



What is a Socket-Weld/Forged Fitting?

A Socket Weld is a pipe attachment detail in which a pipe is inserted into a recessed area of a Valve, fitting or flange. In contrast to butt weld fittings, Socket Weld fittings are mainly used for small pipe diameters (Small Bore Piping); generally for piping whose nominal diameter is NPS 2 or smaller. These fittings are wrought fitting— Fittings made of pipe, tubing, plate or forgings by Forming process or Forging or shaping operations may be performed by hammering, pressing, piercing, extruding, upsetting, rolling, bending, fusion welding, machining, or by a combination of two or more of these operations.

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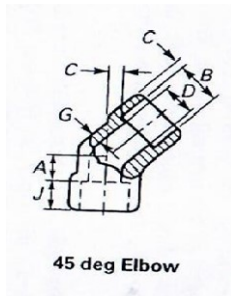
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SOCKET-WELD FITTINGS ANSI B16.11

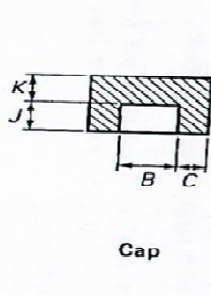


[KEMLITE PIPING SOLUTION]

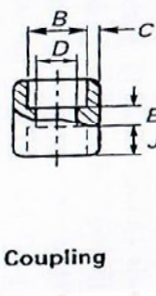
"Renowned for impervious connections"



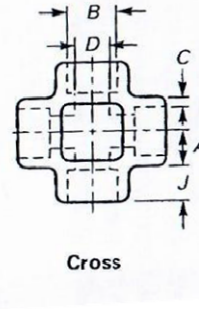
45 deg Elbow



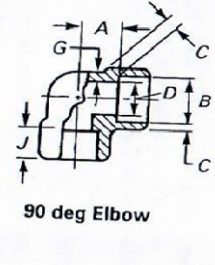
Cap



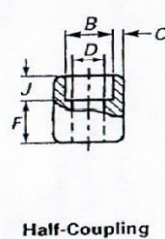
Coupling



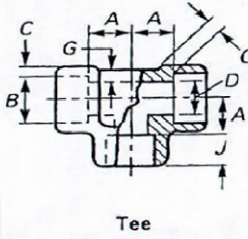
Cross



90 deg Elbow



Half-Coupling



Tee

Bore Diameter of fitting			Socket Wall Thickness									minimum Depth of J
Class designation			3000#			6000#		9000#				
DN	NP Size	Diameter	3000#	6000#	9000#	Avg	Min	Avg	Min	Avg	Min	
6	1/8"	11.2	7.6	4.8	-	3.18	3.18	3.96	3.43	-	-	9.5
		10.8	6.1	3.2	-							
8	1/4"	14.6	10	7.1	-	3.78	3.3	4.6	4.01	-	-	9.5
		14.2	8.5	5.6	-							
10	3/8"	18	13.3	9.9	-	4.01	3.5	5.03	4.37	-	-	9.5
		17.6	11.18	8.4	-							
15	1/2"	22.2	16.6	12.5	7.2	4.67	4.09	5.97	5.18	9.35	8.18	9.5
		21.8	15	11	5.6							
20	3/4"	27.6	21.7	16.3	11.8	4.9	4.27	6.96	6.04	9.78	8.56	12.5
		27.2	20.2	14.8	10.3							
25	1"	34.3	27.4	21.5	16	5.69	4.98	7.92	6.93	11.38	9.96	12.5
		33.9	25.9	19.9	14.4							
32	1 1/4"	43.1	35.8	30.2	23.5	6.07	5.26	7.92	6.93	12.14	10.62	12.5
		42.7	34.3	28.7	22							
40	1 1/2"	49.2	41.6	34.7	28.7	6.35	5.54	8.92	7.8	12.7	11.12	12.5
		48.8	40.1	33.2	27.2							
50	2"	61.7	53.3	43.6	38.9	6.93	6.04	10.92	9.5	13.84	12.12	16
		61.2	51.7	42.1	37.4							
65	2 1/2"	74.4	64.2	-	-	8.76	7.67	-	-	-	-	16
		73.9	61.2	-	-							
80	3"	90.3	79.4	-	-	9.52	8.3	-	-	-	-	16
		89.8	76.4	-	-							
100	4"	115.7	103.8	-	-	10.69	9.35	-	-	-	-	16

SOCKET-WELD FITTINGS ANSI B16.11

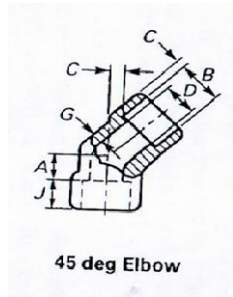


[KEMPLITE PIPING SOLUTION]

