MS BUTT-WELD REDUCING TEE SCH 80

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

BRAND: SW FLOW CONTROLS | SKU: SW-0307 | SIZE 1/2" TO 12" | SCH 80



FIG. 1 | MS BUTT-WELD REDUCING TEE SCH 80

PRODUCT OVERVIEW

The SWBM MS Butt-Weld Reducing Tee takes a 90° branch from a pipeline with the branch one or more sizes smaller than the run, removing the need for a separate reducer. 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	**Reducing tee, 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 12" (DN15 to DN300)**

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	**Reducing outlet, branch smaller than run**

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

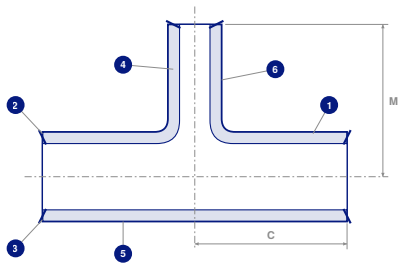


FIG. 2 | SECTION THROUGH TEE

#	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 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.

DIMENSIONS AND WEIGHTS

SIZE	DN	OD (MM)	WALL (MM)	C RUN (MM)	OUTLET OPTIONS, M (MM)	WEIGHT (KG)
1/2"	15	21.3	3.73	25	Confirm	Confirm
3/4"	20	26.7	3.91	29	1/2" (29)	0.15
1"	25	33.4	4.55	38	3/4" (38), 1/2" (38)	0.29
1.1/4"	32	42.2	4.85	48	1" (48), 3/4" (48), 1/2" (48)	0.52
1.1/2"	40	48.3	5.08	57	1.1/4" (57), 1" (57), 3/4" (57), 1/2" (57)	0.76
2"	50	60.3	5.54	64	1.1/2" (60), 1.1/4" (57), 1" (51), 3/4" (44)	1.12
2.1/2"	65	73.0	7.01	76	2" (70), 1.1/2" (67), 1.1/4" (64), 1" (57)	1.98
3"	80	88.9	7.62	86	2.1/2" (83), 2" (76), 1.1/2" (73), 1.1/4" (70)	3.07
3.1/2"	90	101.6	8.08	95	3" (92), 2.1/2" (89), 2" (83), 1.1/2" (79)	4.17
4"	100	114.3	8.56	105	3.1/2" (102), 3" (98), 2.1/2" (95), 2" (89), 1.1/2" (86)	5.52
5"	125	141.3	9.53	124	4" (117), 3.1/2" (114), 3" (111), 2.1/2" (108), 2" (105)	8.71
6"	150	168.3	10.97	143	5" (137), 4" (130), 3.1/2" (127), 3" (124), 2.1/2" (121)	13.8
8"	200	219.1	12.70	178	6" (168), 5" (162), 4" (156), 3.1/2" (152)	25.5
10"	250	273.0	15.09	216	8" (203), 6" (194), 5" (191), 4" (184)	45.8
12"	300	323.8	17.48	254	10" (241), 8" (229), 6" (219), 5" (216)	74.7

Size, OD and wall refer to the run. C = centre to end of run, M = centre to end of outlet, shown in brackets for each outlet size. Weight is for the largest outlet listed. 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. 1/2" run reducing tees are outside the ASME B16.9 table, dimensions confirmed on enquiry.

ORDERING INFORMATION

FIELD	OPTIONS
Product code	SW-0307
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" (run x branch)
Schedule	SCH 80. Other schedules available under separate codes
Material	ASTM A234 WPB. MTC to EN 10204 3.1 on request
Order example	**SW-0307 / 4" x 2" / 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.

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

TYPICAL APPLICATIONS

- Smaller branch take-offs on process lines
- Headers and manifolds
- Instrument and drain connections on larger lines
- Oil and gas, petrochemical and refinery piping
- Water treatment and supply networks
- Fire water and cooling water distribution

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

Sunel Wala Building Materials
Trading Co. LLC (SWBM)
Dubai, United Arab Emirates

SALES ENQUIRIES

info@swbm-fittings.com
Tel: +971 4 238 5652
Mobile / WhatsApp: +971 50 748 1772

ONLINE

www.swbm-fittings.com
Brand: SW Flow Controls

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