

FORGED STEEL SOCKET WELDING & THREADED FITTINGS

1. PRESSURE RATINGS

These fittings shall be designated as pressure class 2000,3000 and 6000 fittings for threading and pressure class 3000, 6000 and 9000 for socket-welding. This designation identifies the fittings with their ratings as shown as follows, Table 1.

Table 1 : Correlation of Fittings Class With Schedule Number of Wall Designation of Pipe for Calculation of Ratings

Pressure Class Designation of Fitting	Type of Fitting	Pipe Used for Rating Basic	
		Schedule NO.	Wall Designation
2000 lb	Threaded	80	X-S
3000 lb	Threaded	160	-
6000 lb	Threaded	-	XX-S
3000 lb	Socket-Welding	80	X-S
6000 lb	Socket-Welding	160	-
9000 lb	Socket-Welding	-	XX-S

• This table is not intended to restrict the use of pipe of thinner or thicker wall with fittings. Pipe actually used may be thinner or thicker in nominal wall than that shown in Table 1. When thinner is used its strength may govern the rating. When thicker pipe is used (e.g., for mechanical strength) the strength of the fitting governs the rating.

Table 2 : Nominal wall thickness of Schedule 160 and Double Extra Strong Pipe.

NPS.	Schedule 160		XX - S	
	in	mm	in	mm
1/8	0.124	3.15	0.190	4.83
1/4	0.145	3.68	0.230	6.05
3/8	0.158	4.01	0.252	6.40

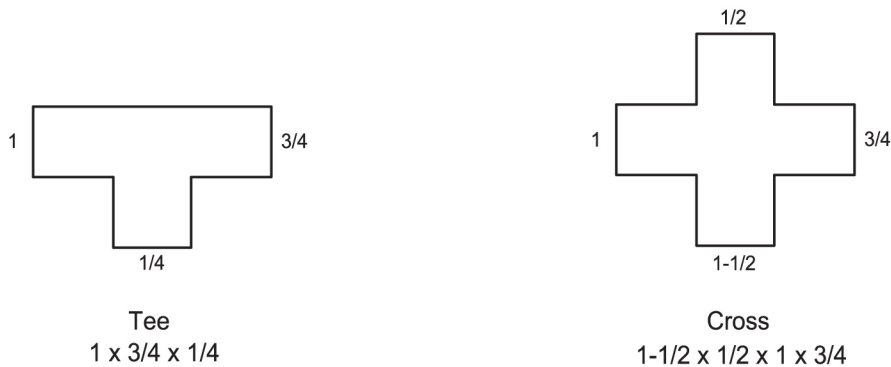
Table 3 : Pressure/Temperature Ratings

Non-shock Working Pressure in Pounds per Square Inch

Service Temperature Degree °F	2000lb Threaded Fittings					3000lb Socket Welding and Threaded Fittings					6000lb Socket Welding and Threaded Fittings				
	Carbon Steel	F304	F316	F22	F5	Carbon Steel	F304	F316	F22	F5	Carbon Steel	F304	F316	F22	F5
100	2000	1715	2000	2000	2000	3000	2570	3000	3000	3000	6000	5145	6000	6000	6000
150	1970	1615	1970	1970	1970	2950	2425	2950	2950	2950	5915	4855	5915	5915	5915
200	1940	1520	1940	1940	1940	2915	2280	2915	2915	2915	5830	4565	5830	5830	5830
250	1915	1445	1915	1915	1915	2875	2170	2975	2975	2975	5750	4340	5750	5750	5750
300	1975	1370	1896	1895	1896	2845	2055	2845	2845	2845	5690	4115	5690	5690	5690
350	1875	1310	1875	1875	1875	2810	1965	2810	2810	2810	5625	3930	5625	5625	5625
400	1850	1245	1850	1850	1850	2775	1870	2775	2775	2775	5550	3745	5550	5550	5550
450	1810	1195	1810	1710	1810	2715	1790	2715	2715	2715	5430	3585	5430	5430	5430
500	1735	1140	1735	1635	1735	2605	1715	2605	2605	2605	5210	3430	5210	5210	5210
550	1640	1100	1640	1540	1640	2460	1650	2460	2460	2460	4925	3305	4925	4925	4925
600	1540	1060	1540	1440	1540	2310	1590	2310	2310	2310	4620	3180	4620	4620	4620
650	1430	1020	1430	1330	1430	2150	1535	2150	2150	2150	4300	3070	4300	4300	4300
700	1305	985	1370	1240	1340	1960	1480	2055	2010	2010	3920	2960	4110	4025	4025
750	1180	950	1305	1145	1245	1775	1425	1960	1870	1870	3550	2850	3920	3745	3745
800	1015	915	1240	1055	1155	1525	1370	1865	1735	1735	3050	2745	3730	3470	3470
850	830	880	1180	1060	1060	1250	1330	1770	1595	1595	2500	2660	3540	3190	3190
900	615	860	1115	970	970	925	1290	1675	1455	1455	1885	2580	3350	2915	2915
950	425	845	1055	880	880	640	1270	1580	1320	1320	1295	2540	3165	2640	2640
1000	235	830	990	740	695	350	1250	1485	1115	1240	715	2500	2975	2230	2085

