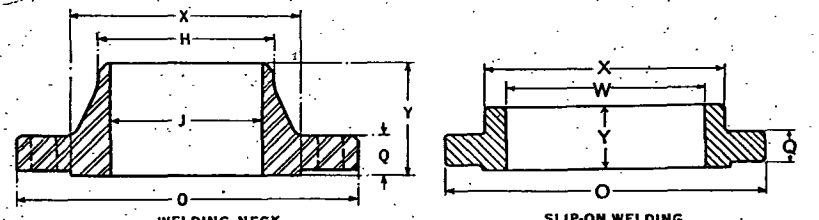


of the *Heating, Piping and Air Conditioning Contractors National Association* should be followed to insure a satisfactory welded joint.

A complete line of manufactured steel welding fittings is now available and a dimensional standard has been prepared under the procedure of the

TABLE 9. AMERICAN STANDARD DIMENSIONS OF STEEL WELDING NECK AND SLIP-ON WELDING FLANGES FOR STEAM SERVICE PRESSURE RATING OF 150 PSI (GAGE) AT A TEMPERATURE OF 500 F, AND 100 PSI (GAGE) AT 750 F, A.S.A. B16-1939



NOMINAL PIPE SIZE	WELDING NECK		SLIP-ON WELDING		LENGTH THRU HUB ^a	INSIDE DIAM. OF PIPE SCHEDULE 40 ^b	BORE OF SLIP-ON FLANGES MIN.	DIAM. OF BOLT CIRCLE	NO. OF BOLTS	SIZE OF BOLTS
	O	Q	X	H						
1/2	3 1/2	1 1/8	1 1/8	0.84	1 1/8	0.62*	0.88	2 3/8	4	1/2
3/4	3 3/4	1 1/2	1 1/2	1.05	2 1/16	0.82*	1.09	2 3/4	4	1/2
1	4 1/4	1 5/8	1 5/8	1.32	2 3/16	1.05*	1.38	3 1/8	4	1/2
1 1/4	4 7/8	2 1/8	2 1/8	1.66	2 1/4	1.38*	1.72	3 1/2	4	1/2
1 1/2	5	2 1/16	2 1/16	1.90	2 1/4	1.61*	1.97	3 3/8	4	1/2
2	6	2 3/16	2 3/16	2.38	2 1/2	2.07*	2.44	4 3/4	4	5/8
2 1/2	7	2 7/8	2 7/8	2.88	2 3/4	2.47*	2.94	5 1/2	4	5/8
3	7 1/2	3 1/8	3 1/8	3.50	2 3/4	3.07*	3.56	6	4	5/8
3 1/2	8 1/2	3 1/2	3 1/2	4.00	2 13/16	3.55*	4.06	7	8	5/8
4	9	3 1/2	3 1/2	4.50	3	4.03*	4.56	7 1/2	8	5/8
5	10	3 1/2	3 1/2	5.56	3 1/2	5.05*	5.66	8 1/2	8	3/4
6	11	1	1	6.63	3 1/2	6.07*	6.72	9 1/2	8	3/4
8	13 1/2	1 1/8	1 1/8	8.63	4	7.98*	8.72	11 1/4	8	3/4
10	16	1 3/8	1 3/8	10.75	4	10.02*	10.88	14 1/4	12	7/8
12	19	1 3/4	1 3/4	12.75	4 1/2	-----	12.88	17	12	7/8
14 O.D.	21	1 3/8	1 3/8	14.00	5	To Be Specified by Purchaser	14.19	18 3/4	12	1
16 O.D.	23 1/2	1 3/8	1 3/8	16.00	5	-----	16.19	21 1/4	16	1
18 O.D.	25	1 3/8	1 3/8	18.00	5 1/2	-----	18.19	22 3/4	16	1 1/8
20 O.D.	27 1/2	1 1/2	1 1/2	20.00	5 1/2	-----	20.19	25	20	1 1/8
24 O.D.	32	1 1/2	1 1/2	24.00	6	-----	24.19	29 1/2	20	1 1/4

All dimensions given in inches.

^aA raised face of 1/8 in. is included in thickness of flange minimum and in length through hub.

^bThe outside surface of the welding end of the hub shall be straight or tapered at not more than 6 deg.

^cDimensions H and J correspond to the outside and inside diameters of pipe as given in A.S.A. B36.10-1939, Schedule 40.

