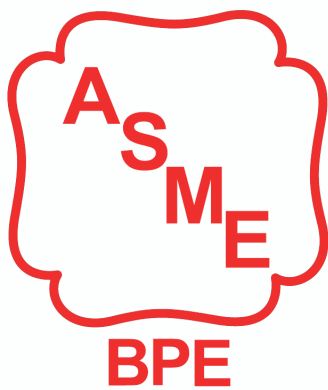


ASME BPE TUBES & FITTINGS



316L
AL-6XN
C-22



Aseptconn is a leading component supplier for the sterile liquid technology used in the pharmaceutical and biopharmaceutical industries. Our innovative products in combination with our years of pharma experience, and resultant expert guidance, enhance the productivity and safety of our customers' manufacturing processes in a sustainable way.

A benefit of our extensive experience is a stock and certification management system that guarantees short delivery with complete, correct, and traceable certification documentation for each order. In addition, our wide range of products allows our customers to obtain all components from a single source.

Aseptconn Team:

Created in 2016, Aseptconn is made up of a team with many years of experience in consulting and sales of components for sterile process technology. We are a customer centric organization focused on innovation, responsiveness and complete order satisfaction. These values provide the foundation of our business conduct.

Aseptconn is ISO 9001: 2015 Certified.



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ASME BPE PRESENTATION



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ASME BPE Specifications

The ASME BPE aids in the design and fabrications of equipment used in pharma and biotech fields, by developing and maintaining a consensus standard with some requirements for systems and components.

Since 1988, throughout the development and the different editions of this standard, the chapters of this document define and simplify the specifications of equipment, particularly for tubes, fittings and valves.

MATERIALS ACCORDING TO PART MM - METALLIC MATERIALS

Grades	UNS	EN	% C	% Mn	% Cr	% Ni	% Mo	PRE
Austenitic Stainless Steel								
304L	S30403	1.4307	0.030	2.00	17.50-19.50	8.00-10.50	-	19
316L (*)	S31603	1.4404	0.030	2.00	16.50-18.50	10.00-14.50	2.00-2.50	23
316L	S31603	1.4435	0.030	2.00	17.50-19.00	12.50-15.00	2.50-3.00	26
Superaustenitic Stainless Steel								
904L	N08904	1.4539	0.020	2.00	19.00-23.00	23.00-28.00	4.00-5.00	34
254SMO	S31254	1.4547	0.020	1.00	19.50-20.50	17.50-18.50	6.00-6.50	42
AL6XN	N08367	1.4529	0.020	1.00	19.00-21.00	24.00-26.00	6.00-7.00	43
Nickel Alloys								
C276	N10276	2.4819	0.010	1.00	14.50-16.50	57.00	15.0-17.0	45
C22	N06022	2.4602	0.015	0.50	20.00-22.50	56.00	12.50-14.50	46

(*) According to MM-2.1-1, with a defined sulphur content between 0,005 and 0,017 %, to achieve repeatability for automatic orbital welding process.

Hardness < 90 HRB.

Non-russian origin of the steel products certification according to EU 833/2014 regulation.

DIMENSIONS ACCORDING TO PART DT - DIMENSIONS & TOLERANCES

Nominal Sizes	OD (mm)	Thickness (mm)
1/4"	6.35	0.89
3/8"	9.53	0.89
1/2"	12.70	1.65
3/4"	19.05	1.65
1"	25.40	1.65
1 1/2"	38.10	1.65
2"	50.80	1.65
2 1/2"	63.50	1.65
3"	76.20	1.65
4"	101.60	2.11
6"	152.40	2.77

with reference to table DT-4-1.

ASME BPE Specifications

TOLERANCES

All these tolerances are defined in chapter DT-7 with reference to tables DT-3-1, DT-3-2 & DT-7.1-1 for fittings, and ASTM A269 & A270-S2 for tubes.

TOLERANCES FOR FITTINGS

Nominal Size	OD (mm)	W.T.MP (mm)	W.T. EP (mm)	Squareness (mm)	Off Angle	Equiv. Angle (mm)	Off Plane (mm)	Centerline Radius (mm)
1/4"	+/- 0.13	+0.08/-0.10	+0.08/-0.15	0.13	0.23	2.1°	0.76	14.30
3/8"	+/- 0.13	+0.08/-0.10	+0.08/-0.15	0.13	0.30	1.8°	0.76	28.58
1/2"	+/- 0.13	+0.13/-0.20	+0.13/-0.25	0.13	0.36	1.6°	0.76	28.58
3/4"	+/- 0.13	+0.13/-0.20	+0.13/-0.25	0.13	0.46	1.4°	0.76	28.58
1"	+/- 0.13	+0.13/-0.20	+0.13/-0.25	0.13	0.64	1.4°	0.76	38.10
1"1/2"	+/- 0.20	+0.13/-0.20	+0.13/-0.25	0.20	0.86	1.3°	1.27	57.15
2"	+/- 0.20	+0.13/-0.20	+0.13/-0.25	0.20	1.09	1.2°	1.27	76.20
2"1/2"	+/- 0.25	+0.13/-0.20	+0.13/-0.25	0.25	1.37	1.2°	1.27	95.25
3"	+/- 0.25	+0.13/-0.20	+0.13/-0.25	0.41	1.73	1.3°	1.27	114.30
4"	+/- 0.38	+0.20/-0.25	+0.20/-0.30	0.41	2.18	1.2°	1.52	152.40
6"	+/- 0.76	+0.38/-0.38	+0.38/-0.43	0.76	3.43	1.3°	1.52	228.60

