

High Pressure Plugs

 FIGURE 2122 Square Head Plugs	Size		A		B		C		Unit Weight	
	NPS	DN	in	mm	in	mm	in	mm	lbs	kg
	1/8	6	0.38	10	0.25	6	0.28	7	0.02	0.01
1/4	8	0.44	11	0.25	6	0.38	10	0.03	0.01	
3/8	10	0.50	13	0.31	8	0.44	11	0.06	0.03	
1/2	15	0.56	14	0.38	10	0.56	14	0.10	0.05	
3/4	20	0.62	16	0.44	11	0.62	16	0.18	0.08	
1	25	0.75	19	0.50	13	0.81	21	0.38	0.17	
1 1/4	32	0.81	21	0.56	14	0.94	24	0.62	0.28	
1 1/2	40	0.81	21	0.62	16	1.12	28	0.88	0.40	
2	50	0.88	22	0.69	18	1.31	32	1.40	0.63	
2 1/2	65	1.06	27	0.75	19	1.50	36	2.20	1.00	
3	80	1.12	28	0.81	21	1.69	41	3.40	1.54	
4	100	1.25	32	1.00	25	2.50	65	8.50	3.85	

 FIGURE 2142 Hex Head Plugs	Size		A		F Across Flats		H		Unit Weight	
	NPS	DN	in	mm	in	mm	in	mm	lbs	kg
	1/8	6	0.38	10	0.44	11	0.25	6	0.03	0.01
1/4	8	0.44	11	0.62	16	0.25	6	0.05	0.02	
3/8	10	0.50	13	0.69	18	0.31	8	0.09	0.04	
1/2	15	0.56	14	0.88	22	0.31	8	0.13	0.06	
3/4	20	0.62	16	1.06	27	0.38	10	0.27	0.12	
1	25	0.75	19	1.38	36	0.38	10	0.48	0.22	
1 1/4	32	0.81	21	1.75	46	0.56	14	0.94	0.43	
1 1/2	40	0.81	21	2.00	50	0.62	16	1.20	0.54	
2	50	0.88	22	2.50	65	0.69	18	2.40	1.09	
2 1/2	65	1.06	27	3.00	75	0.75	19	3.80	1.72	
3	80	1.12	28	3.50	90	0.81	21	4.80	2.18	
4	100	1.25	32	4.62	115	1.00	25	13.00	5.90	

 FIGURE 2121 Round Head Plugs	Size		A		D		E		Unit Weight	
	NPS	DN	in	mm	in	mm	in	mm	lbs	kg
	1/8	6	0.38	10	1.38	35	0.41	10	0.05	0.02
1/4	8	0.44	11	1.62	41	0.53	13	0.10	0.05	
3/8	10	0.50	13	1.62	41	0.69	18	0.16	0.07	
1/2	15	0.56	14	1.75	44	0.84	21	0.28	0.13	
3/4	20	0.62	16	1.75	44	1.06	27	0.42	0.19	
1	25	0.75	19	2.00	51	1.31	33	0.82	0.37	
1 1/4	32	0.81	21	2.00	51	1.69	43	1.20	0.54	
1 1/2	40	0.81	21	2.00	51	1.91	49	1.50	0.68	
2	50	0.88	22	2.50	64	2.38	60	3.20	1.45	
2 1/2	65	1.06	27	2.75	70	2.88	73	-	-	
3	80	1.12	28	2.75	70	3.50	89	-	-	
4	100	1.25	32	3.00	76	4.50	114	-	-	

Note: Plugs and bushings are not identified by Pressure Class. They may be used for ratings up to Pressure Class 6000 (per ASME B16.11)

PROJECT INFORMATION		APPROVAL STAMP	
Project:		<input type="checkbox"/> Approved	
Address:		<input type="checkbox"/> Approved as noted	
Contractor:		<input type="checkbox"/> Not approved	
Engineer:		Remarks:	
Submittal Date:			
Notes 1:			
Notes 2:			



Materials

The steel for Anvil Forged Carbon Steel Fittings consists of forging, bars, seamless pipe or tubes which conform to the requirements for melting process, chemical composition and mechanical properties of ASTM A105.

Design Basis

ASME B16.11 - Forged fittings, socket-weld and threaded

Dimensions

ASME B16.11, unless otherwise noted

Threads

ASME B1.20.1 NPT Threads

Forged Steel Fittings

In accordance with ASME standard B16.11 - "Forged Fittings, Socket-Welding and Threaded" this table shows the schedule of pipe corresponding to each class of fitting for rating purposes.

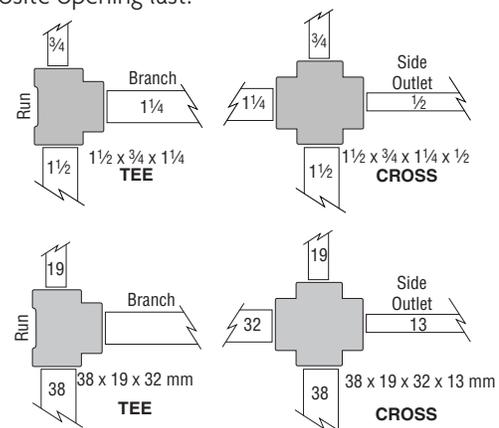
PRESSURE RATINGS		
Class	Schedule	
	N.P.T.	S.W.
2000	80	-
3000	160	80
6000	XXS/XXH	160

ASME B16.11 provides that the maximum allowable pressure of a fitting be computed in accordance with the applicable piping code or regulation for straight seamless pipe or for material of equivalent composition and mechanical properties to the fitting. Any corrosion or mechanical allowances and any reduction in allowable stress due to temperature or other service conditions must be applied to the pipe and fitting alike.

Reducing Fittings

Reducing elbows, tees and crosses are available in both threaded and socket-welding.

On reducing tees and crosses give the size of the largest run opening; then give the opposite opening. On a tee give the branch size last. On a cross give the largest side outlet third and the opposite opening last.



Standards and Specifications

	Dimensions	Material	Thread	Pressure Rating
FORGED STEEL THREADED FITTINGS				
Class 2000, 3000, 6000	ASME B16.11	ASTM A105, ASTM A182, ASTM A350	ASME B1.20.1	ASME B16.11

General Assembly of Threaded Fittings

- 1) Inspect both male and female components prior to assembly.
 - Threads should be free from mechanical damage, dirt, chips and excess cutting oil.
 - Clean or replace components as necessary.
- 2) Application of thread sealant
 - Use a thread sealant that is fast drying, sets-up to a semi hard condition and is vibration resistant. Alternately, an anaerobic sealant may be utilized.
 - Thoroughly mix the thread sealant prior to application.
 - Apply a thick even coat to the male threads only. Best application is achieved with a brush stiff enough to force sealant down to the root of the threads.
- 3) Joint Makeup
 - For sizes up to and including 2" pipe, wrench tight makeup is considered three full turns past handtight. Handtight engagement for 1/2" through 2" thread varies from 4 1/2 turns to 5 turns.
 - For 2 1/2" through 4" sizes, wrench tight makeup is considered two full turns past handtight. Handtight engagement for 2 1/2" through 4" thread varies from 5 1/2 turns to 6 3/4 turns.