2. SIZE IDENTIFICATION

The size of a fitting is identified by the nominal pipe size. For reducing fittings, the size of the largest run opening is to be given first, followed by the size of the opening opposite of the same run. The branch size of a Tee is given last. Where the case is a Cross, the largest side-outlet is thirdly given, then the opening opposite



3. THREADS

Unless otherwise specified in inquiry, all threaded fittings are supplied with NPT threads (ANSI B2.1 American Standard. Taper Pipe Thread) for reference, other available threads are :

- ISO / R7, Pipe Threads for Gas List Tubes and Screwed Fittings where Pressure-tight Joints are made on the threads. (BS 2.1 & JIS B0203 PT Thread).
- API 5B, Line Pipe Threads.
- KS B0222 Taper Pipe Threads.

4. BORE DIAMETER OF FITTINGS

Bore Diameter of fitting are manufactured for conforming with KS. JIS ANSI or MSS dimension.

WALL THICKNESS OF WELDED AND SEAMLESS PIPE

Unit : mm

Nominal Pipe Size		Outside Diameter		Nominal Wall Thickness							
A	B	KS/JIS	ANSI	SPP SGP	Sch 5s	Sch 10s	Sch 10	Sch 20s	Sch 20	Sch 30	Sch 40s
6	1/8	10.50	10.29	-	-	1.24	-	1.5	-	-	1.73
8	1/4	13.80	13.72	-	-	1.65	-	2.0	-	-	2.24
10	3/8	17.30	17.14	-	-	1.65	-	2.0	-	-	2.31
15	1/2	21.70	21.34	2.8	1.65	2.11	-	2.5	-	-	2.77
20	3/4	27.20	26.67	2.8	1.65	2.11	-	2.5	-	-	2.87
25	1	34.00	33.40	3.2	1.65	2.77	-	3.0	-	-	3.38
32	1 1/4	42.70	42.16	3.5	1.65	2.77	-	3.0	-	-	3.56
40	1 1/2	48.60	48.26	3.5	1.65	2.77	-	3.2	-	-	3.68
50	2	60.50	60.32	3.8	1.65	2.77	-	3.5	3.20	-	3.91
65	2 1/2	76.30	73.02	4.2	2.11	3.05	-	3.5	4.50	-	5.16
80	3	89.10	88.90	4.2	2.11	3.05	-	4.0	4.50	-	5.49
90	3 1/2	101.60	101.60	4.2	2.11	3.05	-	4.0	4.50	-	5.74
100	4	114.30	114.30	4.5	2.11	3.05	-	4.0	4.90	-	6.02
125	5	139.80	141.30	4.5	2.77	3.40	-	5.0	5.10	-	6.55
150	6	165.20	168.30	5.0	2.77	3.40	-	5.0	5.50	-	7.11
200	8	216.30	219.08	5.8	2.77	3.76	-	6.5	6.35	7.04	8.18
250	10	267.40	273.05	6.6	3.40	4.19	-	6.5	6.35	7.80	9.27
300	12	318.50	323.80	6.9	3.96	4.57	-	6.5	6.35	8.38	9.52
350	14	355.60	355.60	7.9	3.96	4.78	6.35	8.0	7.92	9.52	*9.52
400	16	406.40	406.40	7.9	4.19	4.78	6.35	8.0	7.92	9.52	*9.52
450	18	457.20	457.20	7.9	4.19	4.78	6.35	8.0	7.92	11.12	*9.52
500	20	508.00	508.00	7.9	4.78	5.54	6.35	9.5	9.52	12.70	*9.52
550	22	558.80	558.80	-	4.78	5.54	6.35	-	9.52	12.70	*9.52
600	24	609.60	609.60	-	5.54	6.35	6.35	-	9.52	14.27	*9.52
650	26	660.40	660.40	-	-	*7.92	7.92	-	12.70	-	*9.52
700	28	711.20	711.20	-	-	*7.92	7.92	-	12.70	15.88	*9.52
750	30	762.00	762.00	-	6.35	*7.92	7.92	-	12.70	15.88	*9.52
800	32	812.80	812.80	-	-	*7.92	7.92	-	12.70	15.88	*9.52
850	34	863.60	863.60	-	-	*7.92	7.92	-	12.70	15.88	*9.52
900	36	914.40	914.40	-	-	*7.92	7.92	-	12.70	15.88	*9.52
950	38	965.20	965.20	-	-	*7.92	-	-	-	-	*9.52
1000	40	1016.00	1016.00	-	-	*7.92	-	-	-	-	*9.52
1050	42	1066.80	1066.80	-	-	*7.92	-	-	-	-	*9.52
1100	44	1117.60	1117.60	-	-	*7.92	-	-	-	-	*9.52
1150	46	1168.40	1168.40	-	-	*7.92	-	-	-	-	*9.52
1200	48	1219.20	1219.20	-	-	*7.92	-	-	-	-	*9.52

