

## 高压锻造管件

### High Pressure Forged Fittings

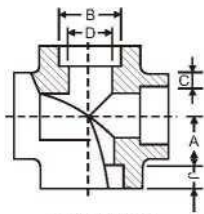


**产品名称**

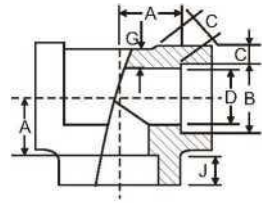
45°弯头、90°弯头、三通、四通、异径管、堵头、封头、活接头、管座、缩接、管箍。

**Products Description:**

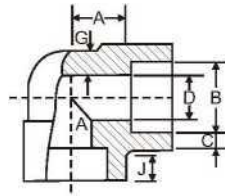
45°Elbow, 90° Elbow, Tee, Cross, Reducer, Cap, Union, Outlet, Swaged Nipple, Coupling.



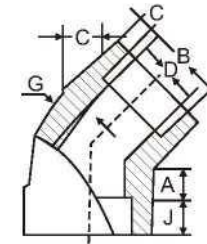
承插焊四通  
SW Cross



承插焊三通  
SW Tee



承插焊90° 弯头  
SW90° Elbow



承插焊45° 弯头  
SW45° Elbow

GB/T 14383 ASME B16.11

公称尺寸 Nominal size		承插孔径 Socket bore dia	流通孔径 Bore dia of fittings			承插孔壁厚 Socket wall thickness						本体壁厚 Body Wall			承插孔深度 Depth of socket	中心到承插孔座 Center to bottom of socket					
DN	NPS	B	D			C						G min			J min	A					
			3000	6000	9000	3000		6000		9000		3000	6000	9000		90° Elbow ,Tee,Cross			45° Elbow		
						Avg	Min	Avg	Min	Avg	Min					3000	6000	9000	3000	6000	9000
6	1/8	10.9	6.1	3.2	-	3.18	3.18	3.96	3.43	-	-	2.41	3.15	-	9.5	11.0	11.0	-	8.0	8.0	-
8	1/4	14.3	8.5	5.6	-	3.78	3.30	4.60	4.01	-	-	3.02	3.68	-	9.5	11.0	13.5	-	8.0	8.0	-
10	3/8	17.7	11.8	8.4	-	4.01	3.50	5.03	4.37	-	-	3.20	4.01	-	9.5	13.5	15.5	-	8.0	11.0	-
15	1/2	21.9	15.0	11.0	5.6	4.67	4.09	5.97	5.18	9.53	8.18	3.73	4.78	7.47	9.5	15.5	19.0	25.5	11.0	12.5	15.5
20	3/4	27.3	20.2	14.8	10.3	4.90	4.27	6.96	6.04	9.78	8.56	3.91	5.56	7.82	12.5	19.0	22.5	28.5	13.0	14.0	19.0
25	1	34.0	25.9	19.9	14.4	5.69	4.98	7.92	6.93	11.38	9.96	4.55	6.35	9.09	12.5	22.5	27.0	32.0	14.0	17.5	20.5
32	1 1/4	42.8	34.3	28.7	22.0	6.07	5.28	7.92	6.93	12.14	10.62	4.85	6.35	9.70	12.5	27.0	32.0	35.0	17.5	20.5	22.5
40	1 1/2	48.9	40.1	33.2	27.2	6.35	5.54	8.92	7.80	12.70	11.12	5.08	7.14	10.15	12.5	32.0	38.0	38.0	20.5	25.5	25.5
50	2	61.2	51.7	42.1	37.4	6.93	6.04	10.92	9.50	13.84	12.12	5.54	8.74	11.07	16.0	38.0	41.0	54.0	25.5	28.5	28.5
65	2 1/2	73.9	61.2	-	-	8.76	7.62	-	-	-	-	7.01	-	-	16.0	41.0	-	-	28.5	-	-
80	3	89.9	76.4	-	-	9.52	8.30	-	-	-	-	7.62	-	-	16.0	57.0	-	-	32.0	-	-
100	4	115.5	100.7	-	-	10.69	9.35	-	-	-	-	8.56	-	-	19.0	66.5	-	-	41.0	-	-

注释 Note:

1).沿承插孔周边的平均壁厚不应小于平均值，局部允许达到最小值

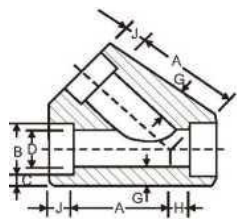
Average of socket wall thickness around periphery shall be no less than listed above.The minimum values are permitted in localized area.

2)考虑到管子外径公差的原因，有的承插孔径比 B16.11 规定略大。

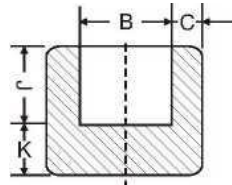
In view of the tolerance of the outside diameter of the pipes,there is possibility that the socket bore diameter is a little greater than what is specified in ASME B16.11

3)当选用的接管尺寸与样本的接管外径与壁厚表规定不一致时，请在采购文件中说明接管尺寸。

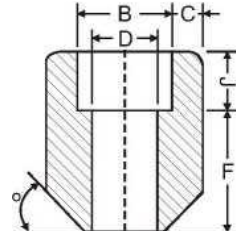
In case the sizes of the connecting pipes differ from the corresponding ones listed,the actual sizes of the matching pipes shall be specified in the purchasing documents.



