



Intercambiadores de Calor y Calderas, C.A.

RIF (Tax ID): J-07047774-1

CORPORATE BROCHURE 2026

SINCE 1990 · TOTAL OPERATIONAL QUALITY

Experts in boilers and heat exchangers

Retubing, repair and maintenance to the ASME code for Venezuela's oil, petrochemical and energy industries.

36 years

of continuous experience

9 hydrojets

in-house fleet rated up to 20,000 PSI

24/7

during shutdowns and emergencies

www.incalca.com

OUR MOTTO

Total Operational Quality

WHO WE ARE

Over three decades serving Venezuela's industrial sector

INCALCA (Intercambiadores de Calor y Calderas, C.A.) is a Venezuelan company founded in 1990 in Los Puertos de Altagracia, Zulia State, specializing in integrated solutions for heat transfer equipment: maintenance, repair, retubing, construction and execution of engineering projects.

Our pioneering spirit has led us to take part in unique projects at the country's main petrochemical complexes and refineries. Despite our specialized name, we carry out contracts covering every discipline of a multidisciplinary project, with the technical and financial capacity to handle work of any scale.

We operate from two strategic locations, in Zulia and Anzoátegui, close to the country's refining, oil production and industrial hubs, with coverage throughout Venezuela.

1990

year founded

36

years of continuous experience

200+

workers deployed at once during shutdowns

15,000 m²

of facilities in Zulia

SECTORS WE SERVE



Oil and gas



Petrochemicals



Energy and power generation



Metallurgy



Sugar and food



Manufacturing and general industry

WHAT DRIVES US

Committed to technical excellence and safety in every operation

Mission

To execute construction, maintenance and metalworking projects to the highest industry standards. Our purpose is to ensure the operational integrity of our clients' equipment through a certified, safe service delivered by highly qualified and adaptable people.

Vision

To lead the industrial services market in Venezuela, standing out for our quality and safety management. We see ourselves as a steadily growing organization, able to meet the technical challenges of modern industry through innovation and the continuous improvement of our processes.

CORPORATE VALUES



Safety first

We never compromise on the safety of our people or our facilities.



Certified quality

We work to international codes as the rule, not the exception.



Adaptability

We respond quickly to the size and urgency each client requires.



Commitment

We treat every contract as our own and deliver on time and on budget.

VALUE PROPOSITION

01 Operational versatility

Technical and financial capacity to deliver anything from one-off maintenance jobs to large-scale projects, with efficiency and control.

02 Comprehensive scope

We manage every phase of a multidisciplinary project, meeting the strict standards of oil and industrial facilities.

03 Certification and quality

ASME "U" stamp for pressure vessel fabrication and National Board "R" stamp for boiler and vessel repair, both currently under renewal; processes aligned with ISO 9001:2015.

04 Human talent

A core team of 15 permanent professionals leads a scalable workforce that has exceeded 200 people working at once on projects and plant shutdowns.



Ethics, transparency and international compliance

We maintain ethics policies, anti-corruption rules and international sanctions compliance standards, aligned with the procurement and Know Your Customer (KYC) processes required by U.S. companies.

OUR SERVICES

Technical solutions that extend the life and efficiency of your assets

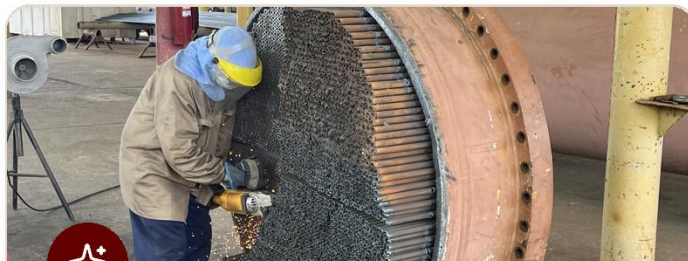
Six integrated service lines, delivered by qualified personnel with specialized equipment, under the ASME code and TEMA and ASTM standards. On site or in our shop, around the clock when the shutdown requires it.



PAGE 05

Heat transfer equipment

Retubing, repair and maintenance of heat exchangers, boilers and furnaces to ASME and TEMA.



