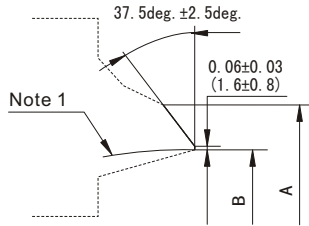
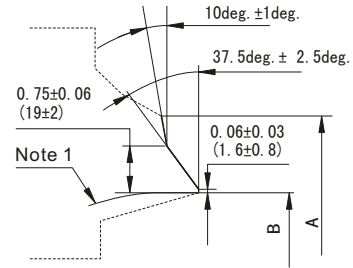


Buttwelding End Dimensions



Note 1 Internal surface may be as formed or machined for dimension B at root face. Comtour within the envelope shall be in accordance with section.

Wall Thickness not Over 0.88in (22mm)
Welding End Detail for Joint Without Backing Ring



Wall Thickness Over 0.88in (22mm)
Welding End Detail for Joint Without Backing Ring

Nominal Pipe Size		Schedule No. [Note(1)]	O.D. at Welding Ends				B		C [Note(3)]		t	
			Wrought or Fabricated Components, A [Note(1)]		Cast Steel Valves, A [Note(2)]							
DN	NPS		mm	in	mm	in	mm	in	mm	in	mm	in
65	2 1/2	40	73.0	2.88	75	2.96	62.5	2.469	62.93	2.479	5.16	0.203
		80					59	2.323	59.69	2.351	7.01	0.276
		160					54	2.125	55.28	2.178	9.53	0.375
		XXS					45	1.771	47.43	1.868	14.02	0.552
80	3	40	88.9	3.50	91	3.59	78	3.068	78.25	3.081	5.49	0.216
		80					73.5	2.900	74.53	2.934	7.62	0.300
		160					66.5	2.624	68.38	2.692	11.13	0.438
		XXS					58.5	2.300	61.19	2.409	15.24	0.600
90	3 1/2	40	101.6	4.00	105	4.12	90	3.548	90.52	3.564	5.74	0.226
		80					85.5	3.364	86.42	3.402	8.08	0.318
100	4	40	114.3	4.50	117	4.62	102	4.026	102.73	4.044	6.02	0.237
		80					97	3.826	98.28	3.869	8.56	0.337
		120					92	3.624	93.78	3.692	11.13	0.438
		160					87.5	3.438	89.65	3.530	13.49	0.531
		XXS					80	3.152	83.30	3.279	17.12	0.674
125	5	40	141.3	5.56	144	5.69	128	5.047	128.80	5.070	6.55	0.258
		80					122	4.813	123.58	4.866	9.53	0.375
		120					116	4.563	118.04	4.647	12.70	0.500
		160					109.5	4.313	112.47	4.428	15.88	0.625
		XXS					103	4.063	106.92	4.209	19.05	0.750
150	6	40	168.3	6.62	172	6.78	154	6.065	154.82	6.094	7.11	0.280
		80					146.5	5.761	148.06	5.828	10.97	0.432
		120					140	5.501	142.29	5.600	14.27	0.562
		160					132	5.187	135.31	5.326	18.26	0.719
		XXS					124.5	4.897	128.85	5.072	21.95	0.864
200	8	40	219.1	8.62	223	8.78	203	7.981	203.75	8.020	8.18	0.322
		60					198.5	7.813	200.02	7.873	10.31	0.406
		80					193.5	7.625	195.84	7.709	12.70	0.500
		100					189	7.437	191.65	7.544	15.09	0.594
		120					182.5	7.187	186.11	7.326	18.26	0.719
		140					178	7.001	181.98	7.163	20.62	0.812
		XXS					174.5	6.875	179.16	7.053	22.23	0.875
		160					173	6.813	177.79	6.998	23.01	0.906
250	10	40	273.0	10.75	278	10.94	254.5	10.020	255.74	10.070	9.27	0.365
		60					247.5	9.750	249.74	9.834	12.70	0.500
		80					243	9.562	245.55	9.670	15.09	0.594
		100					236.5	9.312	240.01	9.451	18.26	0.719
		120					230	9.062	234.44	9.232	21.44	0.844
		140					222	8.750	227.51	8.959	25.40	1.000
		160					216	8.500	221.95	8.740	28.58	1.125
300	12	STD	323.8	12.75	329	12.97	305	12.000	306.08	12.053	9.53	0.375
		40					303	11.938	304.72	11.999	10.31	0.406
		XS					298.5	11.750	300.54	11.834	12.70	0.500
		60					295	11.626	297.79	11.725	14.27	0.562
		80					289	11.374	292.17	11.505	17.48	0.688
		100					281	11.062	285.24	11.232	21.44	0.844
		120					273	10.750	278.31	10.959	25.40	1.000
		140					266.5	10.500	272.75	10.740	28.58	1.125
		160					257	10.126	264.45	10.413	33.32	1.312
350	14	STD	355.6	14.00	362	14.25	336.5	13.250	337.88	13.303	9.53	0.375
		40					333.5	13.124	335.08	13.192	11.13	0.438
		XS					330	13.000	332.34	13.084	12.70	0.500
		60					325.5	12.812	328.15	12.920	15.09	0.594
		80					317.5	12.500	321.22	12.646	19.05	0.750
		100					308	12.124	312.86	12.318	23.83	0.938
		120					300	11.812	305.93	12.044	27.79	1.094
		140					292	11.500	299.00	11.771	31.75	1.250
		160					284	11.188	292.07	11.498	35.71	1.406