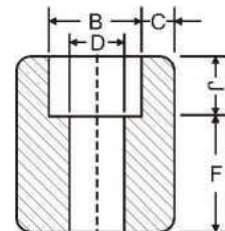
承插焊45°三通  
Lateral



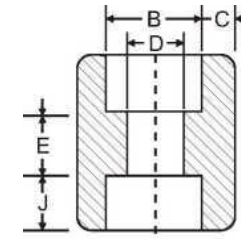
承插焊管帽  
SW Cap



管台  
BOSS



单承口管箍  
SW Half Coupling



双承口管箍  
SW Coupling

GB/T 14383 ASME B16.11

公称尺寸 Nominal size		承插孔径 Socket bore dia	流通孔径 Bore dia of fittings			承插孔径壁厚 Socket wall thickness						本体壁厚 Body Wall			承插孔深度 Min. Depth of socket	长度 Laying lengths	长度 Laying lengths	顶部厚度 End Wall thickness			中心到承插孔座 Center to bottom of socket			
DN	NPS	B	D			C						Gmin			J min	E	F	Kmin			A		H	
			3000	6000	9000	3000		6000		9000		3000	6000	9000				3000	6000	9000	3000	6000	3000	6000
			Avg	Min		Avg	Min	Avg	Min	Avg	Min													
6	1/8	10.9	6.1	3.2	-	3.18	3.18	3.96	3.43	-	-	2.41	3.15	-	9.5	6.5	16.0	4.8	6.4	-	-	-	-	-
8	1/4	14.3	8.5	5.6	-	3.78	3.30	4.60	4.01	-	-	3.02	3.68	-	9.5	6.5	16.0	4.8	6.4	-	-	-	-	-
10	3/8	17.7	11.8	8.4	-	4.01	3.50	5.03	4.37	-	-	3.20	4.01	-	9.5	6.5	17.5	4.8	6.4	-	37	-	9.5	-
15	1/2	21.9	15.0	11.0	5.6	4.67	4.09	5.97	5.18	9.53	8.18	3.73	4.78	7.47	9.5	9.5	22.5	6.4	7.9	11.2	41	51	9.5	11
20	3/4	27.3	20.2	14.8	10.3	4.90	4.27	6.96	6.04	9.78	8.56	3.91	5.56	7.82	12.5	9.5	24.0	6.4	7.9	12.7	51	60	11	13
25	1	34.0	25.9	19.9	14.4	5.69	4.98	7.92	6.93	11.38	9.96	4.55	6.35	9.09	12.5	12.5	28.5	9.6	11.2	14.2	60	71	13	16
32	1 1/4	42.8	34.3	28.7	22.0	6.07	5.28	7.92	6.93	12.14	10.62	4.85	6.35	9.70	12.5	12.5	30.0	9.6	11.2	14.2	71	81	16	17
40	1 1/2	48.9	40.1	33.2	27.2	6.35	5.54	8.92	7.80	12.70	11.12	5.08	7.14	10.15	12.5	12.5	32.0	11.2	12.7	15.7	81	98	17	21
50	2	61.2	51.7	42.1	37.4	6.93	6.04	10.92	9.50	13.85	12.12	5.54	8.74	11.07	16.0	19.0	41.0	12.7	15.7	19.0	98	151	21	30
65	2 1/2	73.9	61.2	-	-	8.76	7.62	-	-	-	-	7.01	-	-	16.0	19.0	43.0	15.7	19.0	-	151	-	30	-
80	3	89.9	76.4	-	-	9.52	8.30	-	-	-	-	7.62	-	-	16.0	19.0	44.5	19.0	22.4	-	184	-	57	-
100	4	115.5	100.7	-	-	10.69	9.35	-	-	-	-	8.56	-	-	19.0	19.0	48.0	22.4	28.4	-	201	-	66	-

注释 (续) Continual Note:

4)当产品为异径时, 其外形尺寸与等径管件相同, 异径端的 B、J、D 的按异径端的尺寸加工。

When the fittings are reducing, the shapes are the same as the ones of the straight fittings dimensions of reducing side(B,J,D) shall be produced according to the reducing sizes.

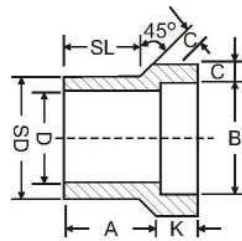
5)双承口管箍也可加工成同心异径或偏心异径型式。

Full couplings can be concentric or eccentric.

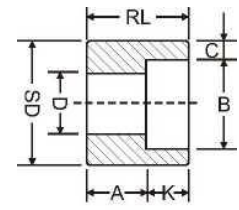
6)可按要求加工成承插焊或螺纹混合的连接型式。

Fittings with the mixed type of socket weld and threaded are also available.