PAGE 06

ASME repair, fabrication and welding

24/7 leak repair, ASME pressure vessels and welding qualified to ASME Section IX.



PAGE 07

Industrial hydrojet cleaning

High-pressure water up to 20,000 PSI for tube bundles, piping, tanks and surface preparation.



PAGE 07

Maintenance and plant shutdowns

24/7 multidisciplinary execution of major maintenance and shutdowns, with planning and quality control.



PAGE 08

Construction and industrial projects

Pressure vessels, spools, steel structures, electromechanical installation, detailed engineering and civil works.



PAGE 08

Specialized procurement

ASTM tubes, materials, valves and instrumentation with 100% MTR traceability and managed imports.

SERVICE 01 · OUR SPECIALTY

Heat transfer equipment

We specialize in the repair, maintenance and retubing of boilers and heat exchangers to the ASME code and TEMA standards. We work on site or in our shop, around the clock, to meet our clients' shutdown windows and restore their equipment's design integrity and efficiency.

Heat exchangers

- Full or partial retubing of shell-and-tube units: fixed-tubesheet, floating-head and U-tube bundles
- Bundle extraction and insertion with an Aquadyne bundle extractor
- Repair of tubesheets, baffles, nozzles and flanges
- Finned-tube air coolers (fin-fan coolers)
- Chemical and mechanical cleaning with efficiency measurement

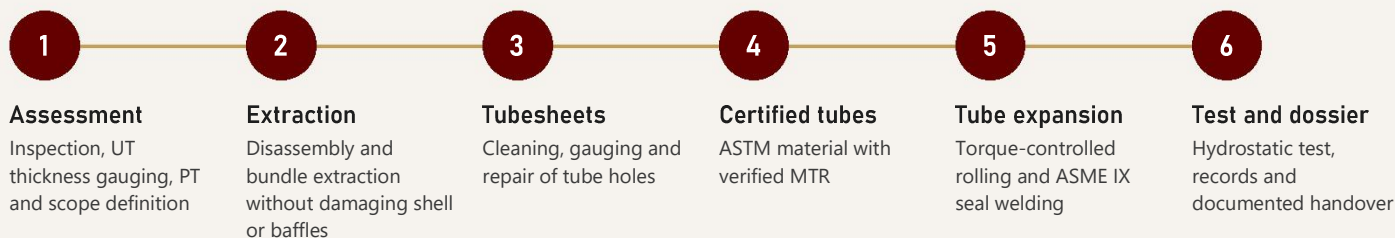
Boilers

- Fire-tube, water-tube and heat-recovery boilers
- Full retubing of the generating bank
- Superheaters and economizers
- Repair of steam drums, casings and burners
- Refractory and thermal insulation rehabilitation

Furnaces and integrity testing

- Process furnace maintenance
- Radiant and convection section tubes
- Hydrostatic and pneumatic testing to ASME/TEMA
- Non-destructive testing (NDT): PT, UT, RT and MT
- Failure analysis and technical recommendations

OUR RETUBING PROCESS



3,000+ tubes per exchanger in a single job

1,000+ tubes in large boilers

24/7 continuous work during shutdowns

Repair, fabrication and welding to the ASME code

With “U” fabrication and “R” repair stamps (currently under renewal) and welders qualified to ASME Section IX, every job follows documented procedures and, for stamped work, is overseen by an Authorized Inspector from Bureau Veritas (formerly OneCIS).



24/7 leak repair and emergency response

We identify the source and cause of every leak before repairing it, so the fix is permanent, not a patch.

- Tube-to-tubesheet leaks: TEMA plugging, re-rolling and TIG re-welding
- Leaks in tubes, shells, flanges and boiler drums
- Leak location by nitrogen or bubble testing
- Post-weld heat treatment (PWHT) when required
- National Board Form R-1 and equipment records
- ASME welders mobilized within hours



ASME Section VIII pressure vessels

Design, calculation and fabrication to ASME VIII, Div. 1, with Form U-1 and nameplate (“U” stamp under renewal).

- Thickness, head and nozzle design calculations
- Certified materials: A-516 Gr 70, A-240 TP 316L
- Weld radiography or UT and hydrostatic testing
- Two- and three-phase separator drums
- Steam accumulators, pressure filters and reactors
- Gas and LPG vessels; custom heat exchangers



ASME Section IX qualified welding

WPS/PQR procedures and welders with current WPQ for the processes and materials the industry requires.