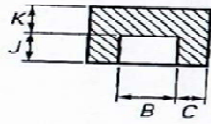
"Renowned for impervious connections"

115.2

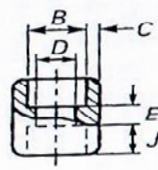
100.4



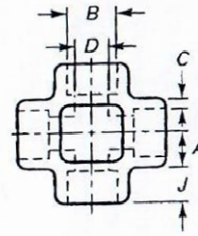
45 deg Elbow



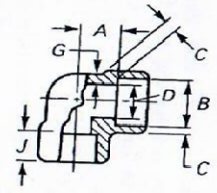
Cap



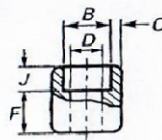
Coupling



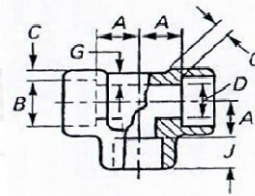
Cross



90 deg Elbow

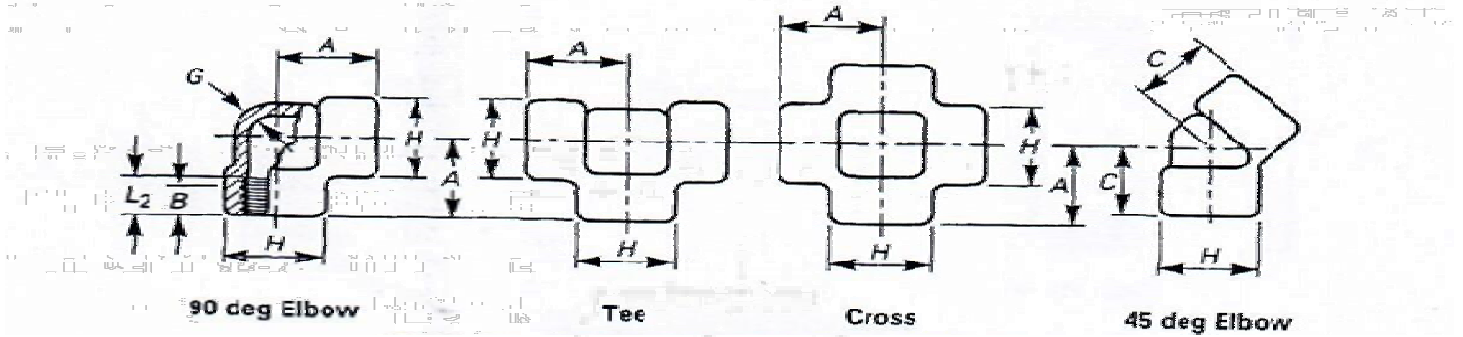


Half-Coupling

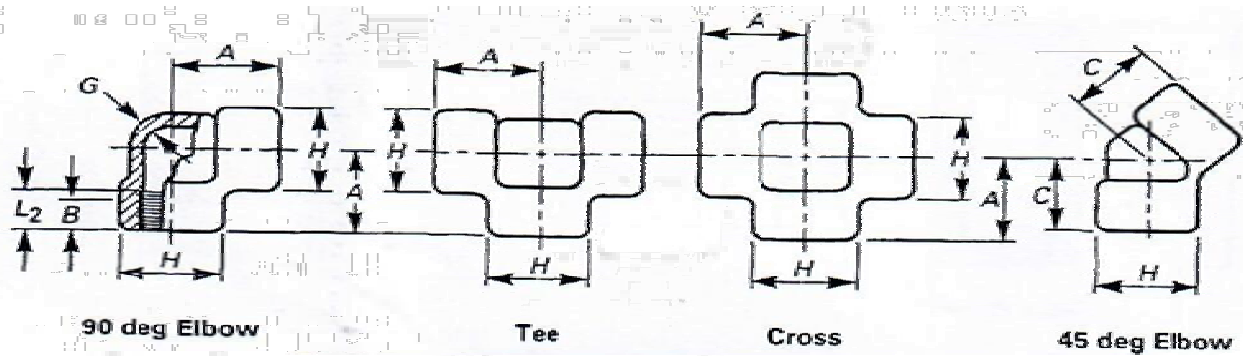


Tee

Center to bottom of socket A						LAYING LENGTHS		Tolerances			End Wall thickness		
90 Deg Elbow			45 Deg Elbow			Coupling	Half Coupling	A	E	F	3000#	6000#	9000#
3000#	6000#	9000#	3000#	6000#	9000#	E	F						
11	11	-	8	8	-	6.5	16	1	1.5	1	4.8	6.4	-
11	13.5	-	8	8	-	6.5	16	1	1.5	1	4.8	6.4	-
13.5	15.5	-	8	11	-	6.5	17.5	1.5	3	1.5	4.8	6.4	-
15.5	19	25.5	11	12.5	15.5	9.5	22.5	1.5	3	1.5	6.4	7.9	11.2
19	22.5	28.5	13	14	19	9.5	24	1.5	3	1.5	6.4	7.9	12.7
22.5	27	32	14	17.5	20.5	12.5	28.5	2	4	2	9.6	11.2	14.2
27	32	35	17.5	20.5	22.5	12.5	30	2	4	2	9.6	11.2	14.2
32	38	38	20.5	25.5	25.5	12.5	32	2	4	2	11.2	12.7	15.7
38	41	54	25.5	28.5	28.5	19	41	2	4	2	12.7	15.7	19
41	-	-	28.5	-	-	19	43	2.5	5	2.5	15.7	19	-
57	-	-	32	-	-	19	44.5	2.5	5	2.5	19	22.4	-
66.5	-	-	41	-	-	19	48	2.5	5	2.5	22.4	28.4	-



Nominal Pipe Size		Center To end			Center To end		
DN		Elbow 2000#	Tees 3000#	Crosses 6000#	2000#	3000#	6000#
6	1/8"	21	21	25	17	17	19
8	1/4"	21	25	28	17	19	22
10	3/8"	25	28	33	19	22	25
15	1/2"	28	33	38	22	25	28
20	3/4"	33	38	44	25	28	33
25	1"	38	44	51	28	33	35
32	1 1/4"	44	51	60	33	35	43
40	1 1/2"	51	60	64	35	43	44
50	2"	60	64	83	43	44	52
65	2 1/2"	76	83	95	52	52	64
80	3"	86	95	106	64	64	79
100	4"	106	114	114	79	79	79

