



CORPORATE STANDARD

AA 724 25 20

Rev. No. 02

PAGE 1 OF 3

COUPLING, SOCKET VEIDIHG

1.0 SCOPE :

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

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

2.0 DESIGHATION:

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

2.1 On drawing:

2.2

i) Material specification column; AA724 25 20.

ii) Description column: CQUPLIHG 1/2* 3000 SU OS.

2.3 For placing indents on purchase: Coupling socket welding, carbon steel, pressure class 3000 lbs, nominal size 1/2' AA 724 25 20.

2.4 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

4.0 COMPLIANCE WITH STANDARDS

4.1 Dimensions tolerances and other requirements:

ANSI B16.11-1991.

4.2 Material:

| | | |
|-----------------|------------|------------------|
| Carbon steel | : to ASHE: | SA 105 |
| Alloy steel | : to ASME: | SA 1S2 Gr: F 22 |
| Stainless steel | : to ASME: | SA 162 Gr: F 321 |

4.0 TECHH1CAL DELIVERY CONDITIONS:

As per Corporate Standard AA 085 14 02 (a copy to been closed).

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.

Revision:

Revised as per ANSI B16.41-1991

APPROVED:
INTERPLANT STANDARDIZATION
COMMITTEE – WG – (IPSC-SMC+RP)

Rev. No. 02

Amd.No.

Reaffirmed

Prepared
HYDERABAD

Issued
Corp. R&D

Dt. Of 1st Issue
10.FEB.'81

Dt.:

Dt:

Year:

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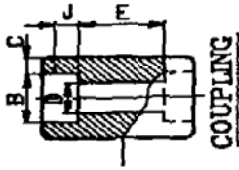


CORPORATE STANDARD

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COUPLING

(All dimensions are in mm unless otherwise specified)

Pressure class designation : 6000lbs

| Nom. Pipe size inches | Socket bore dia. B | | Bore dia of fitting D | | Socket wall thickness C | | 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 | 10 | 8 | 5 | | 282 | 371 | 460 |
| 1/4 | 14.60 | 14.1 | 7.1 | 5.6 | 4.6 | 4.0 | 10 | 8 | 5 | 0.09 | 290 | 380 | 479 |
| 3/8 | 18.05 | 17.55 | 9.9 | 8.4 | 5.05 | 4.36 | 10 | 9 | 3 | 0.13 | 309 | 398 | 487 |
| 1/2 | 22.20 | 21.7 | 12.5 | 11.0 | 5.95 | 5.2 | 10 | 13 | 6 | 0.21 | 312 | 401 | 485 |
| 3/4 | 27.55 | 27.05 | 16.3 | 14.8 | 6.95 | 6.05 | 13 | 13 | 6 | 1.28 | 320 | 410 | 509 |
| 1 | 34.30 | 33.8 | 21.5 | 19.9 | 7.9 | 6.95 | 13 | 17 | 9 | 1.48 | 339 | 428 | 517 |
| 1 1/4 | 43.05 | 42.55 | 30.2 | 28.7 | 7.9 | 6.95 | 13 | 17 | 9 | 1.68 | 347 | 436 | 525 |
| 1 1/2 | 48.15 | 48.65 | 34.7 | 33.2 | 8.9 | 7.8 | 13 | 17 | 9 | 1.05 | 355 | 444 | 533 |
| 2 | 61.60 | 61.1 | 43.6 | 42.1 | 10.9 | 9.5 | 16 | 23 | 15 | 1.95 | 363 | 452 | 541 |