



CORPORATE STANDARD

AA 724 25 01

Rev. No. 02

PAGE 1 OF 3

ELBOWS 90° SOCKET WELDING

1.0. SCOPE :

This standard covers designation, materials, dimensions and sizes of socket welding 90° Elbows suitable for pressure classes 3000 and 6000 lbs.

- 1.1 3000 lbs Elbows can be used upto 900 pressure class and 6000 lbs El bow can be used for 1500 and 2500 pressure classes.

2.0 DESIGNATION:

(Eg :) A 90° E1 bow to this standard of pressure class 3000 lbs, carbon steel material and nominal size 1/2" shall be designated as follows:

2.1 On drawings

- i) Material specification column: AA 724 25 01.
- ii) Description column: ELBOUS 90 OEG 1/2* 3000 SU CS.

- 2.2 For placing indents on purchase: Elbow 90° socket welding, carbon steel, pressure class 3000 lbs, nominal size 1/2". AA 724 25 01.

- 2.3 For issuing enquiries and purchase orders: While issuing enquiries and purchase order's, delete the Corporate Standard No. From clause 2.2 and add the information given under clauses 3.0 (deleting the materials not applicable in clause 3. 2) and 4.0

3.0 COMPLIANCE WITH STANDARDS:

- 3.1 Dimensions, tolerances and other requirements

ANSI B16. 11-1991.

3.2 Material :

Carbon steel : to ASME: SA 105
Alloy steel : to ASME: SA 182 Gr: F 22
Stainless steel :to ASME :SA 182 Gr: F 321

4.0 TECHNICAL DEL(VERY CONDITIONS:

As per Corporate Standard AA 085 14 02 (a copy to be enclosed).

5.0 NOTE:

- 5.1 Weights given in the table are for general reference only and are not meant for commercial transactions.
- 5.2 Corporate sub codes are shown in the table against corporate rationalized sizes.
- 5.3 Sizes used by individual plants are covered in the Annexure along with complete code numbers.

COPYRIGHT AND CONFIDENTIAL
The Information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED
It must not be used directly or indirectly in any way detrimental to the interest of the company.

Revisions:

Revised as per ANSI B16.11-1991

APPROVED:

INTERPLANT STANDARDIZATION
COMMITTEE- (IPSC-SMC+RP)

Rev. No. 02

Amd.No.

Reaffirmed

Prepared

Issued

Dt. of 1st. Issue

Dt: 1-12-95

Dt:

Year:

HYDERABAD

Corp. R&D

FEB. '81

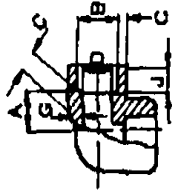


CORPORATE STANDARD

AA 724 25 01

REV. No. 02

PAGE 3 OF 3



90° ELBOW

(All dimensions are in mm unless otherwise specified)

Pressure class designation : 3000lbs

Nom. Pipe size inches	Socket bore dia. B		Bore dia of fitting D		Socket wall thickness C		Body wall G min.	Depth of socket J min	Center-to-bottom of socket-A		Wt/piece kg	Sub code		
	Max.	Min.	Max.	Min.	Ave.	Min.			Max.	Min.		Carbon steel	Alloy steel	Stainless steel
1/8	11.15	10.65	4.8	3.2	3.95	3.45	3.10	10	12	10		288	377	466
1/4	14.60	14.10	7.1	5.6	4.6	4.0	3.70	10	17	13		296	385	474
3/8	18.05	17.55	9.9	8.4	5.05	4.35	4.00	10	17	14		300	393	482
1/2	22.20	21.70	12.5	11.0	5.95	5.2	4.80	10	21	18	0.40	318	407	490
3/4	27.55	27.05	16.3	14.8	6.95	6.05	5.55	13	24	21	0.63	326	415	504
1	34.30	33.80	21.5	19.9	7.9	6.95	6.35	13	29	25	1.0	334	423	512
1 1/4	43.05	42.55	30.2	28.7	7.9	6.95	6.35	13	34	30	1.40	342	431	520
1 1/2	48.15	48.65	34.7	33.2	8.9	7.80	7.15	13	40	36	2.35	350	420	539
2	61.60	61.10	43.6	42.1	10.9	9.50	8.75	16	43	39	3.0	369	458	547