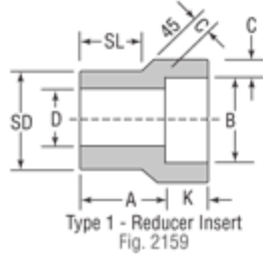
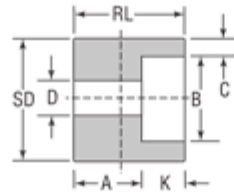


# Forged Steel Fittings

## Socket-Weld Reducer Inserts



Type 1 - Reducer Insert  
Fig. 2159



Type 2 - Reducer Insert  
Fig. 2179

### CLASS 3000

#### For use with Schedule 40 and 80 Pipe

Reducer inserts comply with MSS standard SP-79. They enable standard socket-weld fittings to be used for making any combination of pipe line reductions quickly and economically. Socket-weld reducer inserts serve SD D the same purpose as threaded reducing bushings with threaded fittings.

Size				Class 3000 – For use with Schedule 40 and 80 Pipe											
NPS	DN	NPS	DN	A		D		C Min.		SL		RL Min.		Unit Weight	
				in	mm	in	mm	in	mm	in	mm	in	mm	lbs	kg
1/2	15	1/4	8	0.81	20.57	0.364	9.25	0.149	3.78	0.62	15.75	–	–	0.18	0.08
		3/8	10	0.81	20.57	0.493	12.52	0.158	4.00	0.62	15.75	–	–		
3/4	20	1/4	8	0.69	17.53	0.364	9.25	0.149	3.78	–	–	1.06	27	0.25	0.11
		3/8	10	0.62	15.75	0.493	12.52	0.158	4.00	–	–	1.06	27		
		1/2	15	0.88	22.35	0.622	15.80	0.184	4.67	0.69	17.53	–	–		
1	25	1/4	8	0.75	19.05	0.364	9.25	0.149	3.78	–	–	1.12	28	0.35	0.16
		3/8	10	0.69	17.53	0.493	12.52	0.158	4.00	–	–	1.12	28		
		1/2	15	0.62	15.75	0.622	15.80	0.184	4.67	–	–	1.12	28		
		3/4	20	0.94	23.88	0.824	20.93	0.193	4.90	0.75	19.05	–	–		
1 1/4	32	1/4	8	0.88	22.35	0.364	9.25	0.149	3.78	–	–	1.25	32	0.35	0.25
		3/8	10	0.81	20.57	0.493	12.52	0.158	4.00	–	–	1.25	32		
		1/2	15	0.75	19.05	0.622	15.80	0.184	4.67	–	–	1.25	32		
		3/4	20	0.69	17.53	0.824	20.93	0.193	4.90	–	–	1.25	32		
		1	25	1.00	25.40	1.049	26.65	0.224	5.69	0.81	20.57	–	–		
1 1/2	40	3/8	10	0.88	22.35	0.493	12.52	0.158	4.00	–	–	1.31	33	0.62	0.28
		1/2	15	0.81	20.57	0.622	15.80	0.184	4.67	–	–	1.31	33		
		3/4	20	0.75	19.05	0.824	20.93	0.193	4.90	–	–	1.31	33		
		1	25	0.69	17.53	1.049	26.65	0.224	5.69	–	–	1.31	33		
		1 1/4	32	1.12	28.45	1.380	35.05	0.239	6.00	0.88	22.35	–	–		
2	50	1/2	15	1.00	25.40	0.622	15.80	0.184	4.67	–	–	1.50	38	1.50	0.68
		3/4	20	0.94	23.88	0.824	20.93	0.193	4.90	–	–	1.50	38		
		1	25	0.88	22.35	1.049	26.65	0.224	5.69	–	–	1.50	38		
		1 1/4	32	0.81	20.57	1.380	35.05	0.239	6.00	–	–	1.50	38		
		1 1/2	40	1.25	31.75	1.610	40.64	0.250	6.35	1.00	25.40	–	–		
2 1/2	65	3/4	20	1.56	39.62	0.824	20.93	0.193	4.90	–	–	2.12	54	3.00	1.36
		1	25	1.50	38.10	1.049	26.65	0.224	5.69	–	–	2.12	54		
		1 1/4	32	1.44	36.58	1.380	35.05	0.239	6.00	–	–	2.12	54		
		1 1/2	40	1.38	35.05	1.610	40.64	0.250	6.35	–	–	2.12	54		
		2	50	1.81	46.00	2.067	52.50	0.273	6.93	1.50	38.10	–	–		
3	80	1	25	1.25	31.75	1.049	26.65	0.224	5.69	–	–	1.87	47	4.40	2.00
		1 1/4	32	1.19	30.23	1.380	35.05	0.239	6.00	–	–	1.87	47		
		1 1/2	40	1.12	28.45	1.610	40.64	0.250	6.35	–	–	1.87	47		
		2	50	1.00	25.40	2.067	52.50	0.273	6.93	–	–	1.87	47		
		2 1/2	65	1.50	38.10	2.469	62.71	0.345	8.76	1.25	31.75	–	–		

To minimize the possibility of cracking of the fillet welds, it is recommended that the shank portion of the reducer be withdrawn approximately .0625 in. (1.6 mm) away from the contact with the bottom of the socket before starting the weld. Likewise, the pipe is to be kept away from contacting the bottom of the reducer socket before welding.