TOLERANCES FOR TUBES

Nominal Size	Outside Diameter (mm)	Wall Thickness (mm)	Cut Length (mm)
1/4" - 3/8"	+/- 0.13	+/- 0.15 %	3.20
1/2" TO 1"	+/- 0.13	+/- 0.10 %	3.20
1" 1/2 TO 3"	+/- 0.25	+/- 0.10 %	4.80
4"	+/- 0.38	+/- 0.10 %	4.80
6"	+/- 0.76	+/- 0.10 %	4.80

ASME BPE Specifications

SURFACES FINISHES

Process contact surfaces shall be finished using mechanical or electropolishing, in reference to the following table SF-2.4.1-1 defining Ra max:

SURFACES FINISHES ACCORDING TO PART SF - SURFACE FINISHES FOR MULTI-USE

Mechanically Polished			Electropolished		
Surface Designation	µin	µm	Surface Designation	µin	µm
SF1	20	0.51	SF4	15	0.38
SF2	25	0.64	SF5	20	0.51
SF3	30	0.76	SF6	25	0.64

Ra reading must be in accordance with ASME B46.1.

A multiple step cycle process is conducted to ensure surfaces quality with consistent repeatability:

- Degreasing
- Pickling
- Passivation
- De-ionized water cleaning

INSPECTION PROCEDURES

- Raw material validation
- 100% PMI checking
- 100% Visual inspection
- Endoscopic inspection (not applicable for EP products)
- Dimensions & Tolerances control
- Roughness measurement

MARKING

Each process components is permanently laser marked to maintain traceability:

- ASEPTCONN AG & manufacturer logo
- ASME mark with BPE designator
- Material type
- Dimension
- Process contacts surface designation SF
- Heat number

ASME BPE Specifications

PACKAGING & LABELLING

Weld ends prepared for orbital welding

Each process components is individually delivered with PE caps, sealed in PE foil and with a label in compliance with the following policy:

- Aseptconn logo
- ASME BPE stamp
- Product description
- Standard reference DT-X.X.X-X
- Material type
- Dimension
- Process contacts surface designation SF
- Heat number
- Aseptconn code

DELIVERY

- Cardboard box for fittings
- Wooden crates or tubular containers for tubes

DOCUMENTATION

Full material test and inspection reports according to DIN EN 10204-3.1 are supplied with the finished products and available in digital format.

All the references to ASME BPE standard are linked with and referred to the 2022 revision , issued the 29th of April 2022.



ASME BPE DT INDEX



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ASME BPE

DT Index

DT- 4.1.1 – ELBOWS & BENDS

DT-4.1.1-1 (ex DT-7)



90° Elbow - Ends BW x BW

DT-4.1.1-2 (ex DT-12)



90° Elbow - Ends BW x TC

DT-4.1.1-3 (ex DT-16)



90° Elbow - Ends TC x TC

DT-4.1.1-4 (ex DT-8)



45° Elbow - Ends BW x BW

DT-4.1.1-5 (ex DT-13)



45° Elbow - Ends BW x TC

DT-4.1.1-6 (ex DT-17)



45° Elbow - Ends TC x TC

DT-4.1.1-7 (ex DT-23)



180° Return Bend - Ends
BW x BW

DT-4.1.1-8 (ex DT-24)



180° Return Bend - Ends
TC x TC

DT-4.1.1-9



88° Elbow - Ends BW x BW

DT-4.1.1-10



92° Elbow - Ends BW x BW



ASME BPE

DT Index

DT- 4.1.2 – TEES & CROSSES

DT-4.1.2-1 (ex DT-9)



Straight Equal Tee / Cross -
Ends BW

DT-4.1.2-2 (ex DT-15)



Short Outlet Tee - Ends
BW/TC

DT-4.1.2-3 (ex DT-25)



Short Outlet Run Tee - Ends
BW/TC

DT-4.1.2-4 (ex DT-18)



Straight Equal Tee / Cross -
Ends TC

DT-4.1.2-5 (ex DT-27)



Short Outlet Tee - Ends TC

DT-4.1.2-6 (ex DT-10)



Reducing Tee - Ends BW

DT-4.1.2-7 (ex DT-14)



Short Outlet Reducing Tee -
Ends BW/TC



ASME BPE

DT Index

DT- 4.1.2 – TEES & CROSSES

DT-4.1.2-8 (ex DT-19)



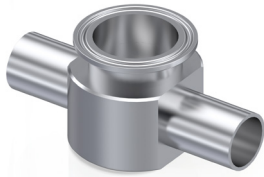
Reducing Tee - Ends TC

DT-4.1.2-9 (ex DT-20)



Short Outlet Reducing Tee - Ends TC

DT-4.1.2-10 (ex DT-28)



Instrument Tee - Ends BW/TC

DT-4.1.2-11 (ex DT-29)



