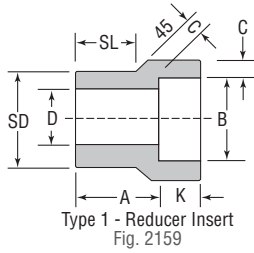
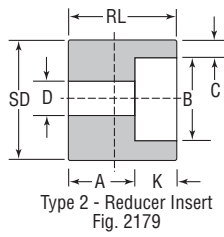


FORGED STEEL FITTINGS

Forged Steel Fittings Socket-Weld Reducer Inserts



Type 1 - Reducer Insert
Fig. 2159



Type 2 - Reducer Insert
Fig. 2179

CLASS 3000

For use with Schedule 40 and 80 Pipe

Reducer inserts comply with MSS standard SP-79. They enable standard socket-weld fittings to be used for making any combination of pipe line reductions quickly and economically. Socket-weld reducer inserts serve SD D the same purpose as threaded reducing bushings with threaded fittings.

Size				Class 3000 – For use with Schedule 40 and 80 Pipe														
SD		B		Type	A		D		C Min.		K		SL		RL Min.	Unit Weight		
NPS	DN	NPS	DN		in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	lbs	kg
1/2	15	1/4	8	1	0.81	20.57	0.364	9.25	0.149	3.78	0.438	11.11	0.62	15.75	–	–	0.18	0.08
		3/8	10	1	0.81	20.57	0.493	12.52	0.158	4.00	0.438	11.11	0.62	15.75	–	–		
3/4	20	1/4	8	2	0.69	17.53	0.364	9.25	0.149	3.78	0.375	9.53	–	–	1.06	27	0.25	0.11
		3/8	10	2	0.62	15.75	0.493	12.52	0.158	4.00	0.438	11.11	–	–	1.06	27		
		1/2	15	1	0.88	22.35	0.622	15.80	0.184	4.67	0.438	11.11	0.69	17.53	–	–		
1	25	1/4	8	2	0.75	19.05	0.364	9.25	0.149	3.78	0.375	9.53	–	–	1.12	28	0.35	0.16
		3/8	10	2	0.69	17.53	0.493	12.52	0.158	4.00	0.438	11.11	–	–	1.12	28		
		1/2	15	2	0.62	15.75	0.622	15.80	0.184	4.67	0.438	11.13	–	–	1.12	28		
		3/4	20	1	0.94	23.88	0.824	20.93	0.193	4.90	0.563	14.29	0.75	19.05	–	–		
1 1/4	32	1/4	8	2	0.88	22.35	0.364	9.25	0.149	3.78	0.375	9.53	–	–	1.25	32	0.35	0.25
		3/8	10	2	0.81	20.57	0.493	12.52	0.158	4.00	0.438	11.11	–	–	1.25	32		
		1/2	15	2	0.75	19.05	0.622	15.80	0.184	4.67	0.438	11.13	–	–	1.25	32		
		3/4	20	2	0.69	17.53	0.824	20.93	0.193	4.90	0.563	14.29	–	–	1.25	32		
		1	25	1	1.00	25.40	1.049	26.65	0.224	5.69	0.563	14.29	0.81	20.57	–	–		
1 1/2	40	3/8	10	2	0.88	22.35	0.493	12.52	0.158	4.00	0.438	11.11	–	–	1.31	33	0.62	0.28
		1/2	15	2	0.81	20.57	0.622	15.80	0.184	4.67	0.438	11.13	–	–	1.31	33		
		3/4	20	2	0.75	19.05	0.824	20.93	0.193	4.90	0.563	14.29	–	–	1.31	33		
		1	25	2	0.69	17.53	1.049	26.65	0.224	5.69	0.500	12.70	–	–	1.31	33		
		1 1/4	32	1	1.12	28.45	1.380	35.05	0.239	6.00	0.563	14.29	0.88	22.35	–	–		
2	50	1/2	15	2	1.00	25.40	0.622	15.80	0.184	4.67	0.438	11.13	–	–	1.50	38	1.50	0.68
		3/4	20	2	0.94	23.88	0.824	20.93	0.193	4.90	0.563	14.29	–	–	1.50	38		
		1	25	2	0.88	22.35	1.049	26.65	0.224	5.69	0.563	14.30	–	–	1.50	38		
		1 1/4	32	2	0.81	20.57	1.380	35.05	0.239	6.00	0.563	14.30	–	–	1.50	38		
		1 1/2	40	1	1.25	31.75	1.610	40.64	0.250	6.35	0.563	14.29	1.00	25.40	–	–		
2 1/2	65	3/4	20	–	1.56	39.62	0.824	20.93	0.193	4.90	0.562	14.27	–	–	2.12	54	3.00	1.36
		1	25	–	1.50	38.10	1.049	26.65	0.224	5.69	0.562	14.27	–	–	2.12	54		
		1 1/4	32	–	1.44	36.58	1.380	35.05	0.239	6.00	0.562	14.27	–	–	2.12	54		
		1 1/2	40	–	1.38	35.05	1.610	40.64	0.250	6.35	0.562	14.27	–	–	2.12	54		
		2	50	–	1.81	46.00	2.067	52.50	0.273	6.93	0.688	17.48	1.50	38.10	–	–		
3	80	1	25	–	1.25	31.75	1.049	26.65	0.224	5.69	0.562	14.27	–	–	1.87	47	4.40	2.00
		1 1/4	32	–	1.19	30.23	1.380	35.05	0.239	6.00	0.562	14.27	–	–	1.87	47		
		1 1/2	40	–	1.12	28.45	1.610	40.64	0.250	6.35	0.562	14.27	–	–	1.87	47		
		2	50	–	1.00	25.40	2.067	52.50	0.273	6.93	0.688	17.48	–	–	1.87	47		
		2 1/2	65	–	1.50	38.10	2.469	62.71	0.345	8.76	0.688	17.48	1.25	31.75	–	–		

The larger size NPS is the insert size.

To minimize the possibility of cracking of the fillet welds, it is recommended that the shank portion of the reducer be withdrawn approximately .0625 in. (1.6 mm) away from the contact with the bottom of the socket before starting the weld. Likewise, the pipe is to be kept away from contacting the bottom of the reducer socket before welding.