## MSS SP-7 承插焊异径插件 MSS SP-79 SW REDUCER INSERTS



1 型  
Type 1



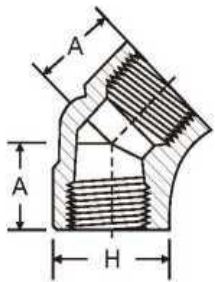
2 型  
Type 2

ASME B16.11

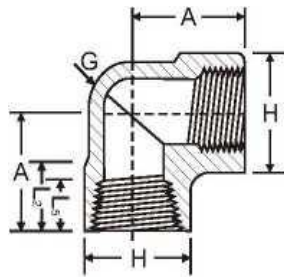
公称尺寸 Nominal size		型式 Type		承插孔径 Socket bore diameter	承插孔深度 Min. Depth of socket	颈体外径 Shank dia	嵌入长度 Laying Length		流通外径 Bore		壁厚 Wall thickness		长度 Length			
DN	NPS	3000	6000	B	Kmin	SD	A		D		C		SL		RL	
							3000	6000	3000	6000	3000	6000	3000	6000	3000	6000
10x8	3/8 x 1/4	1	1	14.3	9.5	17.1	19.1	21.3	9.2	6.4	3.8	4.6	14.2	15.7	-	-
15x10	1/2x3/8	1	1	17.7	9.5	21.3	20.6	23.1	12.5	9.1	4.0	5.0	15.7	15.7	-	-
x8	x 1/4	1	1	14.3	9.5		20.6	20.6	9.2	6.4	3.8	4.6	15.7	15.7	-	-
20x15	3/4 x 1/2	1	1	21.9	9.5	26.7	22.4	25.4	15.8	11.8	4.7	6.0	17.5	19.1	27.0	-
X10	x3/8	2	1	17.7	9.5		15.7	22.4	12.5	9.1	4.0	5.0	-	19.1	27.0	32.0
x8	x1/4	2	2	14.3	9.5	33.4	17.5	22.4	9.2	6.4	3.8	4.6	-	-	-	-
25x20	1 x3/4	1	1	27.3	12.5		23.9	28.5	20.9	15.5	4.9	7.0	19.1	20.6	-	-
x 15	x1/2	2	1	21.9	9.5	42.2	15.7	28.5	15.8	11.8	4.7	6.0	-	20.6	28.5	-
x10	X3/8	2	2	17.7	9.5		17.5	22.4	12.5	9.1	4.0	5.0	-	-	28.5	33.3
x8	x1/4	2	2	14.3	9.5	19.1	23.9	9.2	6.4	3.8	4.6	-	-	28.5	33.3	-
32x25	1 1/4 X 1	1	1	34.0	12.5	60.3	25.4	30.2	26.6	20.7	5.7	7.9	20.6	22.4	-	-
x20	x3/4	2	2	27.3	12.5		17.5	20.6	20.9	15.5	4.9	7.0	-	-	31.8	34.8
x 15	x1/2	2	2	21.9	9.5	19.1	22.4	15.8	11.8	4.7	6.0	-	-	31.8	34.8	-
X 10	x3/8	2	2	17.7	9.5	20.6	23.9	12.5	9.1	4.0	5.0	-	-	31.8	34.8	-
x8	x1/4	2	2	14.3	9.5	22.4	25.4	9.2	6.4	3.8	4.6	-	-	31.8	34.8	-
40x32	1 1/2 X 1 1/4	1	1	42.8	12.5	73.0	28.5	35.1	35.1	29.5	6.1	7.9	22.4	25.4	-	-
x 25	X1	2	1	34.0	12.5		17.5	29.2	26.6	20.7	5.7	7.9	-	25.4	33.3	-
X20	x3/4	2	2	27.3	12.5	19.1	25.4	20.9	15.5	4.9	7.0	-	-	33.3	39.6	-
x 15	x1/2	2	2	22.0	9.5	20.6	26.9	15.8	11.8	4.7	6.0	-	-	33.3	39.6	-
X10	x3/8	2	2	17.7	9.5	22.4	28.5	12.5	9.1	4.0	5.0	-	-	33.3	39.6	-
50x40	2 x 1 1/2	1	1	48.9	12.5	88.9	31.8	38.9	40.9	34.0	6.4	8.9	25.4	28.7	-	-
x32	X 1 1/4	2	2	42.8	12.5		20.6	23.9	35.1	29.5	6.1	7.9	-	-	38.1	41.2
x25	x1	2	2	34.0	12.5	22.4	25.4	26.6	20.7	5.7	7.9	-	-	38.1	41.2	-
x20	X3/4	2	2	27.3	12.5	23.9	26.9	20.9	15.5	4.9	7.0	-	-	38.1	41.2	-
x 15	X1/2	2	2	21.9	9.5	25.4	28.5	15.8	11.8	4.7	6.0	-	-	38.1	41.2	-
65x50	2 1/2 x 2	1	1	61.4	16.0	114.3	46.0	42.7	52.5	42.9	6.9	10.9	38.1	31.8	-	-
x40	X 1 1/2	2	2	48.9	12.5		35.1	35.1	40.9	34.0	6.4	8.9	-	-	53.9	53.9
X32	X 1 1/4	2	2	42.8	12.5	36.6	36.6	35.1	29.5	6.1	7.9	-	-	53.9	53.9	-
x25	x1	2	2	34.0	12.5	38.1	38.1	26.6	20.7	5.7	7.9	-	-	53.9	53.9	-
x20	x3/4	2	2	27.3	12.5	39.6	38.1	20.9	15.5	4.9	7.0	-	-	53.9	53.9	-
80x65	3 x 2 1/2	1	1	74.1	16.0	114.3	38.1	57.2	62.7	54.0	8.8	11.9	31.8	44.5	-	-
x 50	x2	2	2	61.4	16.0		25.4	31.8	52.5	42.9	6.9	10.9	-	-	47.5	53.9
X40	x 1 1/2	2	2	48.9	12.5	28.5	31.8	40.9	34.0	6.4	8.9	-	-	47.5	53.9	-
x32	1 1/4	2	2	42.8	12.5	30.2	31.8	35.1	29.5	6.1	7.9	-	-	47.5	53.9	-
x25	x1	2	2	34.0	12.5	31.8	31.8	26.6	20.7	5.7	7.9	-	-	47.5	53.9	-
100 x 80	4x3	2	1	90.0	16.0	114.3	33.3	54.0	77.9	66.6	9.5	13.8	-	-	60.5	-
X 65	x2 1/2	2	2	74.1	16.0		38.1	54.0	62.7	54.0	8.8	12.5	-	-	60.5	-
x50	x2	2	2	61.4	16.0	38.1	54.0	52.5	42.9	6.9	11.0	-	-	60.5	-	-
x40	X 1 1/2	2	2	48.9	12.5	41.2	57.0	40.9	34.0	6.4	8.9	-	-	60.5	-	-
x32	X 1 1/4	2	2	42.8	12.5	42.9	57.0	35.1	29.5	6.1	7.9	-	-	60.5	-	-

注释 Note:

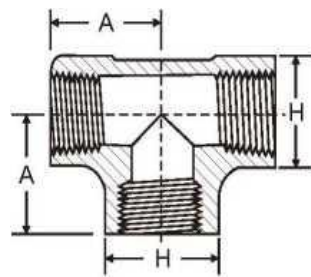
- 1) 制造商选择可以用型式 1 代替型式 2;  
For the manufacturer's option, type 2 can be replaced by type 1.
- 2) 公称尺寸 的表示方为 SD x B;  
The nominal size is showed as SD x B.



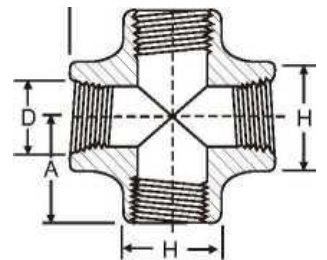
螺纹 45° 弯头  
Threaded 45° Elbow



螺纹 90° 弯头  
Threaded 90° Elbow



螺纹三通  
Threaded Tee



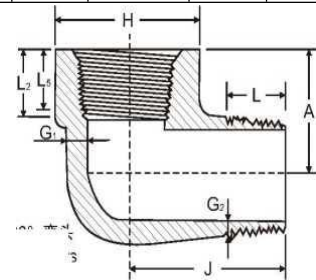
螺纹四通  
Threaded Cross

### GB/T 14383 ASME B16.11

公称直径 Nominal size		中心至端面 Center to end						端面外径 Outside diameter of band			本体壁厚 Wall thickness			螺纹长度 Length of thread	
DN	NPS	A						H			G min			L5min	L2min
		90° Elbows tees Crosses			45° Elbows										
		2000	3000	6000	2000	3000	6000	2000	3000	6000	2000	3000	6000		
6	1/8	21	21	25	17	17	19	22	22	25	3.18	3.18	6.35	6.4	6.7
8	1/4	21	25	28	17	19	22	22	25	33	3.18	3.30	6.60	8.1	10.2
10	3/8	25	28	33	19	22	25	25	33	38	3.18	3.51	6.98	9.1	10.4
15	1/2	28	33	38	22	25	28	33	38	46	3.18	4.09	8.15	10.9	13.6
20	3/4	33	38	44	25	28	33	38	46	56	3.18	4.32	8.53	12.7	13.9
25	1	38	44	51	28	33	35	46	56	62	3.68	4.98	9.93	14.7	17.3
32	1 1/4	44	51	60	33	35	43	56	62	75	3.89	5.28	10.59	17.0	18.0
40	1 1/2	51	60	64	35	43	44	62	75	84	4.01	5.56	11.07	17.8	18.4
50	2	60	64	83	43	44	52	75	84	102	4.27	7.14	12.09	19.0	19.2
65	2 1/2	76	83	95	52	52	64	92	102	121	5.61	7.65	15.29	23.6	28.9
80	3	86	95	106	64	64	79	109	121	146	5.99	8.84	16.64	25.9	30.5
100	4	106	114	114	79	79	79	146	152	152	6.55	11.18	18.67	27.7	33.0

