
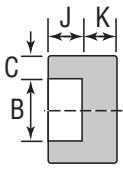


Forged Steel Fittings

Class 3000 Socket Weld

FIGURE 2157 Pipe Caps	Size		B Socket Dia.		C Minimum		J Socket Depth Minimum		K		Unit Weight	
	NPS	DN	in	mm	in	mm	in	mm	in	mm	lbs	kg
		1/8	6	.440 .420	11.2 10.8	0.125	3.18	0.38	9.5	0.19	4.8	0.07
	1/4	8	.575 .555	14.6 14.2	0.130	3.30	0.38	9.5	0.19	4.8	0.09	0.04
	3/8	10	.710 .690	18.0 17.6	0.138	3.50	0.38	9.5	0.19	4.8	0.17	0.08
	1/2	15	.875 .855	22.2 21.8	0.161	4.09	0.38	9.5	0.25	6.4	0.30	0.14
	3/4	20	1.085 1.065	27.6 27.2	0.168	4.27	0.50	12.5	0.25	6.4	0.37	0.17
	1	25	1.350 1.330	34.3 33.9	0.196	4.98	0.50	12.5	0.38	9.6	0.60	0.27
	1 1/4	32	1.695 1.675	43.1 42.7	0.208	5.28	0.50	12.5	0.38	9.6	0.96	0.44
	1 1/2	40	1.935 1.915	49.2 48.8	0.218	5.54	0.50	12.5	0.44	11.2	1.20	0.54
	2	50	2.426 2.406	61.7 61.2	0.238	6.04	0.62	16.0	0.50	12.7	2.00	0.91
	2 1/2	65	2.931 2.906	74.4 73.9	0.302	7.67	0.62	16.0	0.62	15.7	2.75	1.25
	3	80	3.560 3.535	90.3 89.8	0.327	8.30	0.62	16.0	0.75	19.0	5.00	2.27
	4	100	4.570 4.545	115.7 115.2	0.368	9.35	0.75	19.0	0.88	22.4	8.25	3.74

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of the socket prior to welding, to prevent possible cracking of the fillet welds, it is recommended that the pipe be withdrawn approximately 1/16 in (1.6mm) away from contact with the bottom of the socket before starting the weld.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.