

# FORGED STEEL FITTINGS

## Forged Steel Fittings

### Class 6000 Socket Weld

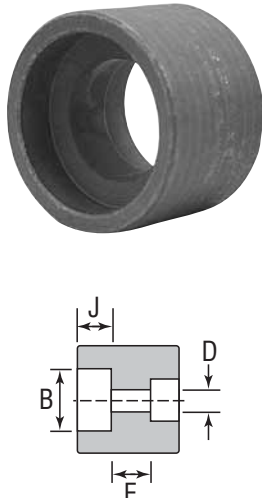
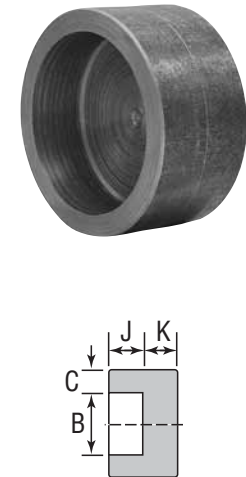
FIGURE 2176 Reducing Couplings	Size				B		D		E		J		Unit Weight	
			Lowest Reduction		Socket Dia.		Bore Dia.				Socket Depth Minimum			
	NPS	DN	NPS	DN	in	mm	in	mm	in	mm	in	mm	lbs	kg
	½	15	¼	8	.875 .855	22.2 21.8	.494 .434	12.5 11.0	0.38	9.5	0.38	9.5	-	-
	¾	20	⅜	10	1.085 1.065	27.6 27.2	.642 .582	16.3 14.8	0.38	9.5	0.50	12.5	0.81	0.37
	1	25	⅜	10	1.350 1.330	34.3 33.9	.845 .785	21.5 19.9	0.50	12.5	0.50	12.5	1.80	0.82
	1¼	32	½	15	1.695 1.675	43.1 42.7	1.190 1.130	30.2 28.7	0.50	12.5	0.50	12.5	2.00	0.91
	1½	40	½	15	1.935 1.915	49.2 48.8	1.368 1.308	34.7 33.2	0.50	12.5	0.50	12.5	3.20	1.45
	2	50	¾	20	2.426 2.406	61.7 61.2	1.717 1.657	43.6 42.1	0.75	19.0	0.62	16.0	5.40	2.45
	2½	65	1¼	32	2.931 2.906	74.4 73.9	2.185 2.065	55.5 52.5	0.75	19.0	0.62	16.0	-	-
	3	80	1½	40	3.560 3.535	90.3 89.8	2.684 2.564	68.2 65.1	0.75	19.0	0.62	16.0	-	-
	4	100	2	50	4.570 4.545	115.7 115.2	3.498 3.378	88.8 85.8	0.75	19.0	0.75	19.0	-	-

FIGURE 2177 Pipe Caps	Size		B		C		J		K		Unit Weight	
			Socket Dia.		Minimum		Socket Depth Minimum		Minimum			
	NPS	DN	in	mm	in	mm	in	mm	in	mm	lbs	kg
	½	15	.875 .855	22.2 21.8	0.204	5.18	0.38	9.5	0.31	7.9	0.42	0.19
	¾	20	1.085 1.065	27.6 27.2	0.238	6.04	0.50	12.5	0.31	7.9	0.58	0.26
	1	25	1.350 1.330	34.3 33.9	0.273	6.93	0.50	12.5	0.44	11.2	1.21	0.55
	1¼	32	1.695 1.675	43.1 42.7	0.273	6.93	0.50	12.5	0.44	11.2	1.00	0.45
	1½	40	1.935 1.915	49.2 48.8	0.307	7.80	0.50	12.5	0.50	12.7	2.12	0.96
	2	50	2.426 2.406	61.7 61.2	0.374	9.50	0.62	16.0	0.62	15.7	4.87	2.21
	2½	65	2.931 2.906	74.4 73.9	0.41	10.41	0.62	16.0	0.75	19.0	-	-
	3	80	3.560 3.535	90.3 89.8	0.48	12.19	0.62	16.0	0.88	22.4	-	-
	4	100	4.570 4.545	115.7 115.2	0.58	14.73	0.75	19.0	1.12	28.4	-	-

**Note:** When the pipe is seated against the bottom of the socket prior to welding, to prevent possible cracking of the fillet welds, it is recommended that the pipe be withdrawn approximately ¼ in (1.6mm) away from contact with the bottom of the socket before starting the weld.

Average of socket wall thickness around periphery shall be no less than listed values. The minimum values are permitted in localized areas.