MS BUTT-WELD ELBOW 45° LONG RADIUS SCH STD

45° Long Radius Butt-Weld Elbow · Carbon Steel ASTM A234 WPB · ASME B16.9

BRAND: SW FLOW CONTROLS | SKU: SW-0291 | SIZE 12" TO 24" | SCH STD



FIG. 1 | MS BUTT-WELD ELBOW 45° LONG RADIUS SCH STD

PRODUCT OVERVIEW

The SWBM MS Butt-Weld 45° Long Radius Elbow gives a 45° change in flow direction with a bend radius of 1.5 times the nominal size, for a gentler transition than a 90° elbow. It is produced from carbon steel to ASTM A234 Grade WPB with a SCH STD wall, dimensioned to ASME B16.9, and is intended for standard weight service on larger bore lines.

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 STD 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	**45° LR elbow, butt-weld**
Material	**Carbon steel, ASTM A234 WPB**
Dimensional standard	**ASME B16.9**
Wall thickness	**SCH STD, ASME B36.10M**
End connection	**Bevelled butt-weld, ASME B16.25**
Size range	**12" to 24" (DN300 to DN600)**

TECHNICAL SPECIFICATION

Material specification	**ASTM A234 / ASME SA234 WPB**	Carbon	**0.30% max**
Dimensional standard	**ASME B16.9**	Manganese	**0.29% to 1.06%**
Wall schedule	**SCH STD to ASME B36.10M**	Tensile strength	**415 to 585 MPa**
End preparation	**Bevel to ASME B16.25**	Yield strength	**240 MPa min**
Bevel angle	**37.5° ±2.5°**	Pressure rating	**Equal to SCH STD seamless pipe**
Geometry	**Long radius, R = 1.5 x NPS**	Surface finish	**Black varnish, rust preventive**

FEATURES AND MATERIALS

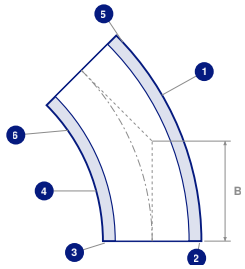


FIG. 2 | SECTION THROUGH ELBOW

#	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 STD 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.

DIMENSIONS AND WEIGHTS

SIZE	DN	OD (MM)	WALL (MM)	B (MM)	R (MM)	WEIGHT (KG)
12"	300	323.8	9.53	190	457	26.5
14"	350	355.6	9.53	222	533	34.0
16"	400	406.4	9.53	254	610	44.7
18"	450	457.0	9.53	286	686	56.7
20"	500	508.0	9.53	318	762	70.1
24"	600	610.0	9.53	381	914	101.3

B = centre to end. R = bend radius (1.5 x NPS). OD and wall to ASME B36.10M SCH STD; 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-0291
Size	12", 14", 16", 18", 20", 24"
Schedule	SCH STD. Other schedules available under separate codes
Material	ASTM A234 WPB. MTC to EN 10204 3.1 on request
Order example	**SW-0291 / 18" / SCH STD / 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 STD 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.

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 STD
- 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

TYPICAL APPLICATIONS

- Offsets and gradual direction changes
- Oil and gas, petrochemical and refinery piping
- Chemical processing lines
- Water treatment and supply networks
- Heat exchanger and reactor connections
- Lines where low pressure drop is required

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

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