Buttwelding End Dimensions

Nominal Pipe Size		Schedule No. [Note(1)]	O.D. at Welding Ends				B		C [Note(3)]		t	
			Wrought or Fabricated Components, A [Note(1)]		Cast Steel Valves, A [Note(2)]							
DN	NPS		mm	in	mm	in	mm	in	mm	in	mm	in
400	16	STD	406.4	16.00	413	16.25	387.5	15.250	388.68	15.303	9.53	0.375
		40					381	15.000	383.14	15.084	12.70	0.500
		60					373	14.688	376.21	14.811	16.66	0.656
		80					363.5	14.312	367.84	14.482	21.44	0.844
		100					354	13.938	359.53	14.155	26.19	1.031
		120					344.5	13.562	351.18	13.826	30.96	1.219
		140					333.5	13.124	341.43	13.422	36.53	1.438
		160					325.5	12.812	334.50	13.170	40.49	1.594
450	18	STD	457.2	18.00	464	18.28	438	17.250	439.48	17.303	9.53	0.375
		XS					432	17.000	433.94	17.084	12.70	0.500
		40					428.5	16.876	431.19	16.975	14.27	0.562
		60					419	16.500	422.82	16.646	19.05	0.750
		80					409.5	16.124	414.46	16.318	23.83	0.938
		100					398.5	15.688	404.78	15.936	29.36	1.156
		120					387.5	15.250	395.03	15.553	34.93	1.375
		140					378	14.876	386.77	15.225	39.67	1.562
160					366.5	14.438	376.99	14.842	45.24	1.781		
500	20	STD	508.0	20.00	516	20.31	489	19.250	490.28	19.303	9.53	0.375
		XS					482.5	19.000	484.74	19.084	12.70	0.500
		40					478	18.812	480.55	18.920	15.09	0.594
		60					467	18.376	470.88	18.538	20.62	0.812
		80					455.5	17.938	461.13	18.155	26.19	1.031
		100					443	17.438	450.02	17.717	32.54	1.281
		120					432	17.000	440.29	17.334	38.10	1.500
		140					419	16.500	429.17	16.896	44.45	1.750
160					408	16.062	419.44	16.513	50.01	1.969		
550	22	STD	558.8	22.00	567	22.34	539	21.250	541.08	21.303	9.53	0.375
		XS					533	21.000	535.54	21.084	12.70	0.500
		60					514	20.250	518.86	20.428	22.23	0.875
		80					501	19.750	507.75	19.990	28.58	1.125
		100					488.5	19.250	496.63	19.553	34.93	1.375
		120					476	18.750	485.52	19.115	41.28	1.625
		140					463	18.250	474.41	18.678	47.63	1.875
		160					450.5	17.750	463.30	18.240	53.98	2.125
600	24	STD	609.6	24.00	619	24.38	590.5	23.250	591.88	23.303	9.53	0.375
		XS					584	23.000	586.34	23.084	12.70	0.500
		30					581	22.876	583.59	22.975	14.27	0.562
		40					574.5	22.624	577.97	22.755	17.48	0.688
		60					560.5	22.062	565.49	22.263	24.61	0.969
		80					547.5	21.562	554.38	21.826	30.96	1.219
		100					532	20.938	540.49	21.280	38.89	1.531
		120					517.5	20.376	528.03	20.788	46.02	1.812
		140					505	19.876	516.91	20.350	52.37	2.062
		160					490.5	19.312	504.37	19.857	59.54	2.344
650	26	10	660.4	26.00	670	26.38	645.5	25.376	645.50	25.413	7.92	0.312
		20					635	25.000	637.14	25.084	12.70	0.500
700	28	10	711.2	28.00	721	28.38	695.5	27.376	696.30	27.413	7.92	0.312
		20					686	27.000	687.94	27.084	12.70	0.500
		30					679.5	26.750	682.37	26.865	15.88	0.625
750	30	10	762.0	30.00	772	30.38	746	29.376	747.10	29.413	7.92	0.312
		20					736.5	29.000	738.74	29.084	12.70	0.500
		30					730	28.750	733.17	28.865	15.88	0.625
800	32	10	812.8	32.00	825	32.50	797	31.376	797.90	31.413	7.92	0.312
		20					787.5	31.000	789.54	31.084	12.70	0.500
		30					781	30.750	783.97	30.865	15.88	0.625
		40					778	30.624	781.17	30.755	17.48	0.688
850	34	10	863.6	34.00	876	34.50	848	33.376	848.70	33.413	7.92	0.312
		20					838	33.000	840.34	33.084	12.70	0.500
		30					832	32.750	834.77	32.865	15.88	0.625
		40					828.5	32.624	831.97	32.755	17.48	0.688
900	36	10	914.4	36.00	927	36.50	898.5	35.376	899.50	35.413	7.92	0.312
		20					889	35.000	891.14	35.084	12.70	0.500
		30					882.5	34.750	885.57	34.865	15.88	0.625
		40					876.5	34.500	880.02	34.646	19.05	0.750

NOTES:

- (1) Letter designations signify
 - (a) STD = standard wall thickness
 - (b) XS = extra-strong wall thickness
 - (c) XXS = double extra-strong wall thickness
- (2) The diameters listed are not requirements. They are provided for the convenience of the user.
- (3) Internal machining for continuous backing rings for sizes DN 50 (NPS 2) and smaller is not contemplated.