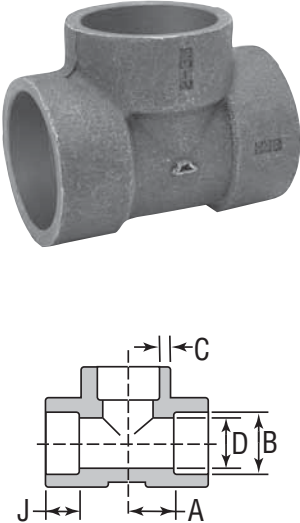
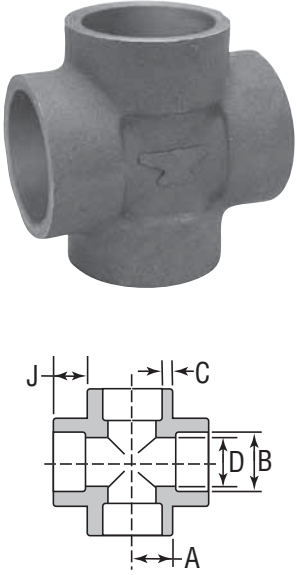


## Forged Steel Fittings

### Class 3000 Socket Weld

| <b>FIGURE 2152</b><br><b>Tees</b>                                                 | Size  |     | A<br>Nominal |      | B<br>Socket Dia. |                | C<br>Minimum |      | D<br>Bore Dia. |                | J<br>Socket Depth<br>Minimum |      | Unit Weight |       |
|-----------------------------------------------------------------------------------|-------|-----|--------------|------|------------------|----------------|--------------|------|----------------|----------------|------------------------------|------|-------------|-------|
|                                                                                   | NPS   | DN  | in           | mm   | in               | mm             | in           | mm   | in             | mm             | in                           | mm   | lbs         | kg    |
|                                                                                   |       |     |              |      |                  |                |              |      |                |                |                              |      |             |       |
|  | 1/8   | 6   | 0.44         | 11.0 | .440<br>.420     | 11.2<br>10.8   | 0.125        | 3.18 | .299<br>.239   | 7.6<br>6.1     | 0.38                         | 9.5  | 0.28        | 0.13  |
|                                                                                   | 1/4   | 8   | 0.44         | 11.0 | .575<br>.555     | 14.6<br>14.2   | 0.130        | 3.30 | .394<br>.334   | 10.0<br>8.5    | 0.38                         | 9.5  | 0.24        | 0.11  |
|                                                                                   | 3/8   | 10  | 0.53         | 13.5 | .710<br>.690     | 18.0<br>17.6   | 0.138        | 3.50 | .523<br>.463   | 13.3<br>11.8   | 0.38                         | 9.5  | 0.38        | 0.17  |
|                                                                                   | 1/2   | 15  | 0.62         | 15.5 | .875<br>.855     | 22.2<br>21.8   | 0.161        | 4.09 | .652<br>.592   | 16.6<br>15.0   | 0.38                         | 9.5  | 0.65        | 0.29  |
|                                                                                   | 3/4   | 20  | 0.75         | 19.0 | 1.085<br>1.065   | 27.6<br>27.2   | 0.168        | 4.27 | .854<br>.794   | 21.7<br>20.2   | 0.50                         | 12.5 | 0.86        | 0.39  |
|                                                                                   | 1     | 25  | 0.88         | 22.5 | 1.350<br>1.330   | 34.3<br>33.9   | 0.196        | 4.98 | 1.079<br>1.019 | 27.4<br>25.9   | 0.50                         | 12.5 | 1.37        | 0.62  |
|                                                                                   | 1 1/4 | 32  | 1.06         | 27.0 | 1.695<br>1.675   | 43.1<br>42.7   | 0.208        | 5.28 | 1.410<br>1.350 | 35.8<br>34.3   | 0.50                         | 12.5 | 2.00        | 0.91  |
|                                                                                   | 1 1/2 | 40  | 1.25         | 32.0 | 1.935<br>1.915   | 49.2<br>48.8   | 0.218        | 5.54 | 1.640<br>1.580 | 41.6<br>40.1   | 0.50                         | 12.5 | 2.80        | 1.27  |
|                                                                                   | 2     | 50  | 1.50         | 38.0 | 2.426<br>2.406   | 61.7<br>61.2   | 0.238        | 6.04 | 2.097<br>2.037 | 53.3<br>51.7   | 0.62                         | 16.0 | 3.85        | 1.75  |
|                                                                                   | 2 1/2 | 65  | 1.62         | 41.0 | 2.931<br>2.906   | 74.4<br>73.9   | 0.302        | 7.67 | 2.529<br>2.409 | 64.2<br>61.2   | 0.62                         | 16.0 | 8.20        | 3.72  |
|                                                                                   | 3     | 80  | 2.25         | 57.0 | 3.560<br>3.535   | 90.3<br>89.8   | 0.327        | 8.30 | 3.128<br>3.008 | 79.4<br>76.4   | 0.62                         | 16.0 | 12.00       | 5.44  |
|                                                                                   | 4     | 100 | 2.62         | 66.5 | 4.570<br>4.545   | 115.7<br>115.2 | 0.368        | 9.35 | 4.086<br>3.966 | 103.8<br>100.7 | 0.75                         | 19.0 | 29.00       | 13.15 |

