

PIPE REINFORCING FOR FULL VACUUM SERVICE @ 200°C. STAINLESS STEEL I.D. PIPE

Notes:

1. Minimum total weld length on each side of stiffener not less than half circumference.
2. All dimensions are given in inches.

I.D.	WALL THICKNESS		Spacing (L)	STIFFENER RINGS	
	Unstiffened	Stiffened		Angle Size	Bar Size
1-1/2	14 GA (0.078®)	14 GA (0.078®)			
2	14 GA (0.078®)	14 GA (0.078®)			
2-1/2	14 GA (0.078®)			Not Required	
3	14 GA (0.078®)	14 GA (0.078®)			
4	14 GA (0.078®)	14 GA (0.078®)			
6	14 GA (0.078®)	14 GA (0.078®)			
8	12 GA (0.109®)	14 GA (0.078®)	80	1 x 1 x 1/4	1-1/2 x 1/4
10	12 GA (0.109®)	12 GA (0.109®)		Not Required	
12	11 GA (0.125®)	12 GA (0.109®)	120	1 x 1 x 1/4	1-1/2 x 1/4
14	10 GA (0.140®)	11 GA (0.125®)	120	1 x 1 x 1/4	1-1/2 x 1/4
16	3/16 (0.187®)	11 GA (0.125®)	80	1-1/2 x 1-1/2 x 3/16	2 x 3/16
18	3/16 (0.187®)	11 GA (0.125®)	60	1-1/2 x 1-1/2 x 3/16	2 x 3/16
20	1/4 (0.250®)	11 GA (0.125®)	60	1-1/2 x 1-1/2 x 1/4	2 x 1/4
24	1/4 (0.250®)	3/16 (0.187®)	120	2 x 2 x 1/8	2 x 5/16
26	1/4 (0.250®)	3/16 (0.187®)	120	2 x 2 x 3/16	2 x 5/16
30	5/16 (0.312®)	3/16 (0.187®)	80	2 x 2 x 3/16	2 x 3/8
36	3/8 (0.375®)	1/4 (0.250®)	120	2-1/2 x 2-1/2 x 3/16	2-1/2 x 3/8
42		1/4 (0.250®)	120	2-1/2 x 2-1/2 x 1/4	3 x 1/4
48		1/4 (0.250®)	110	2-1/2 x 2-1/2 x 1/4	3 x 1/4
54		1/4 (0.250®)	80	3 x 3 x 1/4	4 x 1/4

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