

TOLERANCES OF GAUGE PIPE AND FITTINGS

Size of Pipe or Fitting		All Pipe and Fittings		90° Ells 45° Ells, Laterals, Tee's, Y's	Reducers Stub Ends, Connectors	Backing Rings			Squareness & Angle		Ovality at Welding Ends			
mm	In	O.D. at Welding End	Wall thks. at Welding End	Center to End. Dim.	Overall Length	O.D. I.D.	Bolt Circle	Concentric I.D. to Bolt Circle	A	B				
38	1-1/2	± 1/32" (± 1 mm)	I.D. & I.P.S. Piping: Not less than 87.5% of nominal thickness.	± 1/16" (± 2 mm)	± 1/16" (± 2 mm)			± 1/16"	1/32"	1/16"	± 1/16" (± 2 mm)			
51	2								1/32" (1 mm)	1/16" (2 mm)				
64	2	+ 1/16" - 1/32" (+ 2 mm) (- 1 mm)		± 3/32" (± 2.5 mm)	± 3/32" (± 2.5 mm)				+ 1/8"	± 1/16"	± 1/16"	1/16"	1/8"	± 3/32"
76	3								(2 mm)			(3 mm)	(± 2.5 mm)	
102	4	+ 3/32" - 1/32" (± 2.5 mm) (- 1 mm)		± 1/8"	± 1/8"				(± 3mm)	(± 2mm)	(± 2 mm)	3/32"	3/16"	± 1/8"
152	6											(2.5 mm)	(5 mm)	(± 3 mm)
203	8	± 1/8" - 1/32" (+ 3 mm) (- 1 mm)		± 3/32"	1/4"				± 5/32"	± 4 mm	± 3/16"	3/32"	1/4"	± 5/32"
254	10											(2.5 mm)	(7 mm)	(± 4 mm)
305	12	± 1/8" - 1/32" (+ 3 mm) (- 1 mm)		± 1/8"	± 1/8"				± 3/16"	± 3/8"	± 3/8"	1/8"	3/8"	± 3/16"
356	14											(3 mm)	(10 mm)	(± 5 mm)
406	16	± 1/8" - 1/32" (+ 3 mm) (- 1 mm)	± 1/8"	± 1/8"	± 3/16"	± 3/8"	± 3/8"	3/16"	3/8"	± 1/4" (± 7 mm)				
457	18							(2.5 mm)	(7 mm)		(± 4 mm)			
508	20	± 1/8" - 1/32" (+ 3 mm) (- 1 mm)	± 1/8"	± 1/8"	± 3/16"	± 3/8"	± 3/8"	3/16"	3/8"	± 1/4" (± 7 mm)				
610	24							(2.5 mm)	(7 mm)		(± 4 mm)			
762	30	± 1/8" - 1/32" (+ 3 mm) (- 1 mm)	± 1/8"	± 1/8"	± 3/16"	± 3/8"	± 3/8"	3/16"	3/8"	± 1/4" (± 7 mm)				
914	36							(2.5 mm)	(7 mm)		(± 4 mm)			
1016	40							3/16" (5 mm)	1/2" (13 mm)					

Pipe Straightness = .025" per foot

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
1/32	1/16	1/16	1/8	1/8	5/32	3/16	7/32	7/32	1/4	9/32	5/16	5/16	3/8	3/8	7/16	7/16	15/32	15/32	1/2

Note:

- Other tolerance requests from customers will be considered.
- Pressed van-stones and pressed stub-ends; wall thickness reduction may be greater than the tolerance shown above.
- Tolerance on piping assemblies will generally conform to spooling manufacturing tolerance shown on page E-4.