Instrument Tee - Ends TC

DT-4.1.2-12

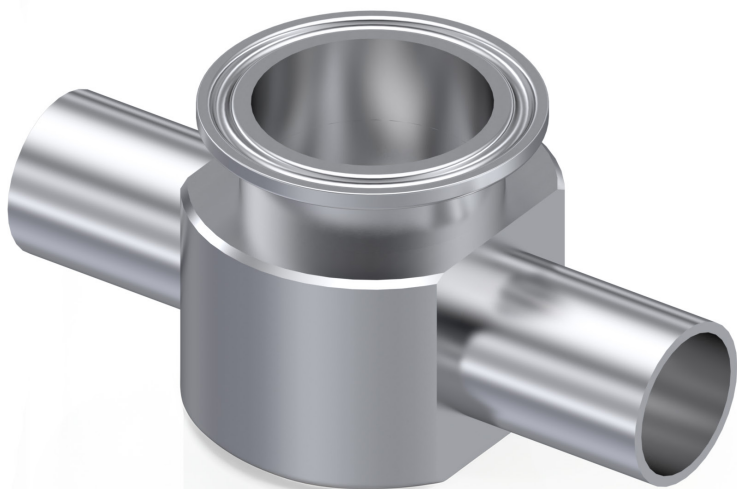


Standard Outlet Tee - Ends BW/TC

DT-4.1.2-13



Standard Outlet Reducing Tee - Ends BW/TC

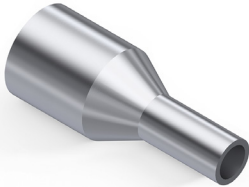


ASME BPE

DT Index

DT- 4.1.3 - REDUCERS

DT-4.1.3-1 (ex DT-11)



Short Concentric / Eccentric
Reducer Ends BW x BW

DT-4.1.3-2 (ex DT-26)



Short Concentric / Eccentric
Reducer Ends BW x TC

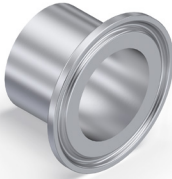
DT-4.1.3-3 (ex DT-21)



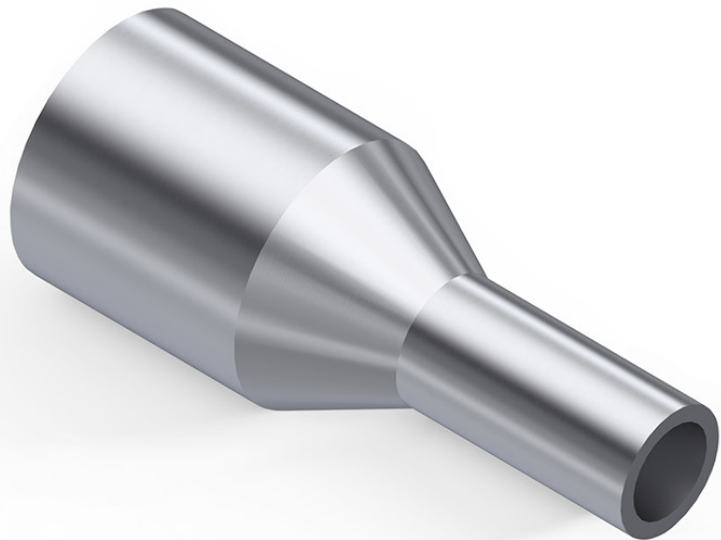
Short Concentric / Eccentric
Reducer Ends TC x TC

DT - 4.1.4 - FERRULES

DT-4.1.4-1 (ex DT-22)



Ferrule A/Long - B/Medium
C/Short - Ends BW x TC



DT - 4.1.5 - CAPS

DT-4.1.5-1 (ex DT-30)



Weld Cap - Ends BW

DT-4.1.5-2 (ex DT-31)



Solid End Cap - Ends BW

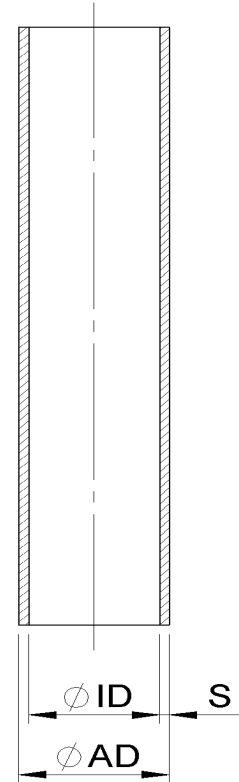
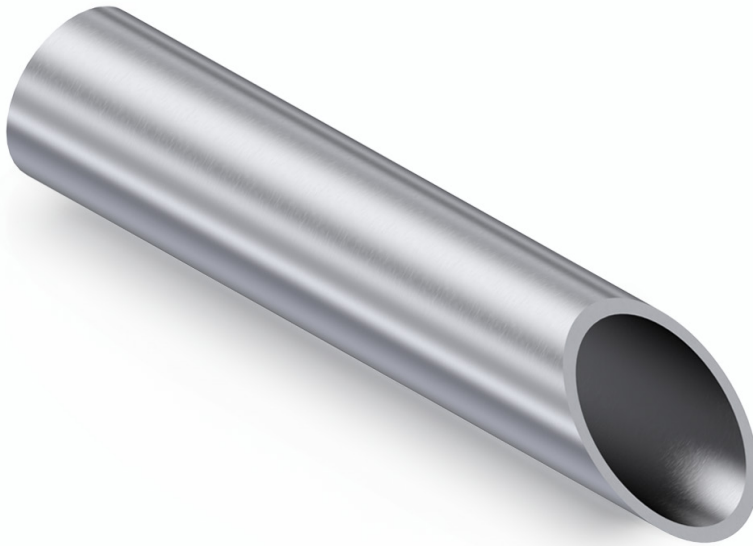


