HARALD LIEBERS
BEHÄLTER - APPARATEBAU GmbH

Quality is the strongest bond. Company Portrait

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Position	Name
Managing Director	Mr.Liebers
Sales	Mr.Böttger,Mr.Köhler
Design/ Project Processing/ Work preparation	Mr.Pflister,Mr.Viertel,U. Mr.Wittig, Mr.Viertel,M. Mr. Pella, Mr. Dreier Mr. Barthold, Mr. Uhlig
Strength calculations	Mr.Pflister,Mr.Wittig,Mr.Pella
Process design	Mr.Wittig
Scheduling	Mr.Liebers
Manufacture	Mr. Flemming, Mr. Paulus
Welding EWE	Mr.Liebers,Mr.Wittig Mr.Uhlig
Quality control	Mr.Grünert, Mr.Weise Mr.Krößin
Accounst department	Ms.Tesch

General information	
Production area (m²)	15000
Total workforce	100
Employed in production	70
Of these, welders	50
Specialist welding engineers	3
Designers	6
Process design	2
Strength calculations	3
Heat calculations	1
Quality control	3

Assembly	
Mobile assembly towers	1

Range of products		D mm	s mm	L m	G t
Vessels and columns					
General equipment	up to	5000	100	45	200
Pressure vessels	up to	5000	60	45	200
Tanks & storage vessels	up to	5000	60	45	200
Agitator vessels	up to	5000	60	45	200
Columns	up to	5000	60	45	200

Horizontal and Vertical Mixer
separate manufacturing area

Heat exchangers
Floating head, hairpin,double tube
Fixed tube plate, reboiler

Machine building
Depending on weight, up to 200 t

Manufacture of small vessels
separate manufacturing area

Manufacture of accessories	
Agitators	X
Columns internals	X
Steel structures	X
Pipeline construction	X

Materials	
Black/white separation	
Non-alloy structural steels	X
Stainless steels	X
Ferritic chrome steels	X
Ferritic austenitic steels	X
Low-temperature steels 3.5-9% Ni	X
High-temperature steels to P 91	X
Heat-resisting steels	X
Fine grain steels	X
Plated steel	X
Aluminium	
Copper	
Titanium	
Incoloy, Inconel	X
Hastelloy	X
Monel	X
Zirconium	
Plastic	

Surface treatment	
Blasting	X
Coating	X
Pickling/passivating	X
Abrasion	X
Electropolishing	Coop
Rubber lining	Coop

Operating plants	No.
Autog. burning plant	1
CNC	2
Plasma burning unit	2
Roll bending, cold	3
Roll bending, warm	
Profile bending machine	2
Pipe bending machine	2
Press, cold (250t)	1
Press, warm	
Vertical turning & boring mill	
Edging press	1
Boring mill	1
Planing machine	1
Centre lathe	5
Tube rolling mill	1
Belt grinder D 5000	1
Head grinding device	1
Separated workshop for special materials	X

Lifting equipment	
Bridgecrane	15

Annealing equipment	
Furnace	Coop
Inductive	Coop

Welding facilities	No.
OFW 3	1
GTAW 141 / SMAW 111	62
GMAW 131-135	35
SAW 121	3
PAW	
Strip welding unit	
Autom. pipe welding unit	
Turning & welding	25

Testing equipment	
UT - Ultrasonic Examination	X
PT - Liquid Penetrant Exam.	X
RT - Radigraphic Examination	Coop
MT - Magnetic Particle Exam.	X
He - Leaktest	X
Hardness test, fixed	Coop
Hardness test, mobile	X
Metallography	Coop
Delta Ferrit	X

NDE tester approvals	EN 473
UT - Ultrasonic Examination	X
PT - Liquid Penetrant Exam.	X
RT - Radiographic Examination	X
MT - Magnetic Particle Exam.	X

Pressure vessel permits	
TÜV (HP0, TRD, TRR)	X
TÜV PED 97/23/EG Modul A1	X
TÜV PED 97/23/EG Modul H1	X
ASME U/U2/S/R stamp	X
ML China-Pressure Vessels A1	X
DIN EN ISO 3834-3	X
Gospromnadzor Republic Belarus	X

Quality Management

Certification according to DIN EN ISO 9001 : 2008

TÜV SÜD ISO 9001
Management Service

Welding approvals

- Manufacturer qualifikation according to DIN 18800 Part 7, grade E
- Spezialized company acc. to WHG § 19 l
- Standard quality requirements DIN EN ISO 3834-3