注释 Note:

- 1) 螺纹按 GB/T 12716(等同于 ASME B1.20.1)中的 NPT 螺纹加工。  
NPT thread shall be machined as per GB/T 12716(equivalent to ASME B1.20.1)

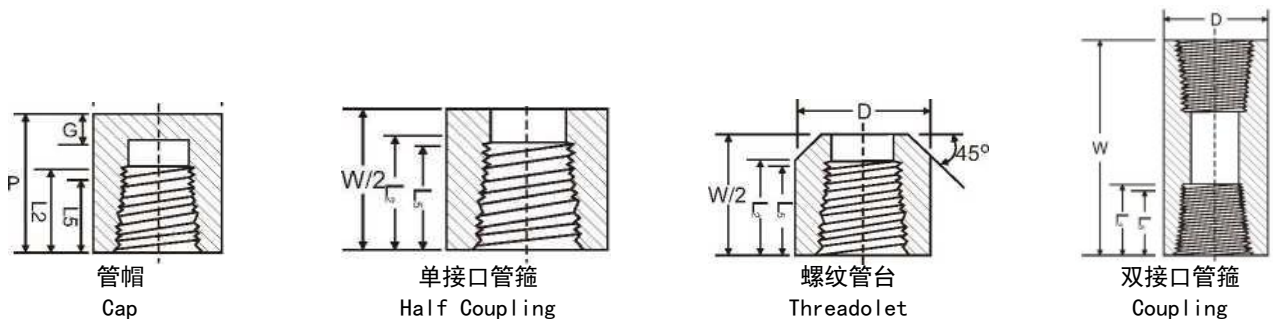


### ASME B16.11

公称尺寸 Nominal size		中心至内螺纹端面 Center to female End		中心至外螺纹端面 Center to male End		端面外径 Outside diameter of band		本体壁厚 Wall thickness		本体壁厚 Wall thickness		内螺纹长度 Length of female thread		外螺纹长度 Length of male thread
DN	NPS	A		J		H		G1min		G2min		L5min	L2min	Lmin
		3000	6000	3000	6000	3000	6000	3000	6000	3000	6000			
6	1/8	19	22	25	32	19	25	3.18	5.08	2.74	4.22	6.4	6.7	10
8	1/4	22	25	32	38	25	32	3.30	5.66	3.22	5.28	8.1	10.2	11
10	3/8	25	28	38	41	32	38	3.51	6.98	3.50	5.59	9.1	10.4	13
15	1/2	28	35	41	48	38	44	4.09	8.15	4.16	6.53	10.9	13.6	14
20	3/4	35	44	48	57	44	51	4.32	8.53	4.88	6.86	12.7	13.9	16
25	1	44	51	57	66	51	62	4.98	9.93	5.56	7.95	14.7	17.3	19
32	1 1/4	51	54	66	71	62	70	5.28	10.59	5.56	8.48	17.0	18.0	21
40	1 1/2	54	64	71	84	70	84	5.56	11.07	6.25	8.89	17.8	18.4	21
50	2	64	83	84	105	84	102	7.14	12.09	7.64	9.70	19.0	19.2	22

注释 Note:

- 1) 制造商也可以选择使用螺纹 90° 弯头的 A 和 H 尺寸。  
For manufacturer's option, dimension A and H of threaded 90° elbow can be employed.
- 2) 螺纹按 GB/T 12716(等同于 ASME B1.20.1)中的 NPT 螺纹加工。  
NPT thread shall be machined as per GB/T 12716(equivalent to ASME B1.20.1)

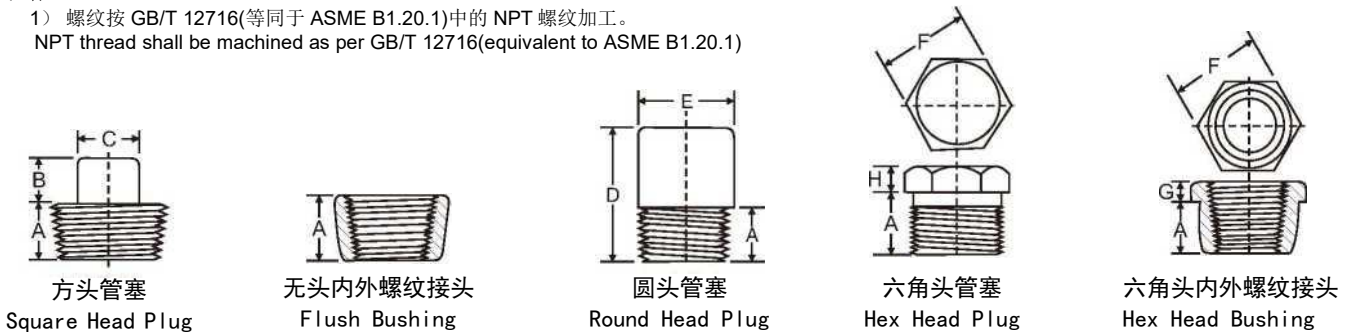


GB/T 14383 ASME B16.11

公称尺寸 Nominal size		端面至端面 End-to-end		端面至端面 End-to-end		外径 Outside diameter		顶部厚度 End wall		螺纹长度 Length of thread	
DN	NPS	W		P		D		G		L5min	L2min
		3000&6000	3000	6000	3000	6000	3000	6000			
6	1/8	32	19	-	16	22	4.8	-	6.4	6.7	
8	1/4	35	25	27	19	25	4.8	6.4	8.1	10.2	
10	3/8	38	25	27	22	32	4.8	6.4	9.1	10.4	
15	1/2	48	32	33	28	38	6.4	7.9	10.9	13.6	
20	3/4	51	37	38	35	44	6.4	7.9	12.7	13.9	
25	1	60	41	43	44	57	9.7	11.2	14.7	17.3	
32	1 1/4	67	44	46	57	64	9.7	11.2	17.0	18.0	
40	1 1/2	79	44	48	64	76	11.2	12.7	17.8	18.4	
50	2	86	48	51	76	92	12.7	15.7	19.0	19.2	
65	2 1/2	92	60	64	92	108	15.7	19.0	23.6	28.9	
80	3	108	65	68	108	127	19.0	22.4	25.9	30.5	
100	4	121	68	75	140	159	22.4	28.4	27.7	33.0	

