



CORPORATE STANDARD

AA7242504

Rev. No. 05

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ELBOWS 90°, LONG RADIUS, SEAMLESS BUTT WELDING STAINLESS STEEL

1.0 SCOPE:

This standard covers designation, material, sizes and dimensions of seamless butt welding 90° long radius elbows.

2.0 DESIGNATION:

A 90° long radius seamless elbow to this standard of nominal size 2" and schedule 40 S shall be designated as follows:

2.1 On drawings:

- a) Material specification column: AA 7242504
- b) Description column: ELBOW 90° LR 2" SCH 40 S BW SS.

2.2 For placing indents on purchase:

Elbow 90°, long radius, seamless, butt welding, stainless steel nominal size 2"sch 40S, AA7242504

2.3 For issuing enquiries and on purchase orders:

While issuing enquiries and purchase orders delete BHEL standard number from the clause 2.2 and add the information given under clause 3.0 (delete the material not applicable in Clause 3.2) and 4.0.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

- 3.1 Dimensions, Tolerances & General requirements: ASME B16.9 – 2012
- 3.2 Material: Stainless steel to ASME SA 403, Gr.: WP 321

4.0 TECHNICAL DELIVERY CONDITIONS:

As per BHEL standard AA0851402.

5.0 REFERRED STANDARDS (Latest publications including amendments):

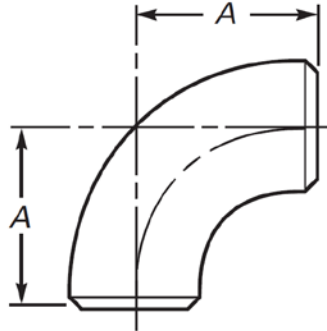
- 1) AA0851402
- 2) ASME SA 403

Revisions:
Revised in-line with ASME B16.9 – 2012.

APPROVED:
INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC (SMC+RP)

Rev. No. 05	Amd. No.	Reaffirmed	Prepared	Issued	Dt. of 1 st Issue
Dt: 15-03-2014	Dt:	Year:	HPEP, Hyderabad	Corp. R&D	February, 1981

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**ELBOW 90°**

All dimensions are in 'mm' unless otherwise specified.

Nom. Pipe Size in inches	Schedule	ASME Pipe size OD X Th.	Out Side dia. bevel		Centre-to-End: 'A'		Wt./piece kg	Sub-code
			NOM	TOL.	NOM	TOL.		
1/2	40S	21.3 X 2.77	21	±1	38	±2	0.16	015
	80S	21.3 X 3.73					0.2	023
3/4	40S	26.7 X 2.87	27		38		0.2	031
	80S	26.7 X 3.91					0.3	040
	160S	26.7 X 5.56					0.3	058
1	40S	33.4 X 3.38	33		38		0.3	066
	80S	33.4 X 4.55					0.44	074
	160S	33.4 X 6.35					0.57	082
1 1/4			42		48			
1 1/2	40S	48.3 X 3.68	48		57		0.77	104
	160S	48.3 X 7.14					1.6	112
2	10S	60.3 X 2.77	60		76		1.3	120
	40S	60.3 X 3.91					1.8	139
	80S	60.3 X 5.54					1.9	147
	160S	60.3 X 8.74		2.7		155		
2 1/2			73	95				
3	10S	88.9 X 3.05	89	114	3.1	171		
	40S	88.9 X 5.49			3.8	180		
	80S	88.9 X 7.62			4.5	198		
	XXS	88.9 X 15.24			7.6	201		
3 1/2			102	133				
4	10S	114.3 X 3.05	114	+2 -1	152	2.1	228	
	40S	114.3 X 6.02				3.9	238	
	160S	114.3 X 13.49				8.1	244	
	XXS	114.3 X 17.12				9.9	252	
5			141	190				
6	10S	168.3 X 3.40	168	+3 -1	229	5.5	279	
	40S	168.3 X 7.11				10.5	287	
	80S	168.3 X 10.97				15.5	295	
8	10S	219.1 X 3.76	219	±2	305		309	
	40S	219.1 X 8.18				11.3	317	
	80S	219.1 X 12.7				21.1	325	
10	10S	273.0 X 4.19	273	+4 -3	381	31.2	333	
	40S	273.0 X 9.27				20.1	341	



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			NOM	TOL.	NOM	TOL.		
12			324	+4 - 3	457	±3	37.2	
14			355		533			
16	10 S	406.4X 6.35	406		610			376
18	10 S	457 X 6.35	457	686			384	
20			508	+6 - 5	762			
22			559		838			
24			610		914			

NOTE:

- 1) The weight given in the table are for general reference only and are not for commercial transactions.
- 2) Corporate sub-codes are shown in the table against corporate rationalised sizes.