ASME BPE DT NUMBERS



Welding Accessories

DT-4.1 TUBES



TECHNICAL SPECIFICATIONS TUBES DT-4.1

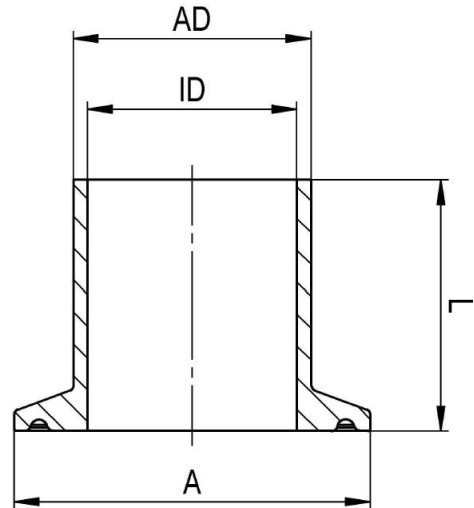
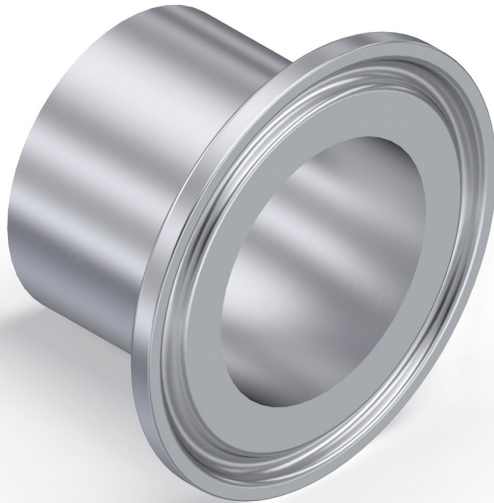
Nominal Size	AD (mm)	ID (mm)	S (mm)	Part Numbers
1/4"	6.35	4.57	0.89	130.A-025.WEL.XX.XXX
3/8"	9.53	7.75	0.89	130.A-0375.WEL.XX.XXX
1/2"	12.70	9.40	1.65	130.A-050.WEL.XX.XXX
3/4"	19.05	15.75	1.65	130.A-075.WEL.XX.XXX
1"	25.40	22.10	1.65	130.A-100.WEL.XX.XXX
1 1/2"	38.10	34.80	1.65	130.A-150.WEL.XX.XXX
2"	50.80	47.50	1.65	130.A-200.WEL.XX.XXX
2 1/2"	63.50	60.20	1.65	130.A-250.WEL.XX.XXX
3"	76.20	72.90	1.65	130.A-300.WEL.XX.XXX
4"	101.60	97.38	2.11	130.A-400.WEL.XX.XXX
6"	152.40	146.86	2.77	130.A-600.WEL.XX.XXX

.XX.XXX = .MB.SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XX.XXX = .EP.SF4 - Electropolished SF4 - Ra max < 0.38 µm

Tri-Clamp Connections

DT-4.1.4-1 (ex DT-22) TRI-CLAMP FERRULES



TECHNICAL SPECIFICATIONS TRI-CLAMPS DT-4.1.4-1 - B SERIES (STANDARD VERSION)

Nominal Size	AD (mm)	ID (mm)	A (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	25.00	28.58	102.A-025.025.XXX
3/8"	9.53	7.75	25.00	28.58	102.A-038.025.XXX
1/2"	12.70	9.40	25.00	28.58	102.A-050-025.XXX
3/4"	19.05	15.75	25.00	28.58	102.A-075-025.XXX
1"	25.40	22.10	50.50	28.58	102.A-100-050.XXX
1 1/2"	38.10	34.80	50.50	28.58	102.A-150.050.XXX
2"	50.80	47.50	64.00	28.58	102.A-200.064.XXX
2 1/2"	63.50	60.20	77.50	28.58	102.A-250.077.XXX
3"	76.20	72.90	91.00	28.58	102.A-300.091.XXX
4"	101.60	97.38	119.00	28.58	102.A-400.119.XXX
6"	152.40	146.86	167.00	38.10	102.A-600.167.XXX

.XXX = .SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XXX = .SF4 - Electropolished SF4 - Ra max < 0.38 µm

Tri-Clamp Connections

DT-4.1.4-1 (ex DT-22) TRI-CLAMP FERRULES

TECHNICAL SPECIFICATIONS TRI-CLAMPS DT-4.1.4-1 - C SERIES (SHORT VERSION)