注释 Note:

- 1) 螺纹按 GB/T 12716(等同于 ASME B1.20.1)中的 NPT 螺纹加工。  
NPT thread shall be machined as per GB/T 12716(equivalent to ASME B1.20.1)



GB/T 14383 ASME B16.11

公称尺寸 Nominal size		长度 Length	方头高度 Square height	方头对边宽度 Width flats	圆头致敬 Head diameter	总长 Length	六角头厚度 Hex height	六角头厚度 Hex height	六角对边宽度 Hex width flats
DN	NPS	Amin	Bmin	C min	Emin	Dmin	Hmin	Gmin	Emin
6	1/8	10	6	7	10	35	6	-	11
8	1/4	11	6	10	14	41	6	3	16
10	3/8	13	8	11	18	41	8	4	18
15	1/2	14	10	14	21	44	8	5	22
20	3/4	16	11	16	27	44	10	6	27
25	1	19	13	21	33	51	10	6	36
32	1 1/4	21	14	24	43	51	14	7	46
40	1 1/2	21	16	28	48	51	16	8	50
50	2	22	18	32	60	64	18	9	65
65	2 1/2	27	19	36	73	70	19	10	75
80	3	28	21	41	89	70	21	10	90
100	4	32	25	65	114	76	25	13	115

注释 Note:

- 1) 螺纹按 GB/T 12716(等同于 ASME B1.20.1)中的 NPT 螺纹加工。  
NPT thread shall be machined as per GB/T 12716(equivalent to ASME B1.20.1)

### 承插焊管件的公差

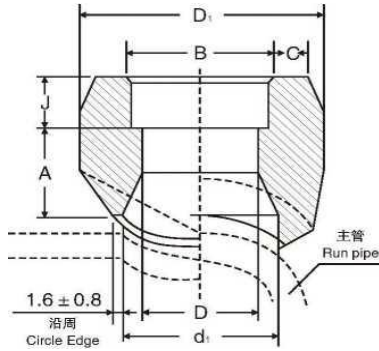
#### TOLERANCE FOR SW FITTINGS

公称直径 Nominal size		所有管件 All fittings		弯头、三通和四通 Elbows, tees & crosses	双接口管箍 Couplings	单接口管箍 Halfcouplings	异径插入件 Reducer inserts			活接头 Unions
		承插孔径 Socket bore dia	流通孔径 Bore dia. of fittings	中心至承插孔底 Center to bottom of socket	承插孔底距离 End wall thickness	承插孔底至端面 Laying length	结构长度 Laying length	主体直径 Shank dia.	长度 Length	结构长度 Laying length
DN	NPS	B	D	AH	E	F	A	SD	SL	E
6-8	1/8-1/4	+0.4 0	+1.5 0	±1.0	±1.5	±1.0	+1.5 0	±0.25	0 -1.5	±1.5
10-20	3/8-3/4	+0.4 0	+1.5 0	±1.5	±3.0	±1.5	+1.5 0	±0.25	0 -1.5	±3.0
25-40	1 —1 1/2	+0.4 0	+ 1.5 0	±2.0	±4.0	±2.0	+2.0 0	±0.25	0 -2.0	±4.0
50	2	+0.5 0	+1.5 0	±2.0	±4.0	±2.0	+2.0 0	±0.5	0 -2.0	±4.0
65-80	2 1/2—3	+0.5 0	+3.0 0	±2.5	±5.0	±2.5	+2.5 0	±0.5	0 -2.5	±5.0
100	4	+0.5 0	+3.0 0	±2.5	±5.0	±2.5	+2.5 0	±0.7	0 -2.5	-

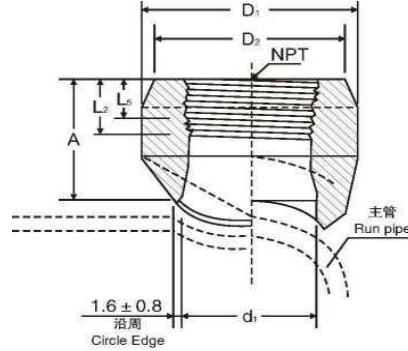
### 螺纹管件的公差

#### TOLERANCE FORTHRD FITTINGS

公称尺寸 Nominal size		弯头、三通和四通 Elbows, tees & crosses	双螺口管箍 Couplings	单螺口管箍 Half-couplings
		中心至端面 Center-to-end	端面至端面 End-to-end	弯头、三通和四通 Elbows, tees & crosses
DN	NPS	A.J	W	W/2
6-8	1/8-1/4	±1.0	±1.0	±1.0
10-20	3/8-3/4	±1.5	±1.5	±1.5
25-50	1-2	±2.0	±2.0	±2.0
65-100	2 1/2-4	±2.5	±2.5	±2.5



承插焊支管座  
Socket



螺纹支管座  
Threadolet

### 承插焊支管座 SOCKOLET

GB/T 19326、HG/T 21632、MSS SP-97

公称尺寸 Nominal size		支管公称尺寸 Branch pipe nominal size		承插孔深度 Depth of socket	结构长度 Face of fitting to crotch		本体直径 D of fitting		承插孔壁厚 Socket wall thickness		开孔直径 Hole dia	
DN	NPS	DN	NPS	Jmin	A max		D max		C min		d1 nom	
					3000	6000	3000	6000	3000	6000	3000	6000
8-900	1/4-36	6	1/8	9.5	10	-	27	-	3.18	-	16	-
10-900	3/8-36	8	1/4	9.5	10	-	27	-	3.78	-	16	-
15-900	1/2-36	10	3/8	9.5	13	-	30	-	4.01	-	19	-
20-900	3/4-36	15	1/2	9.5	16	24	38	47	4.67	5.97	24	19
25-900	1-36	20	3/4	12.5	16	25	47	53	4.90	6.96	30	25
32-900	1 1/4-36	25	1	12.5	22	29	56	63	5.69	7.92	36	33
40-900	1 1/2-36	32	1 1/4	12.5	22	30	66	74	6.07	7.92	45	38
50-900	2-36	40	1 1/2	12.5	24	32	75	83	6.35	8.92	51	49
65-900	2 1/2-36	50	2	16.0	24	37	90	104	6.93	10.92	65	59
80-900	3-36	65	2 1/2	16.0	25	-	105	-	8.76	-	76	-
100-900	4-36	80	3	16.0	30	-	124	-	9.52	-	94	-
125-900	5-36	100	4	19.0	30	-	154	-	10.69	-	121	-

