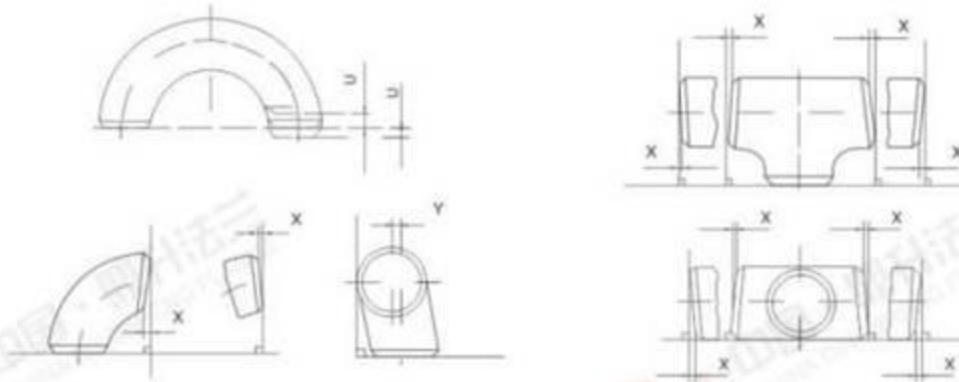


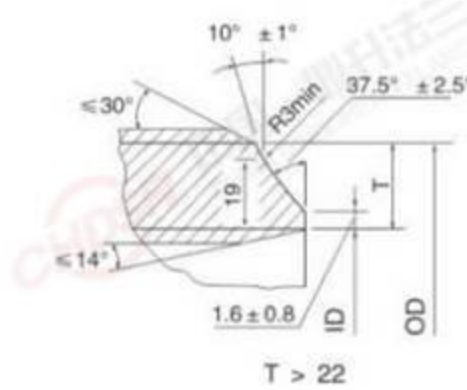
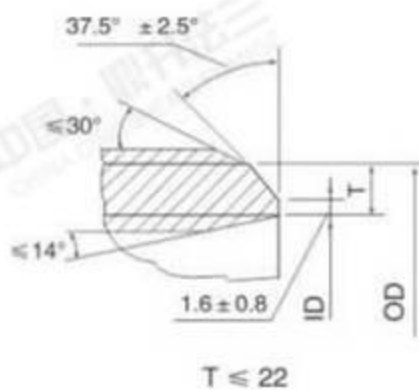
Tolerances For Butt-Welding Fittings

Nominal Pipe Size		All Fittings			90° 45° Elbows, Tees	Reducer Lap-Joint Stub Ends	Caps		180° Returns	
		Outside Diameter at Bevel	Inside Diameter at Bevel	Thickness	Center-to-End Dimension	Overall Length	Overall Length	Center-to-Center Dimension	Back-to-Face Dimension	Alignment of Ends
DN	NPS	OD,D1,D2	ID	T	A,B,C,M	H,F	E,E1	O	K	U
15-65	1/2-2.1/2	+ 1.6,-0.8	0.8	Not less than 87.50% of nominal thickness	2	2	3	6	6	1
80-90	3-3.1/2	1.6	1.6		2	2	3	6	6	1
100	4	1.6	1.6		2	2	3	6	6	1
125-200	5-8	+2.4-1.6	1.6		200.00%	2	6	6	6	1
250-450	10-18	+4.0-3.2	3.2		2	2	6	10	6	2
500-600	20-24	1.6	4.8		2	2	6	10	6	2
650-750	26-30	59.2	4.8		300.00%	5	10			
800-1200	32-48	1.6	4.8		5	5	10			
1300-1500	52-60	3.1	6.4		9.5	-	-			
1600-1700	64-68	2.5	9.5		12	-	-			
1800-2000	72-80	+ 16,-12	12.0		16	-	-			

Angularity Tolerance of Butt-welding Fittings



Nominal Size		DN	15-100	125-200	250-300	350-400	450-600	650-750	800-1050	1100-1200	1300-1500
		NPS	1/2-4	5-8	10-12	14-16	18-24	26-30	32-42	44-48	52-60
Angularity tolerance	Off Angle	Q	1	2	3	3	4	5	5	5	6.4
	Off Plain	P	2	4	5	6	10	10	13	19	20



Limiting tolerances can be slightly difference between the different standards and codes.