| <b>FIGURE 2153</b><br><b>Crosses</b>                                                | Size  |     | A<br>Nominal |      | B<br>Socket Dia. |                | C<br>Minimum |      | D<br>Bore Dia. |                | J<br>Socket Depth<br>Minimum |      | Unit Weight |      |
|-------------------------------------------------------------------------------------|-------|-----|--------------|------|------------------|----------------|--------------|------|----------------|----------------|------------------------------|------|-------------|------|
|                                                                                     | NPS   | DN  | in           | mm   | in               | mm             | in           | mm   | in             | mm             | in                           | mm   | lbs         | kg   |
|                                                                                     |       |     |              |      |                  |                |              |      |                |                |                              |      |             |      |
|  | 1/8   | 6   | 0.44         | 11.0 | .440<br>.420     | 11.2<br>10.8   | 0.125        | 3.18 | .299<br>.239   | 7.6<br>6.1     | 0.38                         | 9.5  | 0.45        | 0.20 |
|                                                                                     | 1/4   | 8   | 0.44         | 11.0 | .575<br>.555     | 14.6<br>14.2   | 0.130        | 3.30 | .394<br>.334   | 10.0<br>8.5    | 0.38                         | 9.5  | 0.38        | 0.17 |
|                                                                                     | 3/8   | 10  | 0.53         | 13.5 | .710<br>.690     | 18.0<br>17.6   | 0.138        | 3.50 | .523<br>.463   | 13.3<br>11.8   | 0.38                         | 9.5  | 0.32        | 0.15 |
|                                                                                     | 1/2   | 15  | 0.62         | 15.5 | .875<br>.855     | 22.2<br>21.8   | 0.161        | 4.09 | .652<br>.592   | 16.6<br>15.0   | 0.38                         | 9.5  | 0.81        | 0.37 |
|                                                                                     | 3/4   | 20  | 0.75         | 19.0 | 1.085<br>1.065   | 27.6<br>27.2   | 0.168        | 4.27 | .854<br>.794   | 21.7<br>20.2   | 0.50                         | 12.5 | 1.10        | 0.50 |
|                                                                                     | 1     | 25  | 0.88         | 22.5 | 1.350<br>1.330   | 34.3<br>33.9   | 0.196        | 4.98 | 1.079<br>1.019 | 27.4<br>25.9   | 0.50                         | 12.5 | 1.56        | 0.71 |
|                                                                                     | 1 1/4 | 32  | 1.06         | 27.0 | 1.695<br>1.675   | 43.1<br>42.7   | 0.208        | 5.28 | 1.410<br>1.350 | 35.8<br>34.3   | 0.50                         | 12.5 | 2.44        | 1.11 |
|                                                                                     | 1 1/2 | 40  | 1.25         | 32.0 | 1.935<br>1.915   | 49.2<br>48.8   | 0.218        | 5.54 | 1.640<br>1.580 | 41.6<br>40.1   | 0.50                         | 12.5 | 3.25        | 1.47 |
|                                                                                     | 2     | 50  | 1.50         | 38.0 | 2.426<br>2.406   | 61.7<br>61.2   | 0.238        | 6.04 | 2.097<br>2.037 | 53.3<br>51.7   | 0.62                         | 16.0 | 5.20        | 2.36 |
|                                                                                     | 2 1/2 | 65  | 1.62         | 41.0 | 2.931<br>2.906   | 74.4<br>73.9   | 0.302        | 7.67 | 2.529<br>2.409 | 64.2<br>61.2   | 0.62                         | 16.0 | 13.40       | 6.08 |
|                                                                                     | 3     | 80  | 2.25         | 57.0 | 3.560<br>3.535   | 90.3<br>89.8   | 0.327        | 8.30 | 3.128<br>3.008 | 79.4<br>76.4   | 0.62                         | 16.0 | 20.00       | 9.07 |
|                                                                                     | 4     | 100 | 2.62         | 66.5 | 4.570<br>4.545   | 115.7<br>115.2 | 0.368        | 9.35 | 4.086<br>3.966 | 103.8<br>100.7 | 0.75                         | 19.0 | —           | —    |

**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.