

Swivel joints are used extensively in low-pressure steam and hot water heating systems and in hot water supply lines. The swivel joints absorb the expansive movement of the pipe by the turning of threaded joints. In many cases the straight pipe in the offset of a swivel joint is sufficiently flexible to take up the expansion without developing enough thrust to produce swiveling in the threaded joint. This is preferable since continued turning in the threaded joint may in time result in a leak, particularly when the pressure is high. The amount of elongation which a swivel joint can take up is controlled by the length of the swing piece employed and by the lateral displacement which is permissible in the long pipe runs.

Probably the most economical method of providing for expansion of piping in a long run is to take advantage of the directional changes which must necessarily occur in the piping and proportion the offsets so that sufficient flexibility is secured. Ninety-degree bends with long, straight tangents in either a horizontal or a vertical plane are an excellent means for securing adequate flexibility with larger sizes of pipe. When flexi-

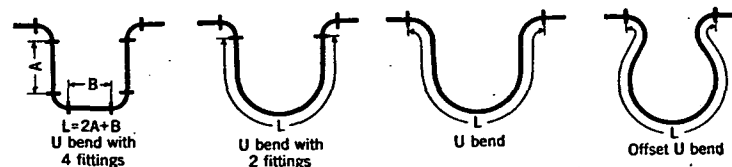


FIG. 1. MEASUREMENT OF L ON VARIOUS PIPE BENDS

bility cannot be obtained in this manner, it is necessary to make use of some type of expansion bend. The exact calculation of the size of expansion bends required to take up a given amount of thermal expansion is relatively complicated¹. The following approximate method, however, has been found to give reasonably good results and is deemed to be sufficiently accurate for most heating work.

Fig. 1 shows several types of expansion bends commonly used for taking up thermal expansion. The amount of pipe, L , required in each of these bends may be computed from the following formula:

$$L = 6.16 \sqrt{D \Delta} \quad (2)$$

where

L = length of pipe, feet.

D = outside diameter of the pipe used, inches.

Δ = the amount of expansion to be taken up, inches.

This formula, based on the use of mild-steel pipe with wall thicknesses not heavier than extra-strong, assumes a maximum safe value of fiber stress of 16,000 lb per square inch. When square type bends are used, the width of the bend should not exceed about two times the height. It is

¹Piping Handbook, by Walker and Crocker, and A Manual for the Design of Piping for Flexibility by the Use of Graphs, by E. A. Wert, S. Smith, and E. T. Cope, published by The Detroit Edison Company.

further assumed that the corners are made with screwed or flanged elbows or with arcs of circles having radii five to six times the pipe diameter. Use of welding elbows with radii of $1\frac{1}{2}$ times the pipe diameter will decrease the end thrusts somewhat but will raise the fiber stress correspondingly.

All risers must be anchored and safeguarded so that the difference in length when hot from the length when cold shall not disarrange the normal and orderly provisions for drainage of the branches.

Proper anchoring of piping is especially necessary with light-weight radiators, to allow for freedom of expansion in order that no pipe strain

TABLE 6. THERMAL EXPANSION OF PIPE IN INCHES PER 100 FT*
(For superheated steam and other fluids refer to temperature column)

SATURATED STEAM			ELONGATION IN INCHES PER 100 FT FROM -20 F UP				SATURATED STEAM		ELONGATION IN INCHES PER 100 FT FROM -20 F UP				
Vacuum Inches of Hg.	Pressure Pounds per Square Inch Gage	Tem- perature Degrees Fahren- heit	Cast- Iron Pipe	Steel Pipe	Wrought Iron Pipe	Copper Pipe	Pressure Pounds per Square Inch Gage	Tem- perature Degrees Fahren- heit	Cast- Iron Pipe	Steel Pipe	Wrought Iron Pipe	Copper Pipe	
29.39 28.89 27.99 26.48 24.04 20.27 14.63 6.45		-20	0	0	0	0	664.3	500	3.847	4.296	4.477	6.110	
		0	0.127	0.145	0.152	0.204	795.3	520	4.020	4.487	4.677	6.352	
		20	0.255	0.293	0.306	0.442	945.3	540	4.190	4.670	4.866	6.614	
		40	0.390	0.430	0.465	0.655	1115.3	560	4.365	4.860	5.057	6.850	
		60	0.518	0.593	0.620	0.888	1308.3	580	4.541	5.051	5.268	7.123	
		80	0.649	0.725	0.780	1.100	1525.3	600	4.725	5.247	5.455	7.388	
		100	0.787	0.898	0.939	1.338	1768.3	620	4.896	5.437	5.660	7.636	
		120	0.926	1.055	1.110	1.570	2041.3	640	5.082	5.627	5.850	7.893	
		140	1.051	1.209	1.265	1.794	2346.3	660	5.260	5.831	6.067	8.153	
		160	1.200	1.368	1.427	2.008	2705	680	5.442	6.020	6.260	8.400	
		180	1.345	1.528	1.597	2.255	3080	700	5.629	6.229	6.481	8.676	
		200	1.495	1.691	1.778	2.500		720	5.808	6.425	6.673	8.912	
		2.5	220	1.634	1.852	1.936	2.720		740	6.006	6.635	6.899	9.203
		10.3	240	1.780	2.020	2.110	2.960		760	6.200	6.833	7.100	9.460
		20.7	260	1.931	2.183	2.279	3.189		780	6.389	7.046	7.314	9.736
		34.5	280	2.085	2.350	2.465	3.422		800	6.587	7.250	7.508	9.992
		52.3	300	2.233	2.519	2.630	3.665		820	6.779	7.464	7.757	10.272
		74.9	320	2.395	2.690	2.800	3.900		840	6.970	7.662	7.952	10.512
		103.3	340	2.543	2.862	2.988	4.145		860	7.176	7.888	8.195	10.814
	138.3	360	2.700	3.029	3.175	4.380		880	7.375	8.098	8.400	11.175	
	180.9	380	2.859	3.211	3.350	4.628		900	7.579	8.313	8.639	11.360	
	232.4	400	3.008	3.375	3.521	4.870		920	7.795	8.545	8.867	11.625	
	293.7	420	3.182	3.566	3.720	5.118		940	7.989	8.755	9.089	11.911	
	366.1	440	3.345	3.740	3.900	5.358		960	8.200	8.975	9.300	12.180	
	451.3	460	3.511	3.929	4.096	5.612		980	8.406	9.196	9.547	12.473	
	550.3	480	3.683	4.100	4.280	5.855		1000	8.617	9.421	9.776	12.747	

*From Piping Handbook, by Walker and Crocker. This table gives the expansion from -20 F to the temperature in question. To obtain the amount of expansion between any two temperatures take the difference between the figures in the table for those temperatures. For example, if a steel pipe is installed at a temperature of 60 F and is to operate at 300 F, the expansion would be $2.519 - 0.593 = 1.926$ in.

will distort the radiators. When expansion strains from the pipes are permitted to reach these light metal heaters they usually emit sounds of distress which are exceedingly troublesome.

PIPE THREADS

All threaded pipe for heating and ventilating installations uses the American Standard taper pipe thread which is made with a taper of 1 in