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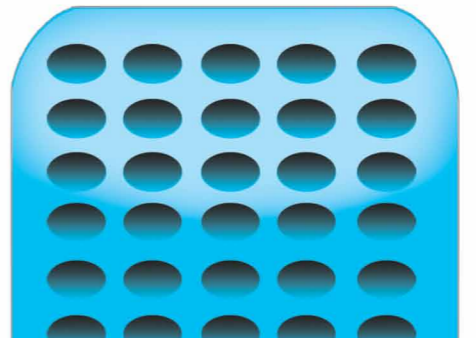
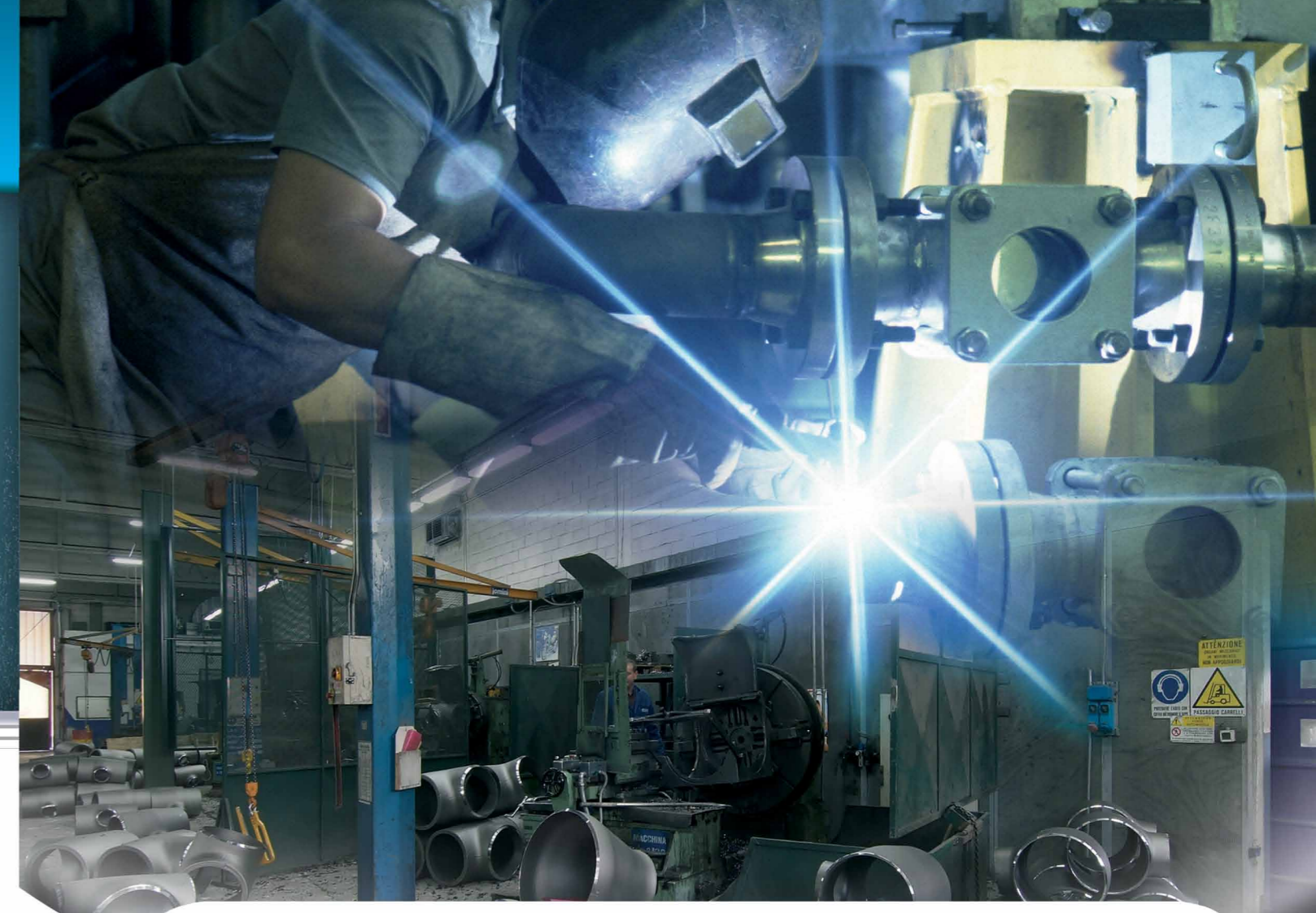
Località La Casetta - 29010 Nibbiano Val Tidone (Piacenza), Italy
Tel. +39 0523 991011 - Fax +39 0523 990688
raccordiforgiati@raccordiforgiati.com - www.raccordiforgiati.com

