MS BUTT-WELD ELBOW 180° LONG RADIUS SCH 40

180° Long Radius Butt-Weld Return · Carbon Steel ASTM A234 WPB · ASME B16.9

BRAND: SW FLOW CONTROLS | SKU: SW-0298 | SIZE 1/2" TO 6" | SCH 40



FIG. 1 | MS BUTT-WELD ELBOW 180° LONG RADIUS SCH 40

PRODUCT OVERVIEW

The SWBM MS Butt-Weld 180° Long Radius Return reverses flow direction so a line can double back in a compact space, as in heat exchanger, furnace and coil circuits. It is produced from carbon steel to ASTM A234 Grade WPB with a SCH 40 wall, dimensioned to ASME B16.9, and is intended for standard pressure process and utility 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 40 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	**180° LR return, butt-weld**
Material	**Carbon steel, ASTM A234 WPB**
Dimensional standard	**ASME B16.9**
Wall thickness	**SCH 40, ASME B36.10M**
End connection	**Bevelled butt-weld, ASME B16.25**
Size range	**1/2" to 6" (DN15 to DN150)**

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 40 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 40 seamless pipe**
Geometry	**Long radius, R = 1.5 x NPS**	Surface finish	**Black varnish, rust preventive**

FEATURES AND MATERIALS

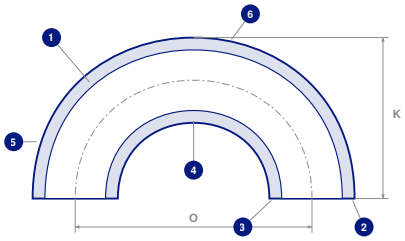


FIG. 2 | SECTION THROUGH RETURN

#	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 40 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)	O (MM)	K (MM)	WEIGHT (KG)
1/2"	15	21.3	2.77	76	48	0.15
3/4"	20	26.7	2.87	76	51	0.20
1"	25	33.4	3.38	76	56	0.30
1.1/4"	32	42.2	3.56	95	70	0.51
1.1/2"	40	48.3	3.68	114	83	0.73
2"	50	60.3	3.91	152	106	1.30
2.1/2"	65	73.0	5.16	190	132	2.58
3"	80	88.9	5.49	229	159	4.04
3.1/2"	90	101.6	5.74	267	184	5.67
4"	100	114.3	6.02	305	210	7.68
5"	125	141.3	6.55	381	262	13.0
6"	150	168.3	7.11	457	313	20.3

O = centre to centre, K = back to face. OD and wall to ASME B36.10M SCH 40; 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-0298
Size	1/2", 3/4", 1", 1.1/4", 1.1/2", 2", 2.1/2", 3", 3.1/2", 4", 5", 6"
Schedule	SCH 40. Other schedules available under separate codes
Material	ASTM A234 WPB. MTC to EN 10204 3.1 on request
Order example	**SW-0298 / 4" / SCH 40 / 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 40 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 40
- 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

- Heat exchanger and coil circuits
- Furnace and heater tube passes
- Oil and gas and refinery piping
- Chemical processing lines
- Cooling and heating loops
- Compact pipeline doubling back

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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