- TIG (GTAW), MIG/MAG (GMAW) and shielded metal arc (SMAW)
- Positions 1G to 6G; thicknesses from 6 to over 100 mm
- Tube-to-tubesheet welding and weld overlay
- Carbon steel, Cr-Mo (P11/P22), stainless and duplex
- Preheating and PWHT with heating blankets
- Shop and field work, at height and in confined spaces



20,000 PSI

working pressure

Fleet of 9 Gardner Denver and Aquadyne units

Gauges calibrated up to 40,000 PSI

SERVICE 03

Industrial hydrojet cleaning

In-house fleet for cleaning critical equipment in shutdowns and maintenance, able to cover several work fronts at once.

- Heat exchanger and boiler tube bundles
- Descaling of piping and process lines
- Tanks, separators, vessels and filters
- Hydroblasting and abrasive-free surface preparation
- Pre-job risk assessment, specialized PPE and confined-space entry protocols

SERVICE 04

Industrial maintenance and plant shutdowns

We arrive on day one of the shutdown with personnel, materials and equipment ready. We work 12-hour shifts and, when the window is critical, around the clock, with single-point technical coordination and the capacity to scale up to more than 200 workers at once.

Plant shutdowns

- Pre-shutdown planning: scope, work permits and early procurement
- 24/7 multidisciplinary execution on multiple fronts
- Tube expansion, welding, NDT and test records
- Daily progress reports and final as-built dossier
- Standby personnel to absorb additional work

Industrial maintenance

- Control valve, safety valve and piping maintenance
- Sandblasting (SSPC-SP5/SP10) and industrial painting
- Load lifting with cranes up to 80 t
- Refractory and insulation installation
- Pumping systems, compressor units and manpower supply

200+

workers at once

12 / 24 h

continuous shutdown shifts

80 t

lifting capacity

AS-BUILT

final job dossier

Construction and industrial projects

- Pressure vessels with or without ASME stamp
- Prefabrication and installation of process, steam and utility piping (spools)
- Fabrication and erection of steel structures
- Electromechanical installation with laser alignment
- Fabrication and machining of parts in our own shop
- Detailed engineering: isometrics, design calculations and as-built drawings
- Civil, mechanical, electrical and instrumentation works



Specialized procurement and technical supplies

MT-3785a7

J08-8070-41305

Logistics: supplier network in the U.S., Europe and Asia · import and customs management · inspection at source or on receipt · expedited shipments for unplanned shutdowns.

Certified quality, safety first

"U"

ASME Stamp

Pressure vessel fabrication ·
Section VIII, Div. 1

UNDER RENEWAL

"R"

National Board Stamp

Boiler and pressure vessel
repair · NBIC

UNDER RENEWAL

IX

ASME Section IX

Qualified procedures and
welders · WPS/PQR/WPQ



Quality management

Processes optimized under
the guidelines of
ISO 9001:2015

Quality Assurance System

All stamped work is overseen by an Authorized Inspector (AI) from Bureau Veritas Inspection & Insurance Company (formerly OneCIS), an ASME-accredited inspection agency. At closeout we deliver a complete quality dossier: MTR certificates, the procedures used, tube expansion records, and NDT and hydrostatic test reports.

Codes and standards: ASME Sections I, VIII Div. 1 and IX · NBIC · TEMA classes R, C and B · ASME B31.1 and B31.3 · API 660 · ASTM · SSPC.



Safety and environment (SIAHO)

Our Industrial Safety, Environment and Occupational Health system (SIAHO) promotes a culture of safety, health and care for the environment, and protects the well-being of our workers, clients and communities. We enforce a zero-accident policy and statistically track incident rates to minimize risk.

- Risk analysis and work permits before every activity
- Confined-space protocols with atmospheric monitoring
- Specialized PPE and personnel certified for high-pressure operations

SIAHO Coordination

SIAHO
Supervisors

Health and
Safety
Committee

Safety
Representatives

Zero accidents in 41 continuous days

Retubing of boilers WH-3A/B, PEQUIVEN Ammonia Plant,
Ana María Campos Petrochemical Complex.