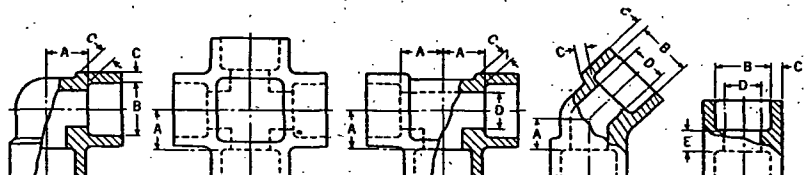
*These diameters are identical with the diameters of what was formerly designated as *Standard Weight Pipe* of the corresponding sizes.

American Standards Association to unify heretofore divergent dimensions for the same type welding fittings as produced by different manufacturers. Standard dimensions for steel butt-welding elbows, tees, caps, and lapped-joint stub ends are given in Table 8. Dimensions for eccentric and concentric reducers, and 180-deg return bends are not shown in Table 8 but are included in the American Standard. Larger sizes also are available in some types of fittings. The welding bevel which is a straight 37 1/2-deg V for wall thickness 3/4 in. and below, and a U-bevel for thicknesses heavier than 3/4 in., conforms to the recommended practice of A.S.A.

Standard B16-1939, American Standard for Steel Pipe Flanges and Flanged Fittings. The latter also contains dimensions for steel welding neck flanges for pressures up to 2500 psi, and slip-on welding flanges for 150 and 300 psi. Table 9 gives these dimensions for welding-neck and slip-on welding flanges suitable for 150 psi gage pressure.

Socket-welding fittings also are commercially available. These fittings have a machined recess for inserting the pipe which is attached by a fillet weld between the pipe wall and socket end. Use of socket-welding fittings generally is restricted to nominal pipe sizes 3 in. and smaller in which range commercial fittings are available. This type of fitting has

TABLE 10. PROPOSED AMERICAN STANDARD DIMENSIONS OF SOCKET-WELDING ELBOWS, TEES, CROSSES, 45-DEG ELBOWS, AND COUPLINGS



NOMINAL PIPE SIZE	MINIMUM DEPTH OF SOCKET	CENTER TO BOTTOM OF SOCKET				COUPLINGS DISTANCE BETWEEN BOTTOM SOCKETS	BORE DIAMETER OF SOCKET, MINIMUM	MINIMUM SOCKET WALL THICKNESS			BORE DIAMETER OF FITTINGS		
		90-Deg Els. Tees, Crosses		45-Deg Els				Sched. 40	Sched. 80	Sched. 160	Sched. 40	Sched. 80	Sched. 160
		Sched. 40 & 80	Sched. 160	Sched. 40 & 80	Sched. 160								
		A		A		E	B	C ^a			D		
1/4	1/4	1/4	1/4	1/4	1/4	1/4	0.555	0.156	0.156	0.364	0.302		
1/2	1/2	1/2	1/2	1/2	1/2	1/2	0.690	0.156	0.156	0.493	0.423		
3/4	3/4	3/4	3/4	3/4	3/4	3/4	0.835	0.156	0.156	0.622	0.546	0.466	
1	1	1	1	1	1	1	1.065	0.156	0.156	0.824	0.742	0.614	
1 1/4	1 1/4	1 1/4	1 1/4	1 1/4	1 1/4	1 1/4	1.330	0.166	0.166	1.049	0.957	0.815	
1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1 1/2	1.675	0.175	0.175	1.350	1.275	1.160	
2	2	2	2	2	2	2	1.915	0.181	0.181	1.610	1.500	1.338	
2 1/2	2 1/2	2 1/2	2 1/2	2 1/2	2 1/2	2 1/2	2.406	0.193	0.193	2.067	1.939	1.689	
3	3	3	3	3	3	3	2.906	0.254	0.254	2.469	2.323	2.125	
							3.353	0.270	0.270	3.068	2.900	2.626	

All dimensions are given in inches.

^aDimension C is 1 1/4 times the nominal pipe thickness, minimum, but not less than 3/4 in.

Reducing sizes have same center to bottom of socket dimension as the largest size of reducing fitting.

gained rapid acceptance owing to its ease of installation, low cost, and ability to make a pressure tight joint without weakening the pipe as is the case with threading. Dimensions for socket-welding fittings as offered by most manufacturers of the product are given in Table 10.

VALVES

Valves are made with both threaded and flanged ends for screwed and bolted connections just as are pipe fittings.

The material used for valves of small size is generally brass or bronze for low pressures and forged steel for high pressures, while in the larger sizes either cast-iron, cast-steel or some of the steel alloys are employed. Practically all iron or steel valves intended for steam or water work are bronze-mounted or trimmed.

Brass, bronze, and iron valves are generally designed for standard or extra heavy service, the former being used up to 125 lb and the latter up