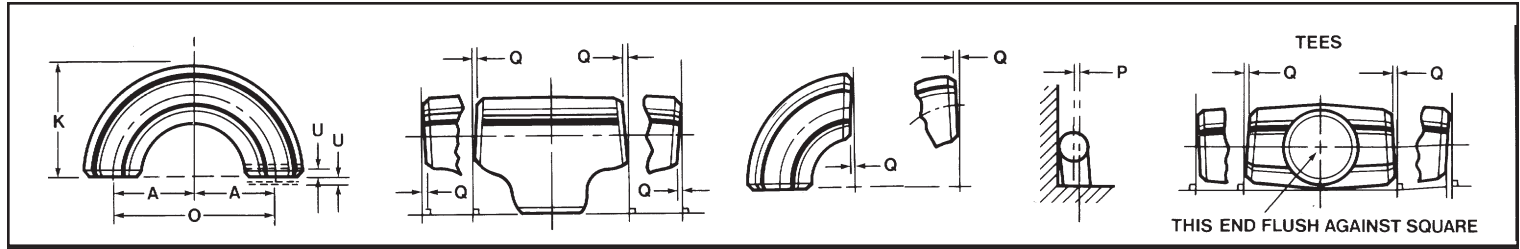


STAINLESS STEEL BUTT WELD DIMENSIONAL TOLERANCES

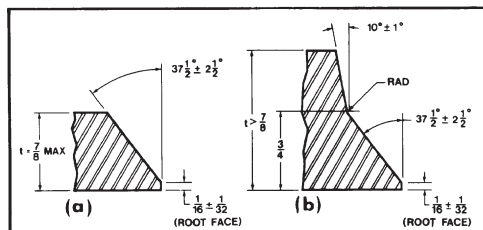


All Fittings	Reducers 90° and Lap 45° Ells and Joint Stub Tees Ends									Caps			180° Returns			Angularity Tol.		
	Nominal Pipe Plane Size (NPS)	Outside ⁽¹⁾ Diameter at Bevel	Inside ⁽²⁾ Diameter at End	Wall ⁽²⁾	Center-to- Thickness Dimension A,B,C,M	Overall End L	Overall Length E	Center-to- Length O	Back-to- Center K	Alignment Face U	Nominal at Ends Size	Off Pipe Q	Off Angle P					
1/2 TO 2-1/2	+1/16 -1/32	±1/32		±1/16	±1/16	±1/8	±1/4	±1/4	±1/32	1/2 TO 4 5 to 8	1/32 1/16	1/16 1/8						
3 To 3-1/2 4	±1/16 ±1/16	±1/16 ±1/16		±1/16 ±1/16	±1/16 ±1/16	±1/8 ±1/8	±1/4 ±1/4	±1/4 ±1/4	±1/32 ±1/32	10 to 12 14 to 16	3/32 3/32	3/16 1/4						
5 TO 8	+3/32 -1/16	±1/16	Not less than 87-1/2% of Normal Thickness	±1/16	±1/16	±1/4	±1/4	±1/4	±1/32	18 to 24	1/8	3/8						
10 TO 18	+1/16 -1/8	±1/8		±3/32	±3/32	±1/4	±3/8	±1/4	±1/16	All dimensions are in inches								
20 TO 24	+1/4 -3/32	±3/32		±3/32	±3/32	±1/4	±3/8	±1/4	±1/16									

(1) Out-of-round is the sum of absolute values of plus and minus tolerance.

(2) The inside diameter at ends and the nominal wall thicknesses are to be specified by the purchaser.

IN ACCORDANCE WITH ANSIB16.9 – B16.28



WELDING ENDS

Nominal Wall Thickness (1)

Less than x*
x* to 7/8 incl.
More than 7/8"
x* = 3/16" for carbon steel, ferritic alloy steel, or wrought iron; 1/8" for austenitic alloy steel.

End Preparation

Cut square or slightly chamfer, at mfr.'s option
Plain bevel as in sketch "a"
Compound bevel as in sketch "b"

IN ACCORDANCE WITH ANSIB16.9 – B16.28