Equipped to respond



FEATURED EQUIPMENT

Aquadyne tube bundle extractor

Self-contained hydraulic unit for safely extracting and inserting tube bundles without damaging tubes, shell or baffles.

Push / pull force	60,000 lbf, bidirectional
Max. bundle diameter	80 in (2.03 m)
Max. bundle length	24.6 ft (7.5 m)
Engine	Self-contained diesel, suitable for hazardous areas
Handling	Self-balancing: works with a single crane



Lifting

- Cranes of 80, 50, 25, 20 and 7 t
- 8 t and 4 t forklifts
- 100 ft and 20 ft manlifts



Cleaning

- Fleet of 9 hydrojets up to 20,000 PSI
- Recirculation and dewatering pumps
- Vacuum trucks and stainless and carbon steel tankers



Welding and PWHT

- 400 A and 500 A diesel welding machines
- SMAW, TIG and MIG equipment
- Local heat treatment (PWHT)



Surface and power

- Compressors up to 1,250 CFM
- Sandblasting and painting equipment
- Generators up to 125 kVA



Transport

- Tractor-trailers and light- and medium-duty trucks
- Pickups and support vehicles
- In-house transport for hydrojets and equipment



Shop, field & civil works

- Lathes in our own machine shop
- Tube expanders and a precision cutting saw for field work
- D4 dozers, backhoes and concrete mixers



FACILITIES IN LOS PUERTOS DE ALTAGRACIA, ZULIA

15,000 m²
total site

1,200 m²
workshops

600 m²
warehouse

550 m²
offices

PROVEN EXPERIENCE

Projects that back our track record

More than 100 documented projects between 2000 and 2025 at the main petrochemical complexes and industrial plants in Venezuela.

2008

PEQUIVEN · OLEFINS I

Maintenance and repair of 50 heat exchangers during a plant shutdown

21,110 tubes in 21 days, no delays

2010

SUPER OCTANOS · J.A. ANZOÁTEGUI COMPLEX

Full boiler retubing with refractory demolition and casing repairs

100 workers · 45 continuous days

2011

PEQUIVEN · MVC II

Emergency heat exchanger repair, working around the clock

1,158 new tubes in 6 days

2013

PEQUIVEN · MVC II

Retubing of five heat exchangers plus an additional award for E-513

6,362 tubes replaced

2019

SUPERMETANOL · J.A. ANZOÁTEGUI COMPLEX

Full boiler retubing to the ASME code with a new superheater

1,516 tubes

2022

PROPILVEN · ANA MARÍA CAMPOS COMPLEX

Retubing of two heat exchangers at the INCALCA shop

8 days per unit · zero nonconformities

2023

PEQUIVEN · OLEFINS I

Heat exchanger retubing to ASME/TEMA with SSPC-SP5 sandblasting

3,000 tubes · 60 days of round-the-clock work

2025

SUPERMETANOL · J.A. ANZOÁTEGUI COMPLEX

Major emergency boiler repair and combustion system advisory

Immediate technical response

TRUSTED BY

PDVSA	PEQUIVEN	Chevron	Maurel & Prom	SuperMetanol	Super Octanos
Metor	FertiNitro	Polinter	Propilven	Pralca	Sinovensa
PDVSA VASSA	Estireno Zulia	Empresas Polar	PepsiCo	Central Azucarero CAPCA	AGA



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CONTACT

Let's talk about your next project

Request technical advice or a quote. For an accurate proposal, share drawings, isometrics or the equipment's technical specifications.

HEADQUARTERS · ZULIA

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EASTERN BRANCH · ANZOÁTEGUI

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INCALCA workshops: next to C. C. Puerto Píritu
Puerto Píritu, Anzoátegui State, Venezuela

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Email incalcaoriente@gmail.com

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NATIONWIDE COVERAGE

Projects completed in Zulia, Anzoátegui, Carabobo, Aragua, Bolívar, Lara, Barinas and Nueva Esparta, among other states.
Mobilization within 24 to 48 hours to states near our locations and 24/7 emergency response.



VISIT OUR WEBSITE

www.inc calca.com

Scan the code to see our services, equipment and completed projects.