Sales Office

Località Vascellino - 29010 Nibbiano Val Tidone (Piacenza), Italy
Tel. +39 0523 991211 - Fax +39 0523 991277



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RACCORDI A SALDARE DI TESTA BUTTWELDING FITTINGS

Dimensioni e tolleranze
Dimensions and tolerances

Dimensioni secondo ASME B 36.10M / Dimensions according to ASME B 36.10M														ASME B 36.19M					
Diametro nominale	Diametro esterno	Spessori nominali / Nominal wall thicknesses												Spessori nominali / Nominal wall thicknesses					
Nominal pipe size	Outside diameter	Sch. 10	Sch. 20	Sch. 30	Standard wt	Sch. 40	Sch. 60	Extra strong	Sch. 80	Sch. 100	Sch. 120	Sch. 140	Sch. 160	Double extra strong	Sch. 5 S	Sch. 10 S	Sch. 40 S	Sch. 80 S	
1/2"	21.30				2.77	2.77		3.73	3.73					4.78	7.47	1.65	2.11	2.77	3.73
3/4"	26.70				2.87	2.87		3.91	3.91					5.56	7.82	1.65	2.11	2.87	3.91
1"	33.40				3.38	3.38		4.55	4.55					6.35	9.09	1.65	2.77	3.38	4.55
1 1/4"	42.20				3.56	3.56		4.85	4.85					6.35	9.70	1.65	2.77	3.56	4.85
1 1/2"	48.30				3.68	3.68		5.08	5.08					7.14	10.15	1.65	2.77	3.68	5.08
2"	60.30				3.91	3.91		5.54	5.54					8.74	11.07	1.65	2.77	3.91	5.54
2 1/2"	73.00				5.16	5.16		7.01	7.01					9.53	14.02	2.11	3.05	5.16	7.01
3"	88.90				5.49	5.49		7.62	7.62					11.13	15.24	2.11	3.05	5.49	7.62
3 1/2"	101.60				5.74	5.74		8.08	8.08							2.11	3.05	5.74	8.08
4"	114.30				6.02	6.02		8.56	8.56				11.13	13.49	17.12	2.11	3.05	6.02	8.56
5"	141.30				6.55	6.55		9.53	9.53				12.70	15.88	19.05	2.77	3.40	6.55	9.53
6"	168.30				7.11	7.11		10.97	10.97				14.27	18.26	21.95	2.77	3.40	7.11	10.97
8"	219.10		6.35	7.04	8.18	8.18	10.31	12.70	12.70	15.09	18.26	20.62	23.01	22.23	2.77	3.76	8.18	12.70	
10"	273.10		6.35	7.80	9.27	9.27	12.70	12.70	15.09	18.26	21.44	25.40	28.58	25.40	3.40	4.19	9.27	12.70	
12"	323.90		6.35	8.38	9.53	10.31	14.27	12.70	17.48	21.44	25.40	28.58	33.32	25.40	3.96	4.57	9.53	12.70	
14"	355.60	6.35	7.92	9.53	9.53	11.13	15.09	12.70	19.05	23.83	27.79	31.75	35.71		3.96	4.78	9.53	12.70	
16"	406.40	6.35	7.92	9.53	9.53	12.70	16.66	12.70	21.44	26.19	30.96	36.53	40.49		4.19	4.78	9.53	12.70	
18"	457.00	6.35	7.92	11.13	9.53	14.27	19.05	12.70	23.83	29.36	34.93	39.67	45.24		4.19	4.78	9.53	12.70	
20"	508.00	6.53	9.53	12.70	9.53	15.09	20.62	12.70	26.19	32.54	38.10	44.45	50.01		4.78	5.54	9.53	12.70	
22"	559.00	6.35	9.53	12.70	9.53		22.23	12.70	28.58	34.93	41.28	47.63	53.98		4.78	5.54			
24"	610.00	6.35	9.53	14.27	9.53	17.48	24.61	12.70	30.96	38.89	46.02	52.37	59.54		5.54	6.35	9.53	12.70	
26"	660.00	7.92	12.70		9.53														
28"	711.00	7.92	12.70	15.88	9.53														
30"	762.00	7.92	12.70	15.88	9.53														
32"	813.00	7.92	12.70	15.88	9.53	17.48									6.35	7.92			
34"	864.00	7.92	12.70	15.88	9.53	17.48													
36"	914.00	7.92	12.70	15.88	9.53	19.05													