Nominal Size	AD (mm)	ID (mm)	A (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	25.00	12.70	102S.A-025.025.XXX
3/8"	9.53	7.75	25.00	12.70	102S.A-038.025.XXX
1/2"	12.70	9.40	25.00	12.70	102S.A-050-025.XXX
3/4"	19.05	15.75	25.00	12.70	102S.A-075-025.XXX
1"	25.40	22.10	50.50	12.70	102S.A-100-050.XXX
1"1/2	38.10	34.80	50.50	12.70	102S.A-150.050.XXX
2"	50.80	47.50	64.00	12.70	102S.A-200.064.XXX
2"1/2	63.50	60.20	77.50	12.70	102S.A-250.077.XXX
3"	76.20	72.90	91.00	12.70	102S.A-300.091.XXX
4"	101.60	97.38	119.00	15.88	102S.A-400.119.XXX
6"	152.40	146.86	167.00	19.05	102S.A-600.167.XXX

.XXX = .SF1 - Mechanical polished SF1 - Ra max < 0.51 µm
 .XXX = .SF4 - Electropolished SF4 - Ra max < 0.38 µm

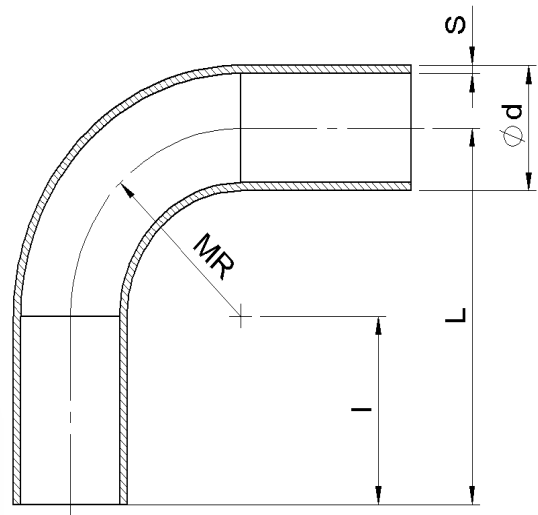
TECHNICAL SPECIFICATIONS TRI-CLAMPS DT-4.1.4-1 - A SERIES (LONG VERSION)

Nominal Size	AD (mm)	ID (mm)	A (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	25.00	44.45	102L.A-025.025.XXX
3/8"	9.53	7.75	25.00	44.45	102L.A-038.025.XXX
1/2"	12.70	9.40	25.00	44.45	102L.A-050-025.XXX
3/4"	19.05	15.75	25.00	44.45	102L.A-075-025.XXX
1"	25.40	22.10	50.50	44.45	102L.A-100-050.XXX
1"1/2	38.10	34.80	50.50	44.45	102L.A-150.050.XXX
2"	50.80	47.50	64.00	57.15	102L.A-200.064.XXX
2"1/2	63.50	60.20	77.50	57.15	102L.A-250.077.XXX
3"	76.20	72.90	91.00	57.15	102L.A-300.091.XXX
4"	101.60	97.38	119.00	57.15	102L.A-400.119.XXX
6"	152.40	146.86	167.00	76.20	102L.A-600.167.XXX

.XXX = .SF1 - Mechanical polished SF1 - Ra max < 0.51 µm
 .XXX = .SF4 - Electropolished SF4 - Ra max < 0.38 µm

Welding Accessories

DT-4.1.1-1 (ex DT-7) 90° ELBOWS



TECHNICAL SPECIFICATIONS 90° ELBOWS DT-4.1.1-1

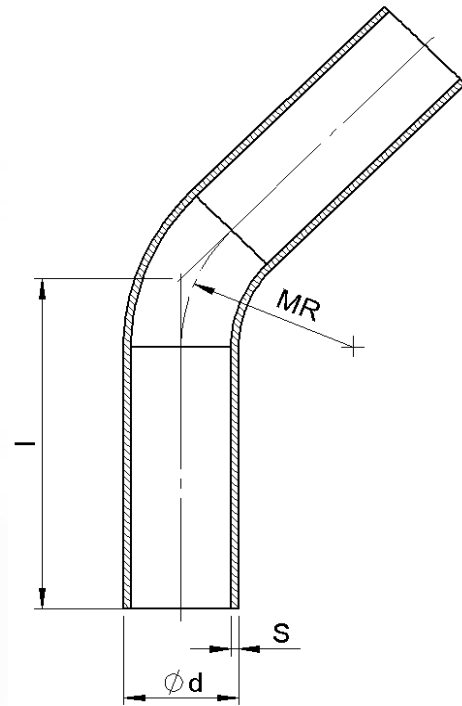
Nominal Size	AD (mm)	ID (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	66.68	116.090.A-025.WEL.XX.XXX
3/8"	9.53	7.75	66.68	116.090.A-0375.WEL.XX.XXX
1/2"	12.70	9.40	76.20	116.090.A-050.WEL.XX.XXX
3/4"	19.05	15.75	76.20	116.090.A-075.WEL.XX.XXX
1"	25.40	22.10	76.20	116.090.A-100.WEL.XX.XXX
1 1/2"	38.10	34.80	95.25	116.090.A-150.WEL.XX.XXX
2"	50.80	47.50	120.65	116.090.A-200.WEL.XX.XXX
2 1/2"	63.50	60.20	139.70	116.090.A-250.WEL.XX.XXX
3"	76.20	72.90	158.75	116.090.A-300.WEL.XX.XXX
4"	101.60	97.38	203.20	116.090.A-400.WEL.XX.XXX
6"	152.40	146.86	292.10	116.090.A-600.WEL.XX.XXX

