt tensioning
- Apply equipment-selection, setup, reaction, and exclusion-zone checks
- Use pressure-to-load calculations and controlled tightening sequences
- Diagnose alignment, leakage, galling, and uneven-load indications
- Build inspection, calibration, traceability, and completion records

## Course Agenda

## Day 1: Bolted-Joint Foundations

- Bolted-Joint Load Path and Joint Diagram
- Preload, Clamp Load, Service Load, and Safety Margin Model
- Friction, Lubrication, Embedment, Relaxation, and Load-Loss Map
- Flange, Gasket, Fastener, Nut, and Washer Identification Checklist
- ASME PCC-1 Assembly-Practice Context and Job-Scope Boundary

## Day 2: Method and Equipment Selection

- Torque-Control versus Direct-Tension Method Selection Matrix
- Hydraulic Torque Wrench, Cassette, Socket, Pump, and Hose Configuration
- Hydraulic Bolt Tensioner, Bridge, Puller, Nut Driver, and Pump Configuration
- Tool-Capacity, Access, Stroke, Bolt-Spacing, and Coverage Selection Sheet
- Calibration Certificate, Pressure Gauge, and Traceability Review

## Day 3: Planning and Calculations

- Target Bolt Load, Bolt Stress, and Allowable-Limit Calculation Sheet
- Torque-to-Preload and Pressure-to-Torque Conversion Method
- Tensioner Area, Hydraulic Pressure, Load Transfer, and Loss Allowance Calculation
- Flange Alignment, Gasket Position, Gap, Parallelism, and Readiness Checklist
- Cross-Pattern, Multi-Pass, Circular-Pass, and Simultaneous-Tensioning Plan

## Day 4: Safe Execution and Verification

- Stored-Energy, Pinch-Point, Hose, Reaction-Arm, and Exclusion-Zone Risk Check
- Hydraulic System Inspection, Connection, Bleeding, Pressurization, and Depressurization Sequence
- Bolt Numbering, Tool Position, Pass Control, and Completion Marking Method
- Residual Load, Breakout, Rotation, Gap, Leakage, and Visual Inspection Indicators
- Nonconformance, Troubleshooting, Escalation, and Controlled Bolting Job Documentation

## Day 5: Simulated Practice and Capstone

- Exercise: Flange Readiness and Joint-Component Inspection
- Exercise: Hydraulic Torque Wrench Setup and Reaction-Point Verification
- Exercise: Hydraulic Bolt Tensioning Pressure and Coverage Plan
- Exercise: Multi-Pass Execution, Inspection, and Nonconformance Response
- Capstone Exercise: Controlled Bolting Job Pack

## Practical Exercises

The course uses suggested activities with simulated tools, joint data, diagrams, and fictional maintenance scenarios.

- Suggested activity: compare torque and tensioning options with an access, capacity, risk, and accuracy decision matrix.
- Suggested activity: calculate target load, hydraulic pressure, pass values, and loss allowances from a controlled job sheet.
- Suggested activity: inspect a simulated flange arrangement and record alignment, gasket, fastener, lubrication, and readiness findings.
- Suggested activity: execute a tabletop bolting sequence and complete inspection, traceability, exception, and handover records.

## FAQs

### Who suits controlled bolting with hydraulic torque and tensioning training, and what does it assume?

It suits maintenance, shutdown, bolting, inspection, rotating-equipment, and supervisory personnel who already support industrial mechanical work. The training assumes basic familiarity with fasteners, flanges, workshop safety, and job procedures.

### How does controlled bolting training differ from a basic torque-wrench course?

Controlled bolting training integrates joint behaviour, hydraulic torque, direct tensioning, calculations, sequencing, calibration, inspection, troubleshooting, and documented acceptance. A basic torque-wrench course usually concentrates on one tool and introductory tightening practice.

### When should hydraulic bolt tensioning be selected instead of hydraulic torque?

Hydraulic bolt tensioning is considered when access, bolt spacing, protrusion, joint geometry, simultaneous loading, friction sensitivity, accuracy requirements, and available equipment favour direct axial loading. The approved job procedure remains decisive.

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## Why can hydraulic torque produce different bolt preload values?

Hydraulic torque can produce variable preload because friction at threads and bearing faces, lubrication condition, surface finish, tool accuracy, alignment, and joint relaxation affect how applied torque becomes bolt load.

## What records support a controlled bolting job?

A controlled bolting job is supported by joint identification, component checks, target values, approved sequence, tool and calibration references, operator entries, pass completion, inspection results, deviations, escalation decisions, and handover acceptance.

## Conclusion

Participants take a Controlled Bolting Job Pack back to work. It combines a method-selection matrix, readiness checklist, calculation sheet, tightening plan, safety controls, inspection record, nonconformance log, and handover form. The pack strengthens repeatable preparation, execution, verification, and traceability while keeping authorization and site-specific procedure decisions with the responsible organization.