



CORPORATE STANDARD

AA 724 25 30

Rev. No. 03

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REDUCERS, CONCENTRIC, SEAMLESS, BUTT WELDING, CARBON STEEL (HIGH TEMPERATURE SERVICE)

1.0 SCOPE:

This standard covers designation, material, sizes and dimensions of seamless butt welding concentric reducers.

2.0 DESIGNATION:

A seamless concentric reducer to this standard of nominal size 2" x 1" and schedule 40 x 80 shall be designated as follows:

2.1. On drawings:

- (a) Material specification column: AA 724 25 30
- (b) Description column : CONTC RDCR 2" x 1" SCH 40 x 80 BW CS HT .

2.2 For placing indents on purchase:

Seamless concentric reducer, butt welding, carbon steel, nominal size 2" x 1", sch 40 x 80, AA 724 25 30.

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 :

INTERPLANT
STANDARDIZATION COMMITTEE- SMC+RP

Rev. No. 03

Amd.No.

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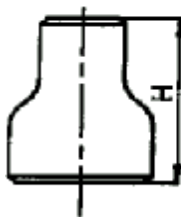
Dt :

Year :

HYDERABAD

Corp. R&D

FEB, 1981



CONCENTRIC REDUCER

(All dimensions are in mm unless otherwise specified)

Nom. pipe size inches	Schedule	ANSI pipe size OD x Th.		OD of large end		OD of small end		End-to-end H:		Wt./ piece Kg	sub-code
		Large end	Small end	Nom.	Tol.	Nom.	Tol.	Nom.	Tol.		
1x1/2	80 x 80	33.4 x 4.55	21.3 x 3.73	33		21		51	±2	0.03	016
	160 x 160	33.4 x 6.35	21.3 x 4.78							0.04	024
2X1	40 x 80	60.3 x 3.91	33.4 x 4.55	60		33		76		0.40	032
	80 x 80	60.3 x 5.54	33.4 x 4.55							0.56	040
	80 x 160	60.3 x 5.54	33.4 x 6.35							0.78	059
	160 x 80	60.3 x 8.74	33.4 x 4.55							0.84	067
	XXS x 160	60.3 x 11.07	33.4 x 6.35							1.00	075
	40 x 80	60.3 x 3.91	48.3 x 5.08							0.40	083
2x1 1/2	80 x 80	60.3 x 5.54	48.3 x 5.08	60	±1	48	±1	76		0.56	091
	160 x 160	60.3 x 8.74	48.3 x 7.14							0.84	105
	XXS x XXS	60.3 x 11.07	48.3 x 10.16							1.00	113
	40 x 80	88.9 x 5.49	48.3 x 5.08							1.00	121
3x1 1/2	80 x 80	88.9 x 7.62	48.3 x 5.08	89		48		89	1.30	130	
	160 x 160	88.9 x 11.12	48.3 x 7.14						1.80	148	
	XXS x XXS	88.9 x 15.24	48.3 x 10.16						2.50	158	
	40 x 40	88.9 x 5.49	60.3 x 3.91						1.00	164	
3X2	40 x 80	88.9 x 5.49	60.3 x 5.54	89		60		89	1.00	172	
	80 x 80	88.9 x 7.82	60.3 x 5.54						1.30	180	
	160 x 160	88.9 x 11.12	60.3 x 8.74						1.80	199	
	XXS x XXS	88.9 x 15.24	60.3 x 11.07						2.50	202	
4X2	40 x 40	114.3 x 8.02	60.3 x 3.91	114	+2 -1	60		102	1.80	210	
	80 x 80	114.3 x 8.56	60.3 x 5.54						2.20	229	
	120 x 80	114.3 x 11.12	60.3 x 5.54						3.00	237	
	160 x 160	114.3 x 13.49	60.3 x 8.74						3.4	245	
	XXS x XXS	114.3 x 17.12	60.3 x 11.07						4.1	253	



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(All dimensions are in mm unless otherwise specified)