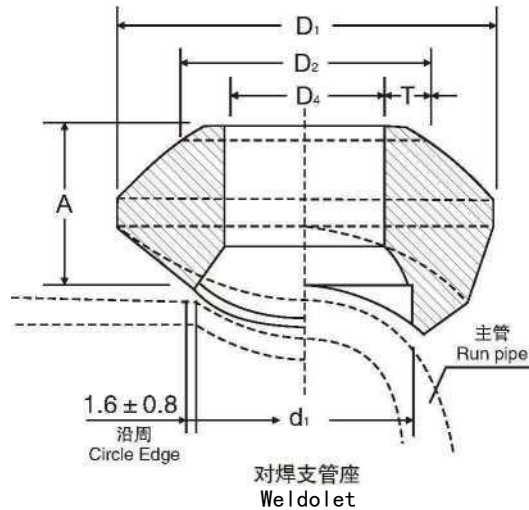
### 螺纹支管座 THREADOLET

GB/T 19326、HG/T 21632、MSS SP-97

公称尺寸 Nominal size		支管公称尺寸 Branch pipe nominal size		承插孔深度 Depth of socket	结构长度 Face of fitting to crotch		本体直径 D of fitting		承插孔壁厚 Socket wall thickness	开孔直径 Hole dia		
DN	NPS	DN	NPS	J min	A max		D max		C min	d1 nom		
					3000	3000	6000	3000		6000	3000	6000
8-900	1/4-36	6	1/8	19	-	27	-	22	-	6.7	16	-
10-900	3/8-36	8	1/4	19	-	27	-	22	-	10.2	16	-
15-900	1/2-36	10	3/8	21	-	30	-	25	-	10.4	19	-
20-900	3/4-36	15	1/2	25	32	38	45	33	42	13.6	24	19
25-900	1-36	20	3/4	27	37	47	52	39	48	13.9	30	25
32-900	1 1/4-36	25	1	33	40	56	63	48	58	17.3	36	33
40-900	1 1/2-36	32	1 1/4	33	41	66	72	58	67	18.0	45	38
50-900	2-36	40	1 1/2	35	43	75	83	64	77	18.4	51	49
65-900	2 1/2-36	50	2	38	52	90	104	77	93	19.2	65	59
80-900	3-36	65	2 1/2	46	-	105	-	94	-	28.9	76	-
100-900	4-36	80	3	51	-	124	-	114	-	30.5	94	-
125-900	5-36	100	4	57	-	154	-	140	-	33.0	121	-

注释 Note:

- 1) 螺纹按 GB/T 12716(等同于 ASME B1.20.1)中的 NPT 螺纹加工。  
NPT thread shall be machined as per GB/T 12716(equivalent to ASME B1.20.1)



### 对焊支管台 WELDOLET

GB/T 19326、HG/T 21632、MSS SP-97

主管公称尺寸 Run pipe nominal size		支管公称尺寸 Branch Nominal size		长度 Lengths			本体直径 Dia.of Fitting			开孔直径 Hole Dia.		
DN	NPS	DN	NPS	A			D2 min			d1 nom		
				STD	XS	Sch160	STD	XS	Sch160	STD	XS	Sch160
8-900	1/4-36	6	1/8	16	16	-	24	42	-	16	16	-
10-900	3/8-36	8	1/4	16	16	-	26	26	-	16	16	-
15-900	1/2-36	10	3/8	19	19	-	30	30	-	19	19	-
20-900	3/4-36	15	1/2	19	19	28	36	36	36	24	24	14
25-900	1-36	20	3/4	22	22	32	43	43	46	30	30	19
32-900	1 1/4-36	25	1	27	27	38	55	55	51	36	36	25
40-900	1 1/2-36	32	1 1/4	32	32	44	66	66	63	45	45	33
50-900	2-36	40	1 1/2	33	33	51	74	74	71	51	51	38
65-900	2 1/2-36	50	2	38	38	55	90	90	82	65	65	43
80-900	3-36	65	2 1/2	41	41	62	104	104	98	76	76	54
90-900	3 1/2-36	80	3	44	44	73	124	124	122	93	93	73
100-900	4-36	90	3 1/2	48	48	-	138	138	-	113	113	-
125-900	5-36	100	4	51	51	84	154	154	154	120	120	98
150-900	6-36	125	5	57	57	94	187	187	188	141	141	122
200-900	8-36	150	6	60	78	105	213	227	222	170	170	146
250-900	10-36	200	8	70	99	-	265	292	-	220	220	-
300-900	12-36	250	10	78	94	-	323	325	-	275	265	-
350-900	14-36	300	12	86	103	-	379	381	-	325	317	-
400-900	16-36	350	14	89	100	-	411	416	-	357	351	-
450-900	18-36	400	16	94	106	-	465	468	-	408	403	-
500-900	20-36	450	18	97	111	-	522	525	-	459	455	-
550-900	22-36	500	20	102	119	-	573	584	-	508	509	-
650-900	26-36	600	24	116	140	-	690	708	-	614	612	-

注释 Note:

D2 与支管接管外径相等、D4 与支管接管内径相等、T 与支管接管壁厚相等。

Dimension D2 is equal to the outside diameter of the branch pipe, and D4 is equal to the inside diameter of the branch pipe, and T is equal to the wall thickness of the branch pipe.