Nota: oltre il 36" esistono solo le schedule STD (9.52 mm) e XS (12.7) / Note: above 36" there are only STD (9.52 mm) and XS (12.7 mm) schedules

Materiali utilizzati e relativi Standard Internazionali Materials used and related International Standards

- ACCIAIO AL CARBONIO E LEGATO PER MEDIE E ALTE TEMPERATURE
CARBON AND ALLOY STEEL
FOR MODERATE AND ELEVATED TEMPERATURES**
 - ASTM/ASME A/SA 234: WPB, WPC, WP1, WP11, WP12, WP5, WP22, WP9, WP91
 - EN 10216-2: P195GH, P235GH, P265GH, 20MnNb6, 16Mo3, 8MoB5-4, 14MoV63, 10CrMo5-5, 13CrMo4-5, 10CrMo9-10, 15NiCuMoNb5-6-4, X11CrMo5, X11CrMo9-1, X10CrMoVb9-1, X10CrMoVb9-2, X20CrMoV11-1 (former BS-DIN-AFNOR equivalent grades)
 - EN 10253-1 EN 10253-2
- ACCIAIO AD ALTO SNERVAMENTO PER CONDUTTURE E OFFSHORE
HIGH YIELD STEEL FOR PIPELINE AND OFFSHORE**
 - ASTM A860/MSS-SP75: WPHY 42, WPHY 46, WPHY 52, WPHY 56, WPHY 60, WPHY 65, WPHY 70, WPHY 80 grades
 - EN 10208-2: L245NB, L290NB, L360NB, L415NB, L360QB, L415QB, L450QB, L485QB, L555QB
- ACCIAIO AL CARBONIO E LEGATO PER IMPIEGO A BASSE TEMPERATURE
CARBON AND ALLOY STEEL
FOR LOW TEMPERATURE SERVICE**
 - ASTM/ASME A/SA 420: WPL6, WPL3
- ACCIAIO INOX
STAINLESS STEEL**
 - ASTM/ASME A/SA 403: WP304, WP304L, WP304H, WP304LN, WP304N, WP316, WP316L, WP316H, WP316LN, WP316N, WP317, WP317L, WP321, WP321H, WP347, WP347H, WPS31254
 - Equivalent grades of EN 10253-3, EN 10253-4 (former AFNOR-DIN-BS equivalent grades)
- ACCIAIO INOX FERRITICO / AUSTENITICO
FERRITIC / AUSTENITIC
STAINLESS STEEL**
 - ASTM/ASME A/SA 815: UNS 31803 (duplex), UNS 32750 (superduplex), UNS 32760 (superduplex), UNS 32550 (superduplex) and equivalent
- LEGA DI NICHEL
NICKEL ALLOY**
 - ASTM/ASME B/SB 366: UNS N04400, UNS N06600, UNS N06625, UNS N08020, UNS N08800, UNS N08811, UNS N08825, UNS N10276
- LEGA DI RAME
COPPER ALLOY**
 - Copper-Nickel ASTM/ASME B/SB 466: UNS C 70600 (CuNi 90/10), UNS C71500 (CuNi 70/30)
- LEGA DI TITANIO
TITANIUM ALLOY**
 - ASTM/ASME B/SB363: WPT2, WPT12
- LEGA DI ALLUMINIO
ALUMINIUM ALLOY**
 - ASTM B361: 3003 and 6061 grades
- STANDARD DI PRODUZIONE
MANUFACTURING STANDARDS**
 - ASME B16.9 - ASME B16.28 - ASME - B16.25 MSS-SP75 - MSS-SP43
 - DIN 2605 - 2606 - 2615 - 2616 - 2617 - BS 1640 GOST 17374 - 17375 - 17376 - 17377 - 17378 17379 - 17380
- CODICI DI PROGETTAZIONE
DESIGN CODES**
 - ASME B31.1 - ASME B31.3 - ASME B31.4 - ASME B31.8
 - EN 13445 - 13480 - 12952 (former BS PD 5500-Swedish Ordinance AFS 1994:39)
 - DIN 2413 - TRD 301
 - AD 2000 Merkblatt B2-B3-B9
 - STOOMWEZEN Rules for Pressure Vessels

