

TABLE 1. MAXIMUM ALLOWABLE CAPACITIES OF UP-FEED RISERS FOR ONE-PIPE LOW PRESSURE STEAM

Based on A. S. H. V. E. Research Laboratory Tests

PIPE SIZE INCHES	VELOCITY FEET PER SECOND	PRESSURE DROP OUNCES PER 100 FT	CAPACITY		
			Sq Ft Radiation	Btu per Hour	Lb Steam per Hour
A	B	C	D	E	F
1	14.1	0.68	45	10,961	11.3
1¼	17.6	0.66	98	23,765	24.5
1½	20.0	0.66	152	36,860	38.0
2	23.0	0.57	288	69,840	72.0
2½	26.0	0.54	464	112,520	116.0
3	29.0	0.48	799	193,600	199.8
3½	31.0	0.44	1144	277,000	286.0
4	32.0	0.39	1520	368,000	380.0

INSTRUCTIONS FOR USING TABLE 1

- Capacities given in Table 1 should never be exceeded on one-pipe risers.
- Capacities are based on ¼-lb condensation per square foot equivalent radiation and actual diameter of standard pipe.
- All pipe should be well reamed and free from constrictions. Fittings should be up to size. (See Tables 4 and 5).

TABLE 2. MAXIMUM ALLOWABLE CAPACITIES OF UP-FEED RISERS FOR TWO-PIPE LOW PRESSURE STEAM

Based on A. S. H. V. E. Research Laboratory Tests

PIPE SIZE INCHES	VELOCITY FEET PER SECOND	PRESSURE DROP OUNCES PER 100 FT	CAPACITY		
			Sq Ft Radiation	Btu per Hour	Lb Steam per Hour
A	B	C	D	E	F
¾	20	-----	40	9550	10.0
1	23	1.78	74	17,900	18.45
1¼	27	1.57	151	36,500	37.65
1½	30	1.48	228	55,200	57.0
2	35	1.33	438	106,100	109.5
2½	38	1.16	678	164,100	169.4
3	41	0.95	1129	273,500	282.2
3½	42	0.81	1548	375,500	387.0
4	43	0.71	2042	495,000	510.5

INSTRUCTIONS FOR USING TABLE 2

- The capacities given in this table should never be exceeded on two-pipe risers.
- Capacities are based on ¼-lb condensation per square foot equivalent radiation and actual diameter of standard pipe.
- All pipe should be well reamed and free from constrictions. Fittings should be up to size. (See Tables 4 and 5.)

TABLE 3. COMPARATIVE CAPACITY OF STEAM LINES AT VARIOUS PITCHES FOR STEAM AND CONDENSATE FLOWING IN OPPOSITE DIRECTIONS^a

Pitch of Pipe in Inches per 10 Ft

PITCH OF PIPE		¼ IN.		½ IN.		1 IN.		1½ IN.		2 IN.		3 IN.		4 IN.		5 IN.		
Pipe Size Inches	Sq Ft Rad. Based on 240 Btu	Max. Vel.	Sq Ft Rad. Based on 240 Btu	Max. Vel.	Sq Ft Rad. Based on 240 Btu	Max. Vel.	Sq Ft Rad. Based on 240 Btu	Max. Vel.	Sq Ft Rad. Based on 240 Btu	Max. Vel.	Sq Ft Rad. Based on 240 Btu	Max. Vel.	Sq Ft Rad. Based on 240 Btu	Max. Vel.	Sq Ft Rad. Based on 240 Btu	Max. Vel.	Sq Ft Rad. Based on 240 Btu	Max. Vel.
¼	25.0	12	30.3	14	37.3	18	40.4	19	42.5	20	46.1	21	47.5	22	49.3	23		
1	45.8	12	52.6	15	63.0	17	70.0	20	75.2	22	83.0	23	87.9	25	90.2	26		
1¼	104.9	18	117.2	20	133.0	23	144.5	25	154.0	27	165.0	28	172.6	29	178.2	31		
1½	142.6	18	159.0	21	181.0	23	196.5	25	209.3	27	224.0	28	234.8	30	242.6	31		
2	236.0	19	263.5	20	299.5	23	325.5	25	346.5	27	371.5	28	388.4	29	401.1	30		

^aData from AMERICAN SOCIETY OF HEATING AND VENTILATING ENGINEERS Research Laboratory.

Equivalent Length of Run

All tables for the flow of steam in pipes, based on pressure drop, must allow for the friction offered by the pipe as well as for the additional resistance of the fittings and valves. These resistances generally are stated in terms of straight pipe; in other words, a certain fitting will produce a drop in pressure equivalent to so many feet of straight run of the same size of pipe. Table 6 gives the number of feet of straight pipe usually allowed for the more common types of fittings and valves. In all pipe sizing tables in this chapter the *length of run* refers to the *equivalent length of run* as distinguished from the *actual length* of pipe in feet. The length of run is not usually known at the outset; hence it is necessary to assume some pipe size at the start. Such an assumption frequently is considerably in error and a more common and practical method is to assume the length of run and to check this assumption after the pipes are sized. For this purpose the length of run usually is taken as double the actual length of pipe.

TABLE 4. PER CENT DIFFERENCE IN CAPACITY FOR CARRYING STEAM AND CONDENSATE DUE TO VARIATION OF PIPE SIZE AND SMOOTHNESS^a

Size of pipe.....	MAXIMUM CONDENSATION, LB PER HOUR			
	¾ In.	1 In.	1¼ In.	1½ In.
Minimum.....	14.00	24.89	45.42	70.50
Maximum.....	15.20	30.08	52.08	82.00
Per cent variation.....	8.6	20.8	14.7	16.3

^aData from AMERICAN SOCIETY OF HEATING AND VENTILATING ENGINEERS Research Laboratory.TABLE 5. EFFECT OF REAMING ENTRANCE TO ONE-INCH ONE-PIPE RISERS^a

	MAXIMUM CAPACITY OF RISER.	PER CENT DECREASE
Reamed entrances.....	24.7 lb per hour	0.0
Rounded entrances.....	23.9 lb per hour	3.2
Squared entrances.....	22.2 lb per hour	10.1
Three wheel cutter.....	19.2 lb per hour	22.2
Single wheel cutter.....	17.6 lb per hour	28.7

^aData from AMERICAN SOCIETY OF HEATING AND VENTILATING ENGINEERS Research Laboratory.