MS BUTT-WELD EQUAL TEE SCH STD

Butt-Weld Equal Tee · Carbon Steel ASTM A234 WPB · ASME B16.9

BRAND: SW FLOW CONTROLS | SKU: SW-0305 | SIZE 12" TO 24" | SCH STD



FIG. 1 | MS BUTT-WELD EQUAL TEE SCH STD

PRODUCT OVERVIEW

The SWBM MS Butt-Weld Equal Tee takes a 90° branch from a pipeline with the run and branch at the same nominal size, to split or combine flow. 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	**Equal tee, 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	**Equal tee, run and branch same size**	Surface finish	**Black varnish, rust preventive**

FEATURES AND MATERIALS

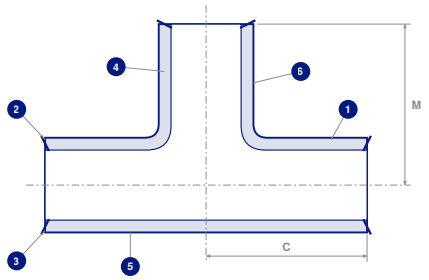


FIG. 2 | SECTION THROUGH TEE

#	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)	C RUN (MM)	M OUTLET (MM)	WEIGHT (KG)
12"	300	323.8	9.53	254	254	44.3
14"	350	355.6	9.53	279	279	53.6
16"	400	406.4	9.53	305	305	66.4
18"	450	457.0	9.53	343	343	84.2
20"	500	508.0	9.53	381	381	104.1
24"	600	610.0	9.53	432	432	139.9

C = centre to end of run, M = centre to end of outlet. 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-0305
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-0305 / 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.

TYPICAL APPLICATIONS

- Branch connections on process and utility lines
- Headers and manifolds
- Oil and gas, petrochemical and refinery piping
- Chemical processing lines
- Water treatment and supply networks
- Fire water and cooling water distribution

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

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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