

Forged Steel Fittings

Class 6000 Socket Weld

FIGURE 2172 Tees		Size		A		B Socket Dia.		C Minimum		D Bore Dia.		J Socket Depth Minimum		Unit Weight	
NPS	DN	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	lbs	kg
	½	15	0.75	19.0	.875 .855	22.2 21.8	0.204	5.18	.494 .434	12.5 11.0	0.38	9.5	1.16	0.53	
	¾	20	0.88	22.5	1.085 1.065	27.6 27.2	0.238	6.04	.642 .582	16.3 14.8	0.50	12.5	2.00	0.91	
	1	25	1.06	27.0	1.350 1.330	34.3 33.9	0.273	6.93	.845 .785	21.5 19.9	0.50	12.5	3.16	1.43	
	1¼	32	1.25	32.0	1.695 1.675	43.1 42.7	0.273	6.93	1.190 1.130	30.2 28.7	0.50	12.5	3.62	1.64	
	1½	40	1.50	38.0	1.935 1.915	49.2 48.8	0.307	7.80	1.368 1.308	34.7 33.2	0.50	12.5	7.10	3.22	
	2	50	1.62	41.0	2.426 2.406	61.7 61.2	0.374	9.50	1.717 1.657	43.6 42.1	0.62	16.0	8.90	4.04	
	2½	65	2.25	57.1	2.931 2.906	74.4 73.9	0.41	10.41	2.185 2.065	55.5 52.5	0.62	16.0	16.63	7.54	
	3	80	2.50	63.5	3.560 3.535	90.3 89.8	0.48	12.19	2.684 2.564	68.2 65.1	0.62	16.0	23.80	10.79	
	4	100	2.62	66.5	4.570 4.545	115.7 115.2	0.58	14.73	3.498 3.378	88.8 85.8	0.75	19.0	45.32	20.55	

FIGURE 2173 Crosses		Size		A		B Socket Dia.		C Minimum		D Bore Dia.		J Socket Depth Minimum		Unit Weight	
NPS	DN	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	lbs	kg
	½	15	0.75	19.0	.875 .855	22.2 21.8	0.204	5.18	.494 .434	12.5 11.0	0.38	9.5	1.40	0.63	
	¾	20	0.88	22.5	1.085 1.065	27.6 27.2	0.238	6.04	.642 .582	16.3 14.8	0.50	12.5	2.30	1.04	
	1	25	1.06	27.0	1.350 1.330	34.3 33.9	0.273	6.93	.845 .785	21.5 19.9	0.50	12.5	3.80	1.72	
	1¼	32	1.25	32.0	1.695 1.675	43.1 42.7	0.273	6.93	1.190 1.130	30.2 28.7	0.50	12.5	4.70	2.13	
	1½	40	1.50	38.0	1.935 1.915	49.2 48.8	0.307	7.80	1.368 1.308	34.7 33.2	0.50	12.5	8.70	3.95	
	2	50	1.62	41.0	2.426 2.406	61.7 61.2	0.374	9.50	1.717 1.657	43.6 42.1	0.62	16.0	9.30	4.22	

FIGURE 2178 Laterals		Size		B		C		D		K		L		Unit Weight	
NPS	DN	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	lbs	kg
	½	15	1.56	39.62	0.855	21.72	0.375	8.89	2.56	65.10	3.56	90.50	2.00	0.91	
	¾	20	1.84	46.74	1.065	27.05	0.500	12.70	3.00	76.20	4.13	104.78	3.06	1.39	
	1	25	2.22	56.39	1.330	33.78	0.500	12.70	3.50	88.90	4.81	122.17	5.13	2.33	
	1¼	32	2.50	63.50	1.675	41.91	0.500	12.70	3.94	100.08	5.38	135.89	6.25	2.84	
	1½	40	3.03	76.96	1.915	49.53	0.500	12.70	4.75	120.65	6.44	163.58	11.94	5.43	

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of the socket prior to welding, to prevent possible cracking of the fillet welds, it is recommended that the pipe be withdrawn approximately 1/16 in (1.6mm) away from contact with the bottom of the socket before starting the weld.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