Asterisks(*) denote PAP Standards as no internationally Recognized Standards for these wallthickness have been established

WALL THICKNESS OF WELDED AND SEAMLESS PIPE

Unit : mm

Normal Wall Thickness											Normal Pipe Size Inch
STD	Sch 40	Sch 60	Sch 80s	X-S	Sch 80	Sch 100	Sch 120	Sch 140	Sch 160	XX-S	
1.73	1.73	2.20	2.41	2.41	2.41	-	-	-	3.15	4.83	1/8
2.24	2.24	2.40	3.02	3.02	3.02	-	-	-	3.68	6.05	1/4
2.31	2.31	2.80	3.20	3.20	3.20	-	-	-	4.01	6.40	3/8
2.77	2.77	3.20	3.73	3.73	3.73	-	-	-	4.78	7.47	1/2
2.87	2.87	3.40	3.91	3.91	3.91	-	-	-	5.56	7.82	3/4
3.38	3.38	3.90	4.55	4.55	4.55	-	-	-	6.35	9.09	1
3.56	3.56	4.50	4.85	4.85	4.85	-	-	-	6.35	9.70	1 1/4
3.68	3.68	4.50	5.08	5.08	5.08	-	-	-	7.14	10.16	1 1/2
3.91	3.91	4.90	5.54	5.54	5.54	-	-	-	8.74	11.07	2
5.16	5.16	6.00	7.01	7.01	7.01	-	-	-	9.52	14.02	2 1/2
5.49	5.49	6.60	7.62	7.62	7.62	-	-	-	11.12	15.24	3
5.74	5.74	7.00	8.08	8.08	8.08	-	-	-	-	-	3 1/2
6.02	6.02	7.10	8.56	8.56	8.56	-	11.12	-	13.49	17.12	4
6.55	6.55	8.10	9.53	9.53	9.53	-	12.70	-	15.88	19.05	5
7.11	7.11	9.30	10.97	10.97	10.97	-	14.27	-	18.26	21.94	6
8.18	8.18	10.31	12.70	12.70	12.70	15.09	18.26	20.62	23.01	22.22	8
9.27	9.27	12.70	12.70	12.70	15.09	18.26	21.44	25.40	28.58	25.40	10
9.52	10.31	14.27	12.70	12.70	17.48	21.44	25.40	28.58	33.32	25.40	12
9.52	11.13	15.09	*12.70	12.70	19.05	23.83	27.79	31.75	35.71	-	14
9.52	12.70	16.66	*12.70	12.70	21.44	26.19	30.96	36.52	40.49	-	16
9.52	14.27	19.05	*12.70	12.70	23.82	29.36	34.92	39.67	45.24	-	18
9.52	15.09	20.62	*12.70	12.70	26.19	32.54	38.10	44.45	50.01	-	20
9.52	-	22.22	*12.70	12.70	25.58	34.92	41.28	47.62	53.98	-	22
9.52	17.48	24.61	*12.70	12.70	30.96	38.89	46.02	52.37	59.54	-	24
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	26
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	28
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	30
9.52	17.48	-	*12.70	12.70	-	-	-	-	-	-	32
9.52	17.48	-	*12.70	12.70	-	-	-	-	-	-	34
9.52	19.05	-	*12.70	12.70	-	-	-	-	-	-	36
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	38
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	40
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	42
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	44
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	46
9.52	-	-	*12.70	12.70	-	-	-	-	-	-	48