

WELDING ENDS

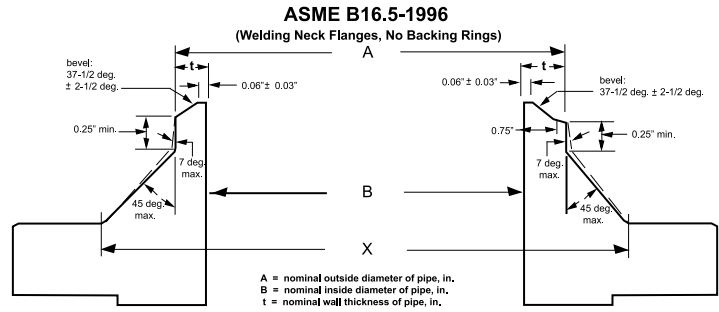


FIG. 8 BEVEL FOR WALL THICKNESSES t FROM 0.19\"

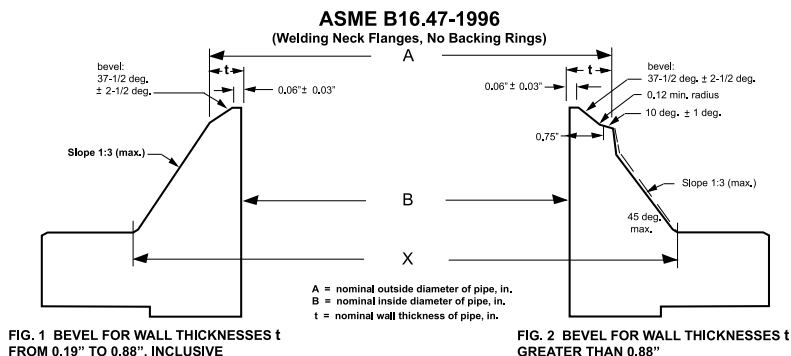
FIG. 9 BEVEL FOR WALL THICKNESSES t GREATER THAN 0.88\"

- NOTES:**
- See paras. 6.7, 6.8 and 7.4 of B16.5-1996 for details and tolerances.
 - See Figs. 10 and 11 of B16.5-1996 for additional details of welding ends.
 - When the thickness of the hub at the bevel is greater than that of the pipe to which the flange is joined and the additional thickness is provided on the outside diameter, a taper weld having a slope not exceeding 1 to 3 may be employed or, alternatively, the greater outside diameter may be tapered, at the same maximum slope or less, from a point on the welding bevel equal to the outside diameter of the mating pipe. Similarly, when the greater thickness is provided on the inside of the flange, it shall be taper-bored from the welding end at a slope not exceeding 1 to 3. When flanges covered by this standard are intended for services with light wall, higher strength pipe, the thickness of the hub at the bevel may be greater than that of the pipe to which the flanges are joined. Under these conditions a single taper hub may be provided and the outside diameter of the hub at the base (dimension X) may also be modified. The additional thickness may be provided on either inside or outside or partially on each side, but the total additional thickness shall not exceed one-half times the nominal wall thickness of intended mating pipe. See Figs. 12, 13, and 14 of ASME B 16.5-1996.