.XX.XXX = .MB.SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XX.XXX = .EP.SF4 - Electropolished SF4 - Ra max < 0.38 µm

Welding Accessories

DT-4.1.1-4 (ex DT-8) 45° ELBOWS



TECHNICAL SPECIFICATIONS 45° ELBOWS DT-4.1.1-4

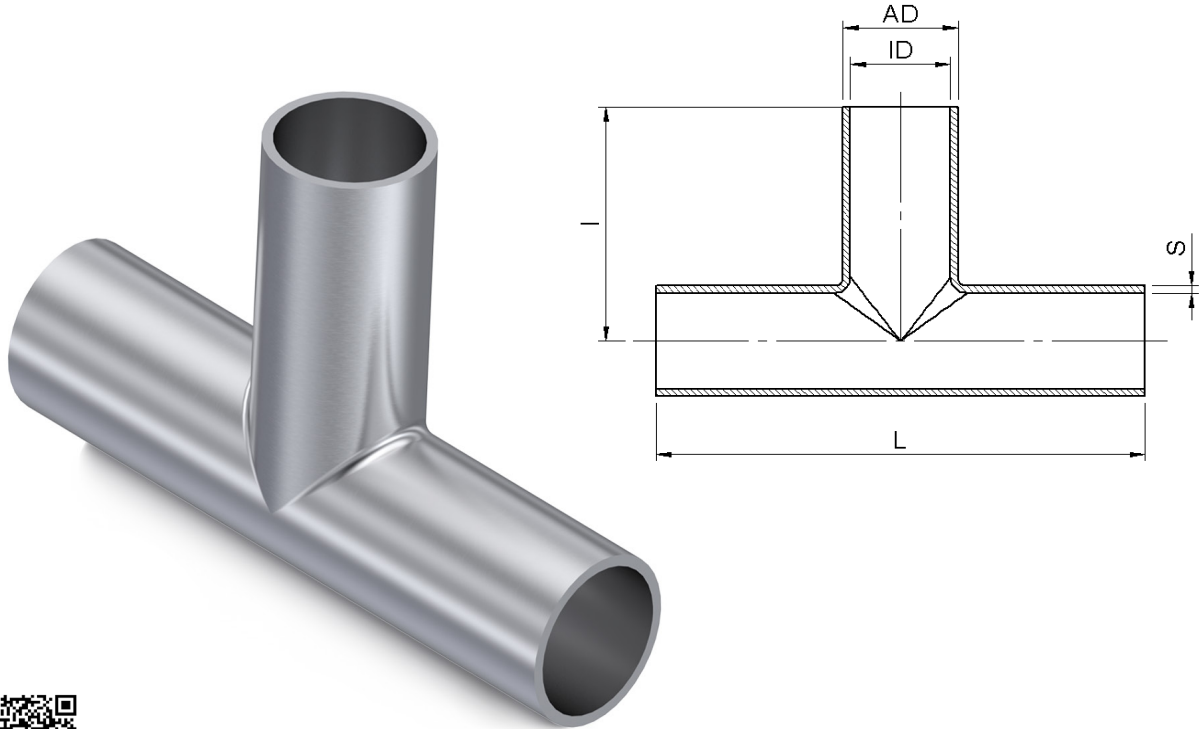
Nominal Size	AD (mm)	ID (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	50.80	116.045.A-025.WEL.XX.XXX
3/8"	9.53	7.75	50.80	116.045.A-0375.WEL.XX.XXX
1/2"	12.70	9.40	57.15	116.045.A-050.WEL.XX.XXX
3/4"	19.05	15.75	57.15	116.045.A-075.WEL.XX.XXX
1"	25.40	22.10	57.15	116.045.A-100.WEL.XX.XXX
1 1/2"	38.10	34.80	63.50	116.045.A-150.WEL.XX.XXX
2"	50.80	47.50	76.20	116.045.A-200.WEL.XX.XXX
2 1/2"	63.50	60.20	85.73	116.045.A-250.WEL.XX.XXX
3"	76.20	72.90	92.08	116.045.A-300.WEL.XX.XXX
4"	101.60	97.38	114.30	116.045.A-400.WEL.XX.XXX
6"	152.40	146.86	158.75	116.045.A-600.WEL.XX.XXX

.XX.XXX = .MB.SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XX.XXX = .EP.SF4 - Electropolished SF4 - Ra max < 0.38 µm

