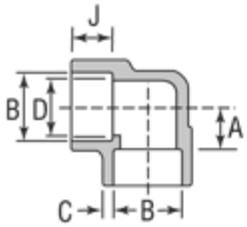
Forged Steel Fittings

Class 3000 Socket Weld

FIGURE 2150
90° Elbows



Size		A Nominal		B Socket Dia.		C Minimum		D Bore Dia.		J Socket Depth Minimum		Unit Weight	
NPS	DN	in	mm	in	mm	in	mm	in	mm	in	mm	lbs	kg
⅛	6	0.44	11.0	.440 .420	11.2 10.8	0.125	3.18	.299 .239	7.6 6.1	0.38	9.5	0.25	0.11
¼	8	0.44	11.0	.575 .555	14.6 14.2	0.130	3.30	.394 .334	10.0 8.5	0.38	9.5	0.31	0.14
⅜	10	0.53	13.5	.710 .690	18.0 17.6	0.138	3.50	.523 .463	13.3 11.8	0.38	9.5	0.31	0.14
½	15	0.62	15.5	.875 .855	22.2 21.8	0.161	4.09	.652 .592	16.6 15.0	0.38	9.5	0.53	0.24
¾	20	0.75	19.0	1.085 1.065	27.6 27.2	0.168	4.27	.854 .794	21.7 20.2	0.50	12.5	0.64	0.29
1	25	0.88	22.5	1.350 1.330	34.3 33.9	0.196	4.98	1.079 1.019	27.4 25.9	0.50	12.5	0.95	0.43
1¼	32	1.06	27.0	1.695 1.675	43.1 42.7	0.208	5.28	1.410 1.350	35.8 34.3	0.50	12.5	1.60	0.73
1½	40	1.25	32.0	1.935 1.915	49.2 48.8	0.218	5.54	1.640 1.580	41.6 40.1	0.50	12.5	2.12	0.96
2	50	1.50	38.0	2.426 2.406	61.7 61.2	0.238	6.04	2.097 2.037	53.3 51.7	0.62	16.0	3.66	1.66
2½	65	1.62	41.0	2.931 2.906	74.4 73.9	0.302	7.67	2.529 2.409	64.2 61.2	0.62	16.0	6.10	2.77
3	80	2.25	57.0	3.560 3.535	90.3 89.8	0.327	8.30	3.128 3.008	79.4 76.4	0.62	16.0	9.70	4.40
4	100	2.62	66.5	4.570 4.545	115.7 115.2	0.368	9.35	4.086 3.966	103.8 100.7	0.75	19.0	23.00	10.43

FIGURE 2151
45° Elbows

Size		A Nominal		B Socket Dia.		C Minimum		D Bore Dia.		J Socket Depth Minimum		Unit Weight	
NPS	DN	in	mm	in	mm	in	mm	in	mm	in	mm	lbs	kg
⅛	6	0.31	8.0	.440 .420	11.2 10.8	0.125	3.18	.299 .239	7.6 6.1	0.38	9.5	0.18	0.08
¼	8	0.31	8.0	.575 .555	14.6 14.2	0.130	3.30	.394 .334	10.0 8.5	0.38	9.5	0.16	0.07
⅜	10	0.31	8.0	.710 .690	18.0 17.6	0.138	3.50	.523 .463	13.3 11.8	0.38	9.5	0.18	0.08
½	15	0.44	11.0	.875 .855	22.2 21.8	0.161	4.09	.652 .592	16.6 15.0	0.38	9.5	0.43	0.20
¾	20	0.50	13.0	1.085 1.065	27.6 27.2	0.168	4.27	.854 .794	21.7 20.2	0.50	12.5	0.58	0.26
1	25	0.56	14.0	1.350 1.330	34.3 33.9	0.196	4.98	1.079 1.019	27.4 25.9	0.50	12.5	0.90	0.41
1¼	32	0.69	17.5	1.695 1.675	43.1 42.7	0.208	5.28	1.410 1.350	35.8 34.3	0.50	12.5	1.30	0.59
1½	40	0.81	20.5	1.935 1.915	49.2 48.8	0.218	5.54	1.640 1.580	41.6 40.1	0.50	12.5	1.57	0.71
2	50	1.00	25.5	2.426 2.406	61.7 61.2	0.238	6.04	2.097 2.037	53.3 51.7	0.62	16.0	2.73	1.24
2½	65	1.12	28.5	2.931 2.906	74.4 73.9	0.302	7.67	2.529 2.409	64.2 61.2	0.62	16.0	7.50	3.40
3	80	1.25	32.0	3.560 3.535	90.3 89.8	0.327	8.30	3.128 3.008	79.4 76.4	0.62	16.0	10.40	4.72
4	100	1.62	41.0	4.570 4.545	115.7 115.2	0.368	9.35	4.086 3.966	103.8 100.7	0.75	19.0	19.80	8.98

Note: When the pipe is seated against the bottom of the socket prior to welding, to prevent possible cracking of the fillet welds, it is recommended that the pipe be withdrawn approximately 1/16 in *(1.6mm)* away from contact with the bottom of the socket before starting the weld.

Average of socket wall thickness around periphery shall be no less than listed values. The minimum values are permitted in localized areas.