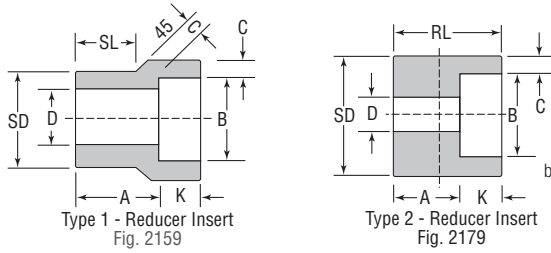


Forged Steel Fittings

Socket-Weld Reducer Inserts



CLASS 6000

For use with Schedule 160 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 6000 – For use with Schedule 160 Pipe										Unit Weight				
SD		B		Type	A		D		C Min.		K		SL		RL Min.		lbs	kg
NPS	DN	NPS	DN		in	mm	in	mm	in	mm	in	mm	in	mm	in	mm		
¾	20	¼	8	2	0.88	22.35	0.250	6.35	0.181	4.60	0.375	9.53	–	–	1.26	32	0.81	0.37
		⅜	10	1	0.88	22.35	0.359	9.12	0.198	5.00	0.438	11.11	0.75	19.05	–	–		
		½	15	1	1.00	25.40	0.464	11.79	0.235	6.00	0.438	11.11	0.75	19.05	–	–		
1	25	¼	8	2	0.94	23.88	0.250	6.35	0.181	4.60	0.375	9.53	–	–	1.31	33	1.80	0.82
		⅜	10	2	0.88	22.35	0.359	9.12	0.198	5.00	0.438	11.13	–	–	1.31	33		
		½	15	1	1.12	28.45	0.464	11.79	0.235	6.00	0.438	11.11	0.81	20.57	–	–		
		¾	20	1	1.12	28.45	0.612	15.49	0.274	6.96	0.563	14.29	0.81	20.57	–	–		
1¼	32	¼	8	2	1.00	25.40	0.250	6.35	0.181	4.60	0.375	9.53	–	–	1.37	35	2.00	0.91
		⅜	10	2	0.94	23.88	0.359	9.12	0.198	5.00	0.438	11.11	–	–	1.37	35		
		½	15	2	0.88	22.35	0.464	11.79	0.235	6.00	0.438	11.13	–	–	1.37	35		
		¾	20	2	0.81	20.57	0.612	15.49	0.274	6.96	0.563	14.29	–	–	1.37	35		
		1	25	1	1.19	30.23	0.815	20.70	0.312	7.92	0.563	14.29	0.88	22.35	–	–		
1½	40	⅜	10	2	1.12	28.45	0.359	9.12	0.198	5.00	0.438	11.11	–	–	1.56	40	3.20	1.45
		½	15	2	1.06	26.92	0.464	11.79	0.235	6.00	0.438	11.13	–	–	1.56	40		
		¾	20	2	1.00	25.40	0.612	15.49	0.274	6.96	0.563	14.29	–	–	1.56	40		
		1	25	1	1.15	29.21	0.815	20.70	0.312	7.92	0.563	14.29	1.00	25.40	–	–		
		1¼	32	1	1.38	35.05	1.160	29.46	0.312	7.92	0.563	14.29	1.00	25.40	–	–		
2	50	½	15	2	1.12	28.45	0.464	11.79	0.235	6.00	0.438	11.13	–	–	1.62	41	5.40	2.45
		¾	20	2	1.06	26.92	0.612	15.49	0.274	6.96	0.562	14.3	–	–	1.62	41		
		1	25	2	1.00	25.40	0.815	20.70	0.312	7.92	0.562	14.3	–	–	1.62	41		
		1¼	32	2	0.94	23.88	1.160	29.46	0.312	7.92	0.562	14.3	–	–	1.62	41		

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To minimize the possibility of cracking of the fillet welds, it is recommended that the shank portion of the reducer be withdrawn approximately .0625 in.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.