MS BUTT-WELD ELBOW 90° LONG RADIUS SCH 80

90° Long Radius Butt-Weld Elbow · Carbon Steel ASTM A234 WPB · ASME B16.9

BRAND: SW FLOW CONTROLS | SKU: SW-0284 | SIZE 1/2" TO 18" | SCH 80



FIG. 1 | MS BUTT-WELD ELBOW 90° LONG RADIUS SCH 80

PRODUCT OVERVIEW

The SWBM MS Butt-Weld 90° Long Radius Elbow changes flow direction by 90° with a bend radius of 1.5 times the nominal size, giving lower pressure drop and turbulence than a short radius elbow. It is produced from carbon steel to ASTM A234 Grade WPB with a SCH 80 wall, dimensioned to ASME B16.9, and is intended for elevated pressure service.

Ends are bevelled for full penetration butt welding to ASME B16.25, giving a permanent, leak tight joint with a smooth bore and no crevices. Wall thickness matches SCH 80 pipe to ASME B36.10M, so the fitting carries the same pressure rating as the connecting seamless pipe of the same schedule and material.

Fitting type	**90° LR elbow, butt-weld**
Material	**Carbon steel, ASTM A234 WPB**
Dimensional standard	**ASME B16.9**
Wall thickness	**SCH 80, ASME B36.10M**
End connection	**Bevelled butt-weld, ASME B16.25**
Size range	**1/2" to 18" (DN15 to DN450)**

TECHNICAL SPECIFICATION

Material specification	**ASTM A234 / ASME SA234 WPB**
Dimensional standard	**ASME B16.9**
Wall schedule	**SCH 80 to ASME B36.10M**
End preparation	**Bevel to ASME B16.25**
Bevel angle	**37.5° ±2.5°**
Geometry	**Long radius, R = 1.5 x NPS**

Carbon	**0.30% max**
Manganese	**0.29% to 1.06%**
Tensile strength	**415 to 585 MPa**
Yield strength	**240 MPa min**
Pressure rating	**Equal to SCH 80 seamless pipe**
Surface finish	**Black varnish, rust preventive**

FEATURES AND MATERIALS

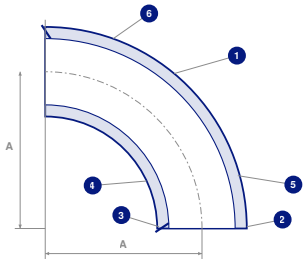


FIG. 2 | SECTION THROUGH ELBOW

#	FEATURE	MATERIAL / DETAIL
1	Body	Carbon steel, ASTM A234 Grade WPB
2	Weld end bevel	37.5° ±2.5° to ASME B16.25
3	Root face (land)	1.6 mm ±0.8 mm
4	Wall thickness	SCH 80 to ASME B36.10M
5	Surface finish	Black varnish, rust preventive
6	Marking	Size, schedule, grade, heat no. (MSS SP-25)

One piece fitting, no assembled parts. Thin walls of 3 mm and under may be supplied square cut or slightly chamfered. Walls over 22 mm are supplied with a compound bevel to ASME B16.25.

DIMENSIONS AND WEIGHTS

SIZE	DN	OD (MM)	WALL (MM)	A (MM)	R (MM)	WEIGHT (KG)
1/2"	15	21.3	3.73	38	38	0.10
3/4"	20	26.7	3.91	38	38	0.13
1"	25	33.4	4.55	38	38	0.19
1.1/4"	32	42.2	4.85	48	48	0.34
1.1/2"	40	48.3	5.08	57	57	0.48
2"	50	60.3	5.54	76	76	0.89
2.1/2"	65	73.0	7.01	95	95	1.70
3"	80	88.9	7.62	114	114	2.74
3.1/2"	90	101.6	8.08	133	133	3.89
4"	100	114.3	8.56	152	152	5.33
5"	125	141.3	9.53	190	190	9.24
6"	150	168.3	10.97	229	229	15.3
8"	200	219.1	12.70	305	305	31.0
10"	250	273.0	15.09	381	381	57.4
12"	300	323.8	17.48	457	457	94.8
14"	350	355.6	19.05	533	533	132.4
16"	400	406.4	21.44	610	610	195.0
18"	450	457.0	23.83	686	686	274.3

A = centre to end. R = bend radius (1.5 x NPS). OD and wall to ASME B36.10M SCH 80; fitting dimensions to ASME B16.9. Weights are calculated estimates and not certified. Dimensions and weights are nominal and are given for guidance only. Certified drawings for the supplied make and size are issued on request.

ORDERING INFORMATION

FIELD	OPTIONS
Product code	SW-0284
Size	1/2", 3/4", 1", 1.1/4", 1.1/2", 2", 2.1/2", 3", 3.1/2", 4", 5", 6", 8", 10", 12", 14", 16", 18"
Schedule	SCH 80. Other schedules available under separate codes
Material	ASTM A234 WPB. MTC to EN 10204 3.1 on request
Order example	**SW-0284 / 4" / SCH 80 / A234 WPB / BW**

Stock held in Dubai for fast despatch across the UAE and GCC. Contact our sales desk for pricing, availability, project quantities and certification requirements.

PRESSURE AND TEMPERATURE

Pressure rating	**Equal to SCH 80 seamless pipe of the same material**
Basis	**ASME B16.9 rating clause**
Allowable stress	**138 MPa at -29°C to +38°C (ASME B31.3)**
Minimum temperature	**-29°C (ASME B31.3, curve B)**
Maximum temperature	**+425°C for prolonged service**

Design pressure is calculated by the piping designer from the governing code (ASME B31.1, B31.3, B31.4 or B31.8) using the wall thickness, corrosion allowance and design temperature. Impact testing may be required near the minimum temperature on thicker walls. Confirm duty with SWBM before use outside these limits.

TYPICAL APPLICATIONS

- Process and utility pipeline routing
- Oil and gas, petrochemical and refinery piping
- Chemical processing lines
- Water treatment and supply networks
- Heat exchanger and reactor connections
- Steam, condensate and cooling water lines

COMPLIANCE AND QUALITY

- Material to ASTM A234 / ASME SA234 Grade WPB
- Dimensions and tolerances to ASME B16.9
- Wall thickness to ASME B36.10M SCH 80
- Weld end bevel to ASME B16.25
- Marking to MSS SP-25
- Heat treatment as required by ASTM A234
- Material test certificate EN 10204 3.1 on request

INSTALLATION AND OPERATION

- Clean the bevel and 25 mm either side to bright metal, removing varnish, oil and rust
- Check bevel and root face for damage, re-dress to ASME B16.25 if required
- Align bores and set a root gap of 1.6 to 3.2 mm with even tack welds
- Weld with procedures and welders qualified to ASME Section IX
- Apply preheat and post weld heat treatment where the piping code requires it
- Carry out NDE and pressure testing to the governing piping code

COMPANY

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