



# CORPORATE STANDARD

AA 724 25 11

Rev. No. 03

PAGE 1 OF 3

## TEES, STRAIGHT, SEAMLESS, BUTT WELDING, CARBON STEEL (HIGH TEMPERATURE SERVICE)

### 1.0 SCOPE:

This standard covers designation, material, sizes and dimensions of seamless butt welding straight Tees.

### 2.0 DESIGNATION:

A seamless straight Tee to this standard of nominal size 2" and schedule 40 shall be designated as follows:

#### 2.1. On drawings:

- (a) Material specification column: AA 724 25 11
- (b) Description column : TEE STRT 2" SCH 40 BW CS HT.

#### 2.2 For placing indents on purchase:

Seamless straight Tee, butt welding, carbon steel, nominal size 2", sch 40, AA 724 25 11.

#### 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 Cl 3.2) and 4.0.

### 3.0 COMPLIANCE WITH NATIONAL STANDARDS:

3.1 **Dimensions, Tolerances & General requirements** : ANSI B 16.9-1993

3.2 **Material** : Carbon steel to ASME SA 234, Gr.: WPB

### 4.0 TECHNICAL DELIVERY CONDITIONS:

As per BHEL standard AA 085 14 02.

### 5.0 REFERRED STANDARDS (Latest publications including amendments):

- 1) ANSI B 16.9
- 2) AA 085 14 02
- 3) ASME SA 234

**Revisions :**  
Cl. 20.8.25 of MOM of WG-SMC+RP

**APPROVED :**  
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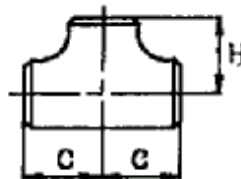
Dt :

Year :

HYDERABAD

Corp. R&D

FEB, 1981



STRAIGHT TEE

(All dimensions in mm otherwise specified)

Nom. pipe size Inches	Schedule	ANSI pipe size OD X Th.	out side dia. at level		centre-to-end			wt./ piece kg	sub-code
			Nom.	Tol.	Run c Nom.	outlet M Tol.	Tol. on C&M		
1/2	80	21.3x3.73	21	±1	25	25	±2	0.24	011
	160	21.3x4.78						0.25	020
3/4	80	26.7x3.91	27		29	29		0.23	038
	160	26.7x5.56			0.26	046			
1	80	33.4x4.55	33		38	38		0.35	054
	160	33.4x6.35			0.44	062			
1 1/4			42		48	48			
1 1/2	80	48.3x5.08	48		57	57		0.96	089
	160	48.3x7.14			1.20	097			
	XXS	48.3x10.16			1.50	100			
2	40	60.3x3.91	60		64	64		1.80	119
	80	60.3x5.54			1.98	127			
	160	60.3x8.74		2.26	135				
	XXS	60.3x11.07		2.56	143				
2 1/2			73	76	76				
3	40	88.9x5.49	89	88	88	3.8	180		
	80	88.9x7.62		4.5	178				
	160	88.9x11.12		6.25	186				
	XXS	88.9x15.24		7.5	194				
3 1/2			102	95	95				
4	40	114.3x6.02	114	+2	105	105	8.10	216	
	80	114.3x8.56					-1	8.40	224
	120	114.3x11.12		9.50			232		
	160	114.3x13.49		13.8			240		
	XXS	114.3x17.12		14.5			259		
5			141	124	124				
6	40	168.3x7.11	168	+3	143	143	16.5	275	
	80	168.3x10.97					-1	19.5	283
	120	168.3x14.27		24.5			291		
	XXS	168.3x21.95		31.9			305		



# CORPORATE STANDARD

AA 724 25 11

Rev. No. 03

PAGE 3 OF 3

**ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED**

Nominal pipe size Inches	Schedule	ANSI Pipe size OD X Th	Outside dia. at bevel		Centru-to-end			Wt./piece kg	Sub-code
			Nom.	Tol.	Run C	Outlet M	Tol. on C&M		
8	20	219.1X 6.35	219	± 2	178	178	± 2	24.0	313
	80	219.1X12.70						30.0	321
	120	219.1X18.20						52.0	330*
10	20	273 X 6.35	273	+ 4 - 3	216	216	± 2	33.0	348
	30	273 X 7.80						39.0	356
	80	273 X15.08						66.0	364
	140	273 X25.40							
12	20	323.8X 6.35	324		254	254	± 3	55.0	380
	40	323.8X 10.31						60.0	399
	80	323.8X 17.47						110.0	402
14	20	355.6X 7.92	356		279	279		54.75	410
16	10	406.4X 6.35	406		305	305		50.18	429
18	10	457.0X 6.35	457		343	343		56.13	437
20	10	508.0 X6.35	508	+ 6	381	381		62.72	445
22			559	- 5	419	419			
24			610		432	432			

**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.
3. Sizes used by individual plants are covered in the Annexure along with complete code numbers.