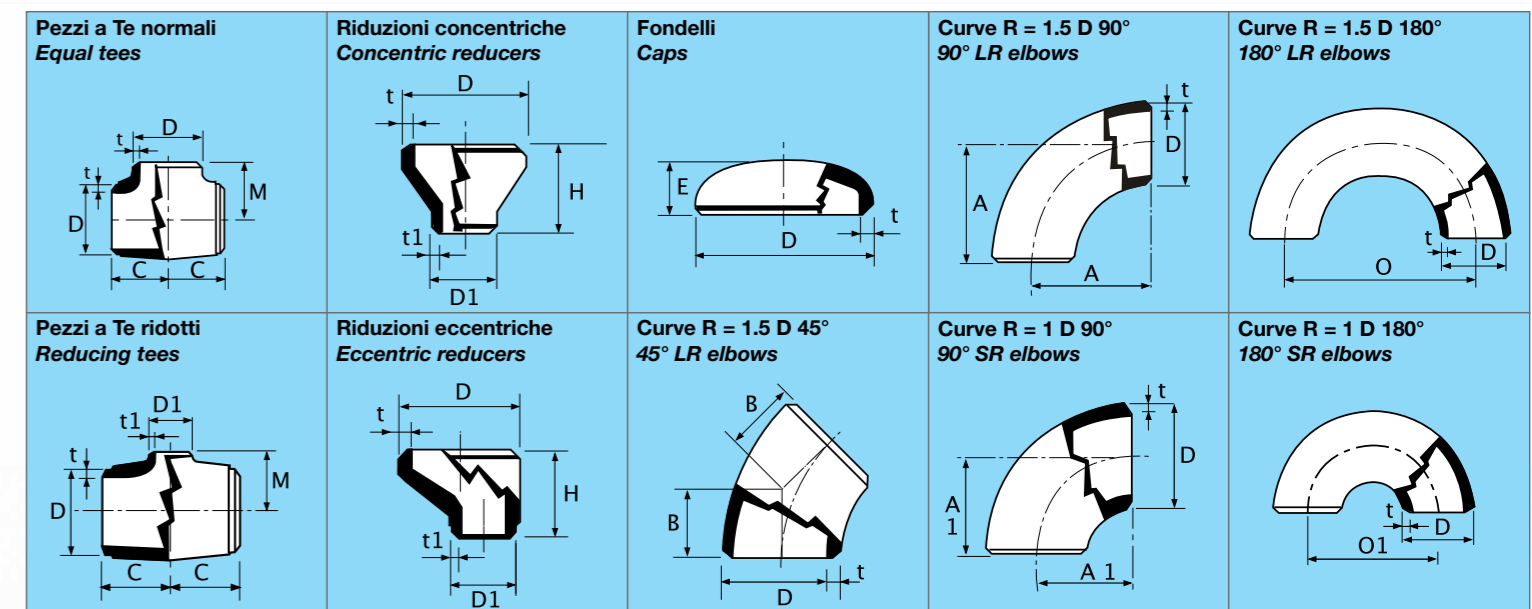
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Dimensioni secondo ASME B 16.9M / Dimensions according to ASME B 16.9M