Welding Accessories

DT-4.1.2-1 (ex DT-9) EQUAL TEES



TECHNICAL SPECIFICATIONS EQUAL TEES DT-4.1.2-1

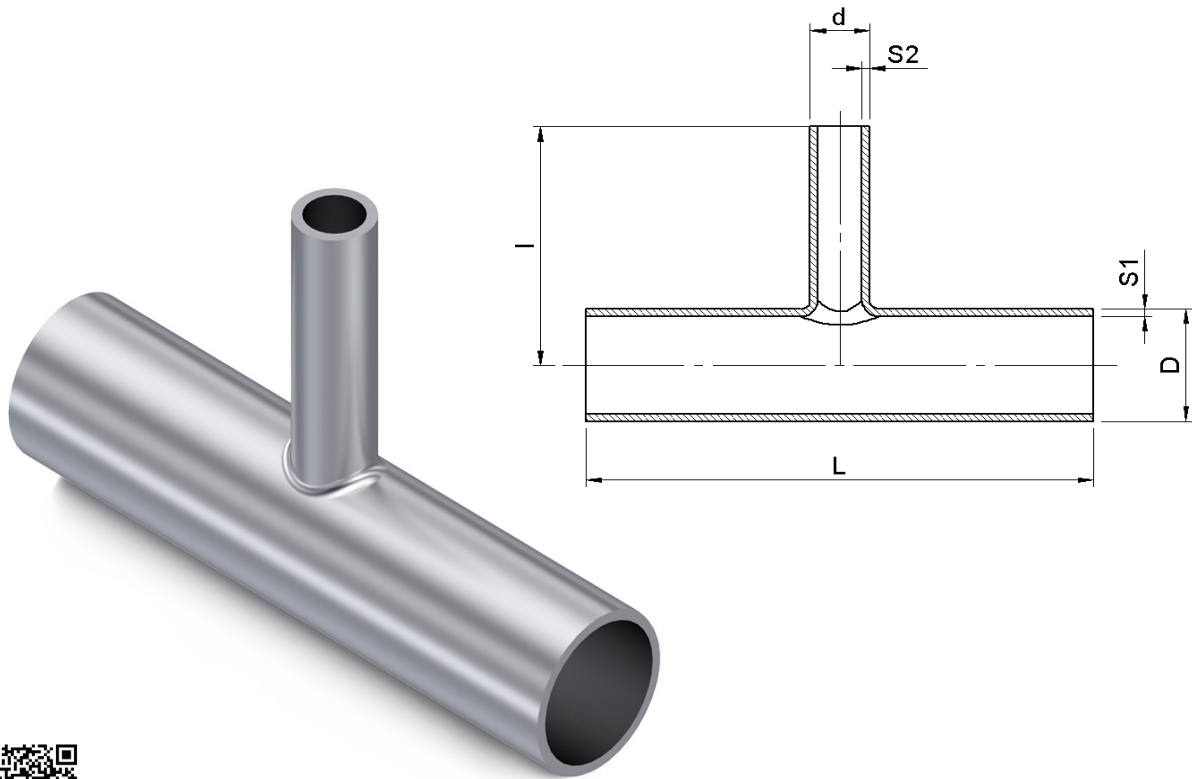
Nominal Size	AD (mm)	ID (mm)	L/2 (mm)	Part Numbers
1/4"	6.35	4.57	44.45	115.E.A-025.WEL.XX.XXX
3/8"	9.53	7.75	44.45	115.E.A-0375.WEL.XX.XXX
1/2"	12.70	9.40	47.63	115.E.A-050.WEL.XX.XXX
3/4"	19.05	15.75	50.80	115.E.A-075.WEL.XX.XXX
1"	25.40	22.10	53.98	115.E.A-100.WEL.XX.XXX
1 1/2"	38.10	34.80	60.33	115.E.A-150.WEL.XX.XXX
2"	50.80	47.50	73.03	115.E.A-200.WEL.XX.XXX
2 1/2"	63.50	60.20	79.38	115.E.A-250.WEL.XX.XXX
3"	76.20	72.90	85.73	115.E.A-300.WEL.XX.XXX
4"	101.60	97.38	104.78	115.E.A-400.WEL.XX.XXX
6"	152.40	146.86	142.88	115.E.A-600.WEL.XX.XXX

.XX.XXX = .MB.SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XX.XXX = .EP.SF4 - Electropolished SF4 - Ra max < 0.38 µm

Welding Accessories

DT-4.1.2-6 (ex DT-10) REDUCING TEES



TECHNICAL SPECIFICATIONS REDUCING TEES DT-4.1.2-6

Dimensions	D (mm)	d (mm)	L/2 (mm)	l (mm)	Part Numbers
3/8" x 1/4"	9.53	6.35	44.45	44.45	115.R.A-0375.A-025.WEL.XX.XXX
1/2" x 1/4"	12.70	6.35	47.63	47.63	115.R.A-050.A-025.WEL.XX.XXX
1/2" x 3/8"	12.70	9.53	47.63	47.63	115.R.A-050.A-0375.WEL.XX.XXX
3/4" x 1/4"	19.05	6.35	50.80	50.80	115.R.A-075.A-025.WEL.XX.XXX
3/4" x 3/8"	19.05	9.53	50.80	50.80	115.R.A-075.A-0375.WEL.XX.XXX
3/4" x 1/2"	19.05	12.70	50.80	50.80	115.R.A-075.A-050.WEL.XX.XXX
1" x 1/4"	25.40	6.35	53.98	53.98	115.R.A-100.A-025.WEL.XX.XXX
1" x 3/8"	25.40	9.53	53.98	53.98	115.R.A-100.A-0375.WEL.XX.XXX
1" x 1/2"	25.40	12.70	53.98	53.98	115.R.A-100.A-050.WEL.XX.XXX
1" x 3/4"	25.40	19.05	53.98	53.98	115.R.A-100.A-075.WEL.XX.XXX
1 1/2" x 1/2"	38.10	12.70	60.33	60.33	115.R.A-150.A-050.WEL.XX.XXX