Welding Neck Flange Bores

Nominal Pipe Size	Coastal Flange NOMINAL INSIDE DIAMETERS)													
	O.D. Inches	Schedule 10	Schedule 20	Schedule 30	Standard Wall	Schedule 40	Schedule 60	Extra Strong	Schedule 80	Schedule 100	Schedule 120	Schedule 140	Schedule 160	XX Strong
1/2	0.840	.674	-----	-----	.622	.622	-----	.546	.546	-----	-----	-----	.464	.252
3/4	1.050	.884	-----	-----	.824	.824	-----	.742	.742	-----	-----	-----	.612	.434
1	1.315	1.097	-----	-----	1.049	1.049	-----	.957	.957	-----	-----	-----	.815	.599
1 1/4	1.660	1.442	-----	-----	1.380	1.380	-----	1.278	1.278	-----	-----	-----	1.160	.896
1 1/2	1.900	1.682	-----	-----	1.610	1.610	-----	1.500	1.500	-----	-----	-----	1.338	1.100
2	2.375	2.157	-----	-----	2.067	2.067	-----	1.939	1.939	-----	-----	-----	1.687	1.503
2 1/2	2.875	2.635	-----	-----	2.469	2.469	-----	2.323	2.323	-----	-----	-----	2.125	1.771
3	3.500	3.260	-----	-----	3.068	3.068	-----	2.900	2.900	-----	-----	-----	2.624	2.300
3 1/2	4.000	3.760	-----	-----	3.548	3.548	-----	3.364	3.364	-----	-----	-----	-----	2.728
4	4.500	4.260	-----	-----	4.026	4.026	-----	3.826	3.826	-----	3.624	-----	3.438	3.152
5	5.563	5.295	-----	-----	5.047	5.047	-----	4.813	4.813	-----	4.563	-----	4.313	4.063
6	6.625	6.357	-----	-----	6.065	6.065	-----	5.761	5.761	-----	5.501	-----	5.187	4.897
8	8.625	8.329	8.125	8.071	7.981	7.981	7.813	7.625	7.625	7.437	7.187	7.001	6.813	6.875
10	10.750	10.420	10.250	10.136	10.020	10.020	9.750	9.750	9.562	9.312	9.062	8.750	8.500	8.750
12	12.750	12.390	12.250	12.090	12.000	11.938	11.626	11.750	11.374	11.062	10.750	10.500	10.126	10.750
14	14.000	13.500	13.376	13.250	13.250	13.124	12.812	13.000	12.500	12.124	11.812	11.500	11.188	-----
16	16.000	15.500	15.376	15.250	15.250	15.000	14.688	15.000	14.312	13.938	13.562	13.124	12.812	-----
18	18.000	17.500	17.376	17.124	17.250	16.876	16.500	17.000	16.124	15.688	15.250	14.876	14.438	-----
20	20.000	19.500	19.250	19.000	19.250	18.812	18.376	19.000	17.938	17.438	17.000	16.500	16.062	-----
22	22.000	21.500	-----	-----	21.250	-----	-----	21.000	-----	-----	-----	-----	-----	-----
24	24.000	23.500	23.250	22.876	23.250	22.624	22.062	23.000	21.562	20.938	20.376	19.876	19.312	-----

WELDING ENDS



- NOTES:**
1. See paras. 6.4, 7.4 of B16.47-1996 for details and tolerances.
 2. See Figs. 10 of B16.47-1996 for additional details of welding ends.
 3. When the thickness of the hub at the bevel is greater than that of the pipe to which the flange is joined and the additional thickness is provided on the outside diameter, a taper weld having a slope not exceeding 1 to 3 may be employed or, alternatively, the greater outside diameter may be tapered, at the same maximum slope or less, from a point on the welding bevel equal to the outside diameter of the mating pipe. Similarly, when the greater thickness is provided on the inside of the flange, it shall be taper-bored from the welding end at a slope not exceeding 1 to 3. When flanges covered by this standard are intended for services with light wall, higher strength pipe, the thickness of the hub at the bevel may be greater than that of the pipe to which the flanges are joined. Under these conditions a single taper hub may be provided and the outside diameter of the hub at the base (dimension X) may also be modified. The additional thickness may be provided on either inside or outside or partially on each side, but the total additional thickness shall not exceed one-half times the nominal wall thickness of intended mating pipe. See Figs. 5, 6, and 7 of ASME B 16.47-1996.

Welding Neck Flange Bores

Nominal Pipe Size	Coastal Flange INSIDE DIAMETERS)																	
	O.D. Inches	Schedule 5	True 5	Schedule 10	True 10	Sch 20	Schedule 30	Std. Bore	True 40	Schedule 60	XH Bore	True 80	Schedule 100	Schedule 120	Schedule 140	Schedule 160	XX Strong	
26	26.000				25.376	25.000		25.250			25.000							
28	28.000				27.376	27.000	26.750	27.250										
30	30.000	29.500		29.376	29.376	29.000	28.750	29.250			29.000							
32	32.000				31.376	31.000	30.750	31.250			31.000							
34	34.000				33.376	33.000	32.750	33.250			33.000							
36	36.000				35.376	35.000	34.750	35.250			35.000							
38	38.000							37.250			37.000							
40	40.000							39.250			39.000							
42	42.000							41.250			41.000							
44	44.000							43.250										
46	46.000							45.250										
48	48.000							47.250			47.000							
50	50.000							49.250										
52	52.000							51.250										
54	54.000							53.250			53.000							
56	56.000							55.250										
58	58.000							57.250										
60	60.000							59.250			59.000							