Diametro nominale Nominal pipe size	Diametro esterno Outside diameter D	Diametro esterno Outside diameter D1	Dimensione Center to end C	Dimensione Center to end M	Lunghezza Lenght H	Diametro nominale Nominal pipe size	Diametro esterno Outside diameter D	Diametro esterno Outside diameter D1	Dimensione Center to end C	Dimensione Center to end M	Lunghezza Lenght H	Diametro nominale Nominal pipe size	Diametro esterno Outside diameter D	Diametro esterno Outside diameter D1	Dimensione Center to end C	Dimensione Center to end M	Lunghezza Lenght H
3/4 x 3/8	27	17	29	29	38	20 x 8	508	219	381	324	508	32 x 20	813	508	597	533	610
3/4 x 1/2	27	21	29	29	38	20 x 10	508	273	381	333	508	32 x 22	813	559	597	546	610
1 x 1/2	33	21	38	38	51	20 x 12	508	324	381	346	508	32 x 24	813	610	597	559	610
1 x 3/4	33	27	38	38	51	20 x 14	508	356	381	356	508	32 x 26	813	660	597	572	610
1 1/4 x 1/2	42	21	48	48	51	20 x 16	508	406	381	356	508	32 x 28	813	711	597	572	610
1 1/4 x 3/4	42	27	48	48	51	20 x 18	508	457	381	368	508	32 x 30	813	762	597	584	610
1 1/4 x 1	42	33	48	48	51	22 x 10	559	273	419	359	508	34 x 20	864	508	635	559	610
1 1/2 x 1/2	48	21	57	57	63	22 x 12	559	324	419	371	508	34 x 22	864	559	635	572	610
1 1/2 x 3/4	48	27	57	57	63	22 x 14	559	356	419	381	508	34 x 24	864	610	635	584	610
1 1/2 x 1	48	33	57	57	63	22 x 16	559	406	419	381	508	34 x 26	864	660	635	597	610
1 1/2 x 1 1/4	48	42	57	57	63	22 x 18	559	457	419	394	508	34 x 28	864	711	635	597	610
2 x 3/4	60	27	64	64	76	22 x 20	559	508	419	406	508	34 x 30	864	762	635	610	610
2 x 1	60	33	64	64	76	24 x 10	610	273	432	384	508	34 x 32	864	813	635	622	610
2 x 1/2	60	42	64	64	76	24 x 12	610	324	432	397	508	36 x 20	914	508	673	584	610
2 x 3/8	60	48	64	64	76	24 x 14	610	356	432	406	508	36 x 22	914	559	673	597	610
2 1/2 x 1	73	33	76	76	89	24 x 16	610	406	432	406	508	36 x 24	914	610	673	610	610
2 1/2 x 1 1/4	73	42	76	76	89	24 x 18	610	457	432	419	508	36 x 26	914	660	673	622	610
2 1/2 x 1 1/2	73	48	76	76	89	24 x 20	610	508	432	432	508	36 x 28	914	711	673	622	610
2 1/2 x 2	73	60	76	76	89	24 x 22	610	559	432	432	508	36 x 30	914	762	673	635	610
3 x 1/4	89	42	86	70	89	26 x 18	660	457	495	444	610	36 x 32	914	813	673	648	610
3 x 1/2	89	48	86	73	89	26 x 20	660	508	495	457	610	38 x 24	965	610	711	635	610
3 x 2	89	60	86	76	89	26 x 22	660	559	495	470	610	38 x 26	965	660	711	648	610
3 x 2 1/2	89	73	86	83	89	26 x 24	660	610	495	483	610	38 x 28	965	711	711	648	610
3 1/2 x 1 1/2	102	48	95	79	102	28 x 18	771	457	521	470	610	38 x 30	965	762	711	673	610
3 1/2 x 2	102	60	95	83	102	28 x 20	771	508	521	483	610	38 x 32	965	813	711	686	610
3 1/2 x 2 1/2	102	73	95	89	101	28 x 22	771	559	521	495	610	38 x 34	965	864	711	698	610
3 1/2 x 3	102	89	95	92	101	28 x 24	771	610	521	508	610	38 x 36	965	914	711	711	610
4 x 1 1/2	114	48	105	86	102	28 x 26	771	660	521	521	610	40 x 24	1016	610	749	660	610
4 x 2	114	60	105	89	102	30 x 18	762	457	559	495	610	40 x 26	1016	660	749	673	610
4 x 2 1/2	114	73	105	95	102	30 x 20	762	508	559	508	610	40 x 28	1016	711	749	673	610
4 x 3	114	89	105	98	102	30 x 22	762	559	559	521	610	40 x 30	1016	762	749	698	610
4 x 3 1/2	114	102	105	102	102	30 x 24	762	610	559	533	610	40 x 32	1016	813	749	711	610
						30 x 26	762	660	559	546	610	40 x 34	1016	864	749	724	610
						30 x 28	762	711	559	546	610	40 x 36	1016	914	749	737	610
												40 x 38	1016	965	749	749	610



