



**TEES, SOCKET WELDING**

**1.0 SCOPE :**

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

1.1 3000 lbs Tees can be used upto 900 pressure class and 6000 lbs Tees can be used for 1500 and 2500 pressure classes.

**2.0 DESIGNATION :**

Eg: A Tee to this standard of pressure classes 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 10
- ii) Description column : TEE 1/2, 3000 SW CS

2.2 For placing indents on purchase: Tee, socket welding, carbon steel, pressure class 3000 lbs, nominal size 1/2" AA 724 25 10.

2.3 For issuing enquiries and purchase orders : While issuing enquiries and purchase orders, 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 DELIVERY CONDITIONS :**

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

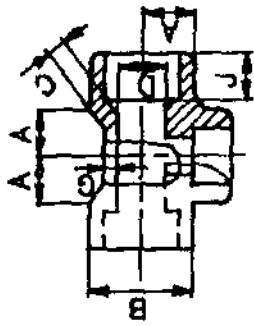
**5.0 NOTE :**

- 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.

<b>Revision:</b> Revised as per ANSI B16.11-1991			<b>Approved:</b> INTERPLANT STANDARDIZATION COMMITTEE-WG (IPSC-SMC+RP)		
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**TEE**

(All dimensions are in mm unless otherwise specified)

Pressure class designation : 6000lbs.

Nom. pipe size inches	Socket bare 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	3.15	10	12	10		287	376	465
1/4	14.60	14.1	7.1	5.6	4.6	4.0	3.70	10	17	13		295	384	473
3/8	18.05	17.55	9.9	8.4	5.05	4.35	4.00	10	17	14		309	392	481
1/2	22.20	21.7	12.5	11.0	5.95	5.2	4.8	10	21	18	0.58	317	406	490
3/4	27.55	27.05	16.3	14.8	6.95	6.05	5.55	13	24	21	1.20	325	414	503
1	34.30	33.8	21.5	19.9	7.9	6.95	6.35	13	29	25	1.58	333	422	511
1 1/4	43.05	42.55	30.2	28.7	7.9	6.95	6.35	13	34	30	1.60	341	430	520
1 1/2	49.15	48.65	34.7	33.2	8.9	7.8	7.15	13	40	36	3.01	350	449	538
2	61.60	61.1	43.6	42.1	10.9	9.5	8.75	16	43	39	3.60	368	457	548