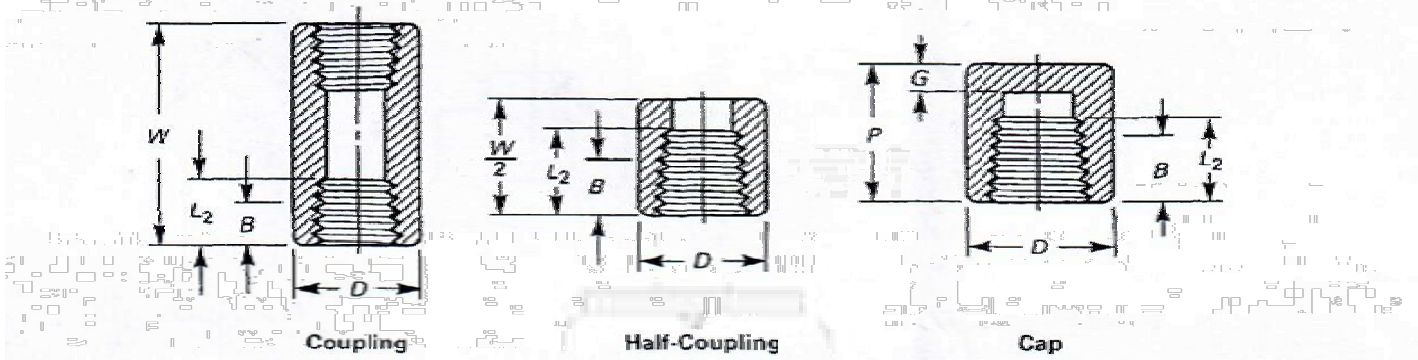


Outside Diameter OF bend

Min Wall Thickness

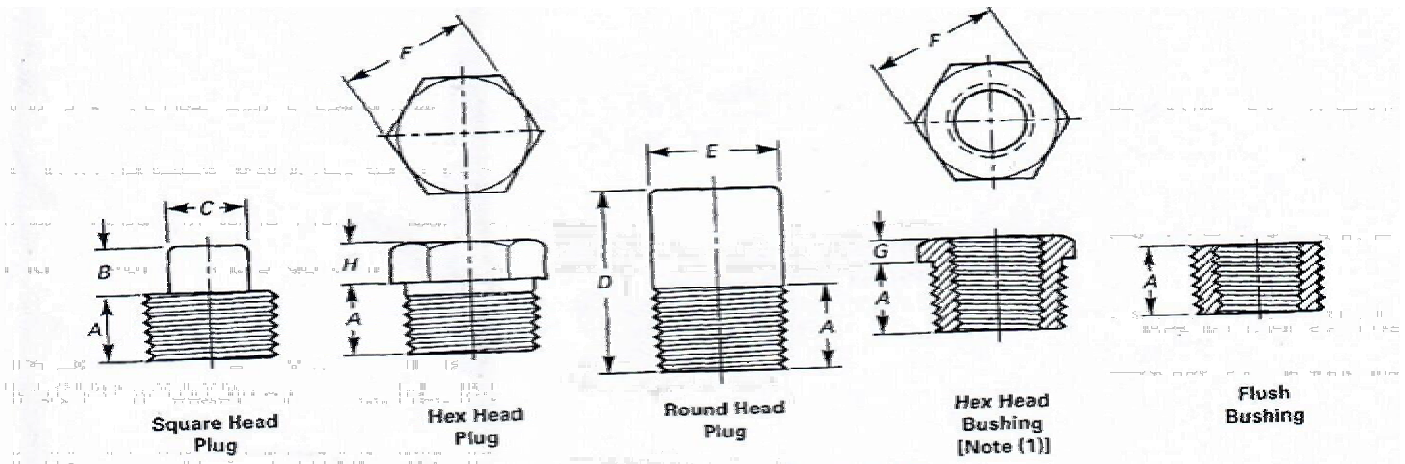
Minimum length of thread

	H			G			Minimum length of thread	
	2000#	3000#	6000#	2000#	3000#	6000#	B	L2
22	22	25		3.18	3.18	6.35	6.4	6.7
22	25	33		3.18	3.3	6.6	8.1	10.2
25	33	38		3.18	3.52	6.98	9.1	10.4
33	38	46		3.18	4.09	8.15	10.9	13.6
38	46	56		3.18	4.32	8.53	12.7	13.9
46	56	62		3.68	4.98	9.93	14.7	17.3
56	62	75		3.89	5.28	10.59	17	18
62	75	84		4.01	5.56	11.07	17.8	18.4
75	84	102		4.27	7.14	12.09	19	19.2
84	102	121		5.61	7.65	15.29	23.6	28.9
109	121	146		5.99	8.84	16.64	25.9	30.5
146	152	152		6.55	11.18	18.67	27.7	33



DN	Nominal Pipe Size	End to End Coupling (W)		End to End Caps (P)		Out Side Diameter (D)		Minimum End Wall thickness (G)		Minimum Length of thread	
		3000#	6000#	3000#	6000#	3000#	6000#	3000#	6000#	B	L2
6	1/8"	32	32	19	-	16	22	4.8		6.4	6.7
8	1/4"	35	35	25	27	19	25	4.8	6.4	8.1	10.2
10	3/8"	38	38	25	27	22	32	4.8	6.4	9.1	10.4