Nom. pipe size inches	Schedule	ANSI pipe size OD x Th.		OD of large end		OD of small end		End-to-end H		Wt./piece Kg	sub-code
		Large end	Small end	Nom.	Tol.	Nom.	Tol.	Nom.	Tol.		
4X3	40 x 40	114.3 x 8.02	88.9 x 5.49							1.6	261
	80 x 40	114.3 x 8.56	88.9 x 5.49							2.2	270
	120 x 80	114.3 x 11.12	88.9 x 7.62			89	±1	102		3.0	288
	160 x 160	114.3 x 13.49	88.9 x 11.12							3.4	296
	XXS x 160	114.3 x 17.12	88.9 x 15.24							4.1	300
6X3	40 x 40	168.3 x 7.11	88.9 x 5.49							4.0	318
	80 x 40	168.3 x 10.97	88.9 x 5.49							5.9	326
	120 x 80	168.3 x 14.27	88.9 x 7.62			89		140		7.5	334
	XXS x 160	168.3 x 21.95	88.9 x 11.12							11.0	342
	40 x 40	168.3 x 7.11	114.3 x 6.02							4.0	350
6X4	80 x 80	168.3 x 10.97	114.3 x 8.56							5.9	369
	120 x 120	168.3 x 14.27	114.3 x 11.12			114	+2 -1	140		7.5	377
	XXS x 160	168.3 x 21.95	114.3 x 13.49							11.0	385
	20 x 40	219.1 x 6.35	114.3 x 6.02							5.0	393
	80 x 80	219.1 x 12.70	114.3 x 8.56							9.8	407
8X4	120 x 120	219.1 x 18.20	114.3 x 11.12			114		152		16.5	415
	20 x 40	219.1 x 6.35	168.3 x 7.11							5.0	423
	80 x 80	219.1 x 12.70	168.3 x 10.97							9.8	431
8X6	120 x 120	219.1 x 18.20	168.3 x 14.27			168	+3 -1	152		16.5	440
	20 x 40	273 x 6.35	168.3 x 7.11							7.3	458
	30 x 40	273 x 7.80	168.3 x 7.11							10.7	466
10X6	80 x 80	273 x 15.08	168.3 x 10.97							17.0	474
	20 x 20	273 x 6.35	219.1 x 6.35							7.3	482
	30 x 20	273 x 7.80	219.1 x 6.35							10.7	490
10X8	80 x 80	273 x 15.08	219.1 x 12.70			219	±2	178		17.0	504
	20 x 20	323.8 x 6.35	219.1 x 6.35							10.0	512
	40 x 20	323.8 x 10.31	218.1 x 6.35							15.0	520
12X8	80 x 80	323.8 x 17.47	219.1 x 12.70			219		203		27.0	539

CORPORATE STANDARD



(All dimensions are in mm unless otherwise specified)

Nom. pipe size Inches	Schedule	ANSI pipe size OD x Th.		OD of large end		OD of small end		End-to-end H		Wt./ piece Kg	sub-code
		Large end	Small end	Nom.	Tol.	Nom.	Tol.	Nom.	Tol.		
12X10	20 x 20	323.8 x 6.35	273 x 6.35	324		273	+4 -3	203		10.0	547
	40 x 30	323.8 x 10.31	273 x 7.80							15.0	555
	80 x 80	323.8 x 17.47	273 x 15.08							27.0	563
14X10	10 x 20	355.6 x 6.35	273 x 6.35	356		273		330		18.0	571
	40 x 30	355.6 x 11.12	273 x 7.80							35.0	580
14X12	10 x 20	355.6 x 6.35	323.8 x 6.35	356		324		330		18.0	598
	40 x 40	355.6 x 11.12	323.8 x 10.31							35.0	601
16X8	40 x 30	406.4 x 12.70	219.1 x 7.04	406	+4 -3	219	±2	356	±3	15.0	610
16X10	40 x 30	406.4 x 12.70	273 x 7.80	406		273		356		16.2	628
16X12	10 x 20	406.4 x 6.35	323.8 x 6.35	406		324		356		22.0	636
16X14	40 x 40	406.4 x 12.70	323.8 x 10.31	406		356	+4 -3	356		44.0	644
	10 x 10	406.4 x 6.35	355.6 x 6.35							22.0	652
18X14	40 x 40	406.4 x 12.70	355.6 x 11.12	457		356		381		44.0	660
	10 x 10	457.2 x 6.35	355.6 x 6.35							27.0	679
18X16	40 x 40	457.2 x 14.27	355.5 x 11.12	457		356		381		53.0	687
	10 x 10	457.2 x 6.35	406.4 x 6.35			406		381		27.0	695
20X16	40 x 40	457.2 x 14.27	406.4 x 12.70	457		406		508		53.0	709
20X18	10 x 10	508 x 6.35	406.4 x 6.35	508		406		508		39.0	717
	10 x 10	508 x 6.35	457.2 x 6.35	508		457		508		39.0	725

NOTE :

1. Weights given in the table are for general reference only and are not meant 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.