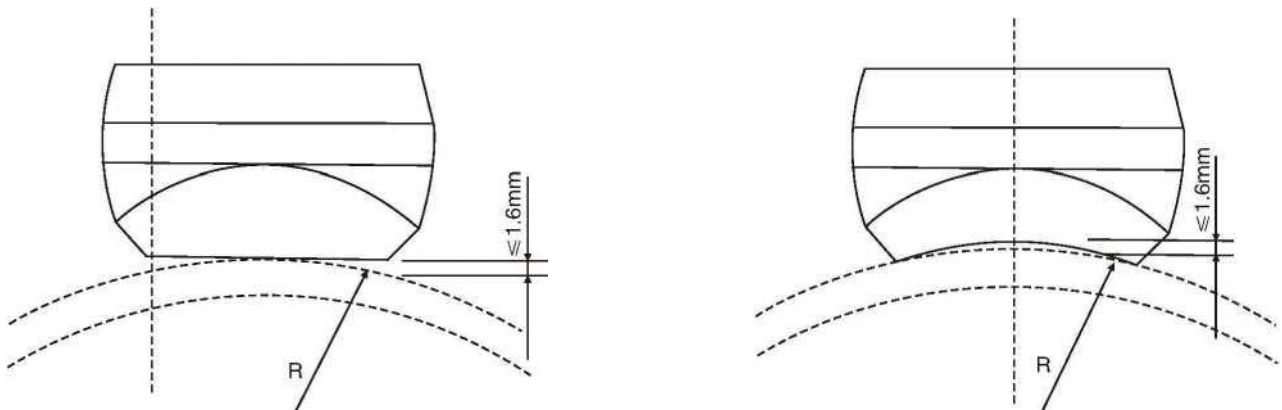
### 支管座的公差

### TOLERANCES OF OUTLETS

支管公称尺寸 Branch nominal size		螺纹对焊 Threadolet	承插焊 Socketolet		对焊 Weldolet	
DN	NPS	A	B	D	D2	d4
6-20	1/8-3/4	±0.8	+0.5 0	+1.5 0	+0.8 -0.4	±0.4
25-100	1-4	±1.6	+0.5 0	+1.5 0	+0.8 -0.4	±0.4
125-300	5-12	±3.2	-	-	+1.6 -0.8	±0.8
350-600	14-24	±4.8	-	-	+ 1.6 -0.8	±0.8

支管座于主管之间的间隙允许偏差如下图

The following figures show the allowable spacing tolerances between outlet and the running pipe



### 支管座的级别与壁厚的关系

### CLASS OF OUTLETS VS SCHEDULE OF THE CONNECTING RUN PIPE

支管公称尺寸 Branch nominal size		连接型式 Type	支管座的级别 Class of outlet	使用的主管壁厚 Schedule of the connecting run pipe
DN	NPS			
6-100	1/8-4	承插焊、螺纹 Socket welding&threaded	3000	XS
15-50	1/2-2	承插焊、螺纹 Socket welding&threaded	6000	SCH 160
6-600	1/8-24	对焊 Butt-welding	STD	STD
6-600	1/8-24	对焊 Butt-welding	XS	XS
15-150	1/2-6	对焊 Butt-welding	SCH160	SCH 160

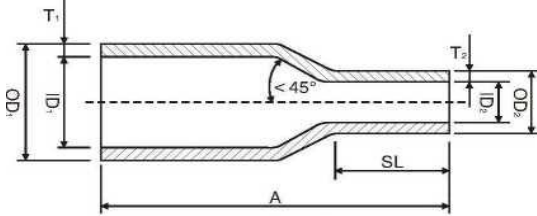
注释 Note :

当支管或主管的厚度超出本表规定时,经制造商和采购方协商,支管座可以制成特殊的厚度、尺寸和形状。

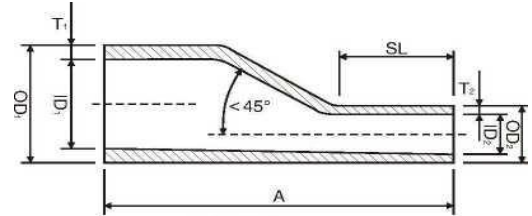
When the thickness(schedule)of the branch or running pipe exceed the range indicated in the above table,the outlet can be fabricated to special thickness,dimension and shape against the agreement between the purchaser and manufacturer.

### 异径短节

### SWAGED NIPPLES



同心异径短节  
Concentric Swaged Nipple



偏心异径短节  
Eccentric Swaged Nipple

#### MSSSP-95 SH/T3419

公称尺寸 Nominal Size		端部外径 OD at End	小端长度 Length of Small End	端面至端面 End to End
DN	NPS	OD1 X OD2	SL min	A
8x6	1/4 x 1/8	13.7x10.3	20	57
10x6	3/8 x 1/8	17.1 x10.3	20	64
10x8	3/8 x 1/4	17.1 x 13.7	20	
15x6	1/2 x 1/8	21.3x10.3	20	70
15x8	1/2x 1/4	21.3x13.7	20	
15x10	1/2x3/8	21.3x17.1	20	76
20x6	3/4 x 1/8	26.7x10.3	20	
20x8	3/4 x 1/4	26.7x13.7	20	
20x10	3/4 x 3/8	26.7x17.1	22	
20x15	3/4 x 1/2	26.7x21.3	22	89
25x6	1 x-1/8	33.4x10.3	20	
25x8	1 x1/4	33.4x13.7	20	
25x10	1 x3/8	33.4x17.1	22	
25x15	1 x1/2	33.4x21.3	22	
25x20	1 x3/4	33.4x26.7	22	
32x6	1 1/4 X 1/8	42.2x10.3	20	102
32x8	1 1/4 X 1/4	42.2x13.7	20	
32x10	1 1/4 x 3/8	42.2x17.1	22	
32x15	1 1/4X1/2	42.2x21.3	22	
32x20	1 1/4 X 3/4	42.2x26.7	25	
32x25	1 1/4 X 1	42.2x33.4	25	
40x6	1 1/2 X 1/8	48.3x10.3	20	114
40x8	1 1/2 X 1/4	48.3x13.7	20	
40x10	1 1/2 x 3/8	48.3x17.1	22	
40x15	1 1/2 x 1/2	48.3x21.3	25	
40x20	1 1/2 x 3/4	48.3x26.7	25	
40x25	1 1/2 X 1	48.3x33.4	25	
40x32	1 1/2X 1 1/4	48.3x42.2	25	165
50x6	2x1/8	60.3x10.3	20	
50x8	2x1/4	60.3x13.7	22	
50x10	2x3/8	60.3x17.1	22	
50x15	2x1/2	60.3x21.3	25	
50x20	2x3/4	60.3x26.7	30	
50x25	2x1	60.3x33.4	30	
50x32	2x1 1/4	60.3x42.2	30	
50x40	2x1 1/2	60.3x48.3	30	