Tolleranze / Tolerances ASME B 16.9M

Diametro nominale Nominal pipe size	Dn	Diametro esterno Outside diameter	Diametro interno Inside diameter	Spessore Wall thickness	Lunghezza totale Overall length 2C	Lunghezza derivazione Branch length M	Lunghezza riduzioni Reducers length H	Lunghezza fondelli Caps length E
1 1/2" ÷ 2 1/2"	15 - 65	+1.6 / - 0.8	+ / - 0.8	NON SUPERIORE AL 12.5% DEL NOMINALE NOT MORE THAN 12.5% OF NOMINAL THICKNESS	+ / - 4	+ / - 2	+ / - 2	+ / - 3
3" ÷ 3 1/2"	80 - 90	+ / - 1.6	+ / - 1.6					
4"	100	+ / - 1.6	+ / - 1.6					
5" ÷ 8"	125 - 200	+2.4 / - 1.6	+ / - 1.6					
10" ÷ 18"	250 - 450	+4.0 / - 3.2	+ / - 3.2					
20" ÷ 24"	500 - 600	+6.4 / - 4.8	+ / - 4.8					
26" ÷ 30"	650 - 750	+6.4 / - 4.8	+ / - 4.8	+ / - 6	+ / - 6	+ / - 5	+ / - 6	
32" ÷ 48"	800 - 1200	+6.4 / - 4.8	+ / - 4.8	+ / - 10	+ / - 5	+ / - 5	+ / - 10	

Esecuzione smussi
Welding bevel for fittings

Tolleranze espresse in millimetri / All tolerances are in millimeters

Tolleranze di angolarità / Angularity tolerances

Diametro nominale Nominal pipe size	Scostamento Off angle Q	Planarità Off plane P
1 1/2" ÷ 4"	± 1	± 2
5" ÷ 8"	± 2	± 4
10" ÷ 12"	± 3	± 5
14" ÷ 16"	± 3	± 6
18" ÷ 24"	± 4	± 10
16" ÷ 30"	± 5	± 10
32" ÷ 42"	± 5	± 13
44" ÷ 48"	± 5	± 19