15	1/2"	48	48	32	33	28	38	6.4	7.9	10.9	13.6
20	3/4"	51	51	37	38	35	44	6.4	7.9	12.7	13.9
25	1"	60	60	41	43	44	57	9.7	11.2	14.7	17.3
32	1 1/4"	67	67	44	46	57	64	9.7	11.2	17	18
40	1 1/2"	79	79	44	48	64	76	11.2	12.7	17.8	18.4
50	2"	86	86	48	51	76	92	12.7	15.7	19	19.2
65	2 1/2"	92	92	60	64	92	108	15.7	19	23.6	28.9
80	3"	108	108	65	68	108	127	19	22.4	25.9	30.5
100	4"	121	121	68	75	140	159	22.4	28.4	27.7	33





DN	Nominal Pipe Size	Min Length (A)	Square Head plugs		Round Bar Plugs Head plugs		Hex Plug & bushings		
			Min Square Height	Min Width flats	Nominal Head Diameter	Min Length	Nominal Width Flats	Bushing	Plugs
			B	C	E	D	E	G	H
6	1/8"	10	6	7	10	35	11		6
8	1/4"	11	6	10	14	41	16	3	6
10	3/8"	13	8	11	18	41	18	4	8
15	1/2"	14	10	14	21	44	22	5	8
20	3/4"	16	11	16	27	44	27	6	10
25	1"	19	13	21	33	51	36	6	10
32	1 1/4"	21	14	24	43	51	46	7	14
40	1 1/2"	21	16	28	48	51	50	8	16
50	2"	22	18	32	60	64	65	9	18
65	2 1/2"	27	19	36	73	70	75	10	19
80	3"	28	21	41	89	70	90	10	21
100	4"	32	25	65	114	76	115	13	25