公称尺寸 Nominal Size		端部外径 OD at End	小端长度 Length of Small End	端面至端面 End to End
DN	NPS	OD1 X OD2	SL min	A
65x6	2 1/2X 1/8	73.0x10.3	22	178
65x8	2 1/2X 1/4	73.0x13.7	22	
65x10	2 1/2X 3/8	73.0x17.1	22	
65x15	2 1/2X 1/2	73.0x21.3	25	
65x20	2 1/2X 3/4	73.0x26.7	25	
65x25	2 1/2 x 1	73.0x33.4	30	
65x32	2 1/2 X 1 1/4	73.0x42.2	30	
65x40	2 1/2 X 1 1/2	73.0x48.3	40	
65x50	2.1/2 x 2	73.0x60.3	40	
80x6	3x1/8	88.9x10.3	22	
80x8	3x1/4	88.9x13.7	22	
80x10	3x3/8	88.9x17.1	22	
80x15	3x1/2	88.9x21.3	25	
80x20	3x3/4	88.9x26.7	25	
80 x 25	3x1	88.9x33.4	30	
80x32	3x 1 1/4	88.9x42.2	30	
80x40	3 X 1 1/2	88.9x48.3	40	
80x50	3x2	88.9x60.3	40	
80x65	3 x 2 1/2	88.9x73.0	40	
90x6	3 1/2X 1/8	101.6x 10.3	22	203
90x8	3 1/2X 1/4	101.6x13.7	22	
90x10	3 1/2X 3/8	101.6x17.1	22	
90x15	3 1/2X 1/2	101.6x21.3	25	
90x20	3 1/2X 3/4	101.6x26.7	25	
90x25	3 1/2X 1	101.6x33.4	30	
90x32	3 1/2 X 1 1/4	101.6x42.2	30	
90x40	3 1/2 X 1 1/2	101.6x48.3	40	
90x50	3 1/2X 2	101.6x60.3	40	
90x65	3 1/2 X 2 1/2	101.6x73.0	40	
90x80	3 1/2X 3	101.6x88.9	40	229
100x8	4x1/4	114.3X 13.7	25	
100x10	4x3/8	114.3X 17.1	25	
100x15	4x1/2	114.3x21.3	25	
100x20	4x3/4	114.3x26.7	30	
100x25	4x1	114.3x33.4	30	
100x32	4x 1 1/4	114.3x42.2	40	

公称尺寸 Nominal Size		端部外径 OD at End	小端长度 Length of Small End	端面至端面 End to End
DN	NPS	OD1 X OD2	SL min	A
100x40	4x 1 1/2	114.3x48.3	40	229
100x50	4x2	114.3x60.3	45	
100x65	4 x 2 1/2	114.3x73.0	45	
100x80	4x3	114.3x88.9	45	
100x90	4 x 3 1/2	114.3x101.6	45	
125x8	5x1/4	141.3x 13.7	25	279
125x10	5x3 8	141.3x 17.1	25	
125x15	5x1/2	141.3x21.3	25	
125x20	5x3/4	141.3x26.7	30	
125x25	5x1	141.3x33.4	30	
125x32	5 X 1 1/4	141.3x42.2	40	
125x40	5 X 1 1/2	141.3x48.3	40	
125x50	5x2	141.3x60.3	45	
125x65	5 x 2 1/2	141.3x73.0	45	
125x80	5x3	141.3x88.9	45	
125x90	5 x 3 1/2	141.3x101.6	45	304
125x100	5x4	141.3x114.3	50	
150x15	6x1/2	168.3x21.3	30	
150x20	6x3/4	168,3x26.7	30	
150x25	6x1	168.3x33.4	40	
150x32	6x 1 1/4	168.3x42.2	40	
150x40	6 X 1 1/2	168.3x48.3	45	
150x50	6x2	168.3x60.3	45	
150x65	6 x 2 1/2	168.3x73.0	45	
150x80	6x3	168.3x88.9	45	
150x90	6 x 3 1/2	168.3x101.6	50	
150x100	6x4	168.3x114.3	50	
150x125	6x5	168.3x141.3	60	

公称尺寸 Nominal Size		端部外径 OD at End	小端长度 Length of Small End	端面至端面 End to End	
DN	NPS	OD1 X OD2	SL min	A	
200 x 25	8x1	219.1 x33.4	40	330	
200 x 32	8 X 1 1/4	219.1 X42.2	40		
200 x 40	8 X 1 1/2	219.1 X48.3	45		
200 x 50	8x2	219.1 X60.3	45		
200 x 65	8 x 2 1/2	219.1 X73.0	45		
200 x 80	8x3	219.1 X88.9	50		
200 x 90	8 x 3 1/2	219.1 X101.6	50		
200x100	8x4	219.1 X114.3	50		
200x125	8x5	219.1 X141.3	60		
200x150	8x6	219.1 X168.3	60		
250 x 50	10x2	273.0x60.3	45	381	
250 x 65	10 x 2 1/2	273.0x73.0	45		
250 x 80	10x3	273.0x88.9	50		
250 x 90	10 x 3 1/2	273.0x101.6	50		
250x100	10x4	273.0x114.3	60		
250x125	10x5	273.0x141.3	60		
250x150	10x6	273.0x168.3	65		
250 x 200	10x8	273.0x219.1	65		
300 x 50	12x2	323.8x60.3	50		406
300 x 65	12 x 2 1/2	323.8x73.0	50		
300 x 80	12x3	323.8x88.9	60		
300 x 90	12 x 3 1/2	323.8x101.6	60		
300x100	12x4	323.8x114.3	65		
300x125	12x5	323.8x141.3	65		
300x150	12x6	323.8x168.3	65		
300 x 200	12x8	323.8x219.1	70		
300 x 250	12x10	323.8x273.0	70		

**注释:**

1)当按 SH/T 3419 标准订货时,其外径应使用 SH/T 3405《石油化工企业钢管外径系列》中规定的外径。

**Note:**

1 )If ordering per SH/T 3419,the outside diameter specified in SH/T 3405 "Tube Outside Diameter In Petrochemical Industry" shall be applied.

**异径短节的公差**

**TOLERANCES OF SWAGED NIPPLES**

公称直径 Nominal Size		端部外径 OD at End		端部内径 ID at End	端面至端面 End to End	壁厚 Wall Thickness
DN	NPS	OD		ID	A	T
		平口端部 Plain End	其它端部 Other Ends			
6-10	1/8-3/8	+0.4 -0.8	±0.8	±0.8	±1.6	不小于公称壁厚的 87.5% Not less than 87.5% Nominal Wall Thickness
15-40	1/2-1 1/2	+0.4 -0.8	±1.6 -0.8	±0.8	±1.6	
50-65	2-2 1/2	±0.8	+1.6 -0.8	±0.8	±3.2	
80-100	3-4	±0.8	±1.6	±1.6	±3.2	
125-150	5-6	+2.4 -1.6	+2.4 -1.6	±1.6	±4.8	
200-300	8-12	+4.0 -3.2	+4.0 -3.2	±3.2	±6.4	