.XX.XXX = .MB.SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XX.XXX = .EP.SF4 - Electropolished SF4 - Ra max < 0.38 µm

Welding Accessories

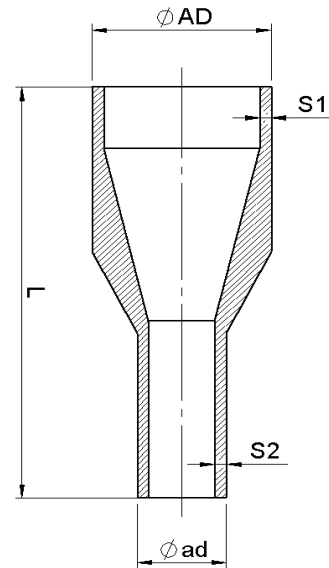
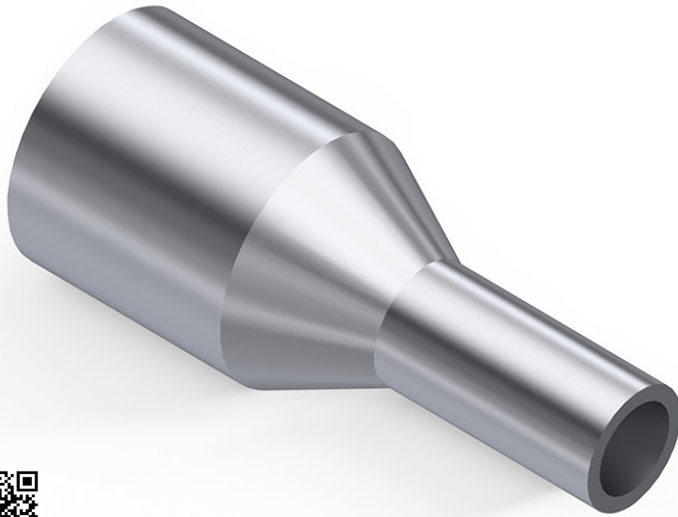
DT-4.1.2-6 (ex DT-10) REDUCING TEES

Dimensions	D (mm)	d (mm)	L/2 (mm)	l (mm)	Part Numbers
1"1/2 x 3/4"	38.10	19.05	60.33	60.33	115.R.A-150.A-075.WEL.XX.XXX
1"1/2 x 1"	38.10	25.40	60.33	60.33	115.R.A-150.A-100.WEL.XX.XXX
2" x 1/2"	50.80	12.70	73.03	66.68	115.R.A-200.A-050.WEL.XX.XXX
2" x 3/4"	50.80	19.05	73.03	66.68	115.R.A-200.A-075.WEL.XX.XXX
2" x 1"	50.80	25.40	73.03	66.68	115.R.A-200.A-100.WEL.XX.XXX
2" x 1"1/2	50.80	38.10	73.03	66.68	115.R.A-200.A-150.WEL.XX.XXX
2"1/2 x 1/2"	63.50	12.70	79.38	73.03	115.R.A-250.A-050.WEL.XX.XXX
2"1/2 x 3/4"	63.50	19.05	79.38	73.03	115.R.A-250.A-075.WEL.XX.XXX
2"1/2 x 1"	63.50	25.40	79.38	73.03	115.R.A-250.A-100.WEL.XX.XXX
2"1/2 x 1"1/2	63.50	38.10	79.38	73.03	115.R.A-250.A-150.WEL.XX.XXX
2"1/2 x 2"	63.50	50.80	79.38	73.03	115.R.A-250.A-200.WEL.XX.XXX
3" x 1/2"	76.20	12.70	79.38	73.03	115.R.A-300.A-050.WEL.XX.XXX
3" x 3/4"	76.20	19.05	79.38	73.03	115.R.A-300.A-075.WEL.XX.XXX
3" x 1"	76.20	25.40	79.38	73.03	115.R.A-300.A-100.WEL.XX.XXX
3" x 1"1/2	76.20	38.10	79.38	73.03	115.R.A-300.A-150.WEL.XX.XXX
3" x 2"	76.20	50.80	79.38	73.03	115.R.A-300.A-200.WEL.XX.XXX
3" x 2"1/2	76.20	63.50	79.38	73.03	115.R.A-300.A-250.WEL.XX.XXX
4" x 1/2"	101.60	12.70	104.78	92.08	115.R.A-400.A-050.WEL.XX.XXX
4" x 3/4"	101.60	19.05	104.78	92.08	115.R.A-400.A-075.WEL.XX.XXX
4" x 1"	101.60	25.40	104.78	92.08	115.R.A-400.A-100.WEL.XX.XXX
4" x 1"1/2	101.60	38.10	104.78	92.08	115.R.A-400.A-150.WEL.XX.XXX
4" x 2"	101.60	50.80	104.78	98.43	115.R.A-400.A-200.WEL.XX.XXX
4" x 2"1/2	101.60	63.50	104.78	98.43	115.R.A-400.A-250.WEL.XX.XXX
4" x 3"	101.60	76.20	104.78	98.43	115.R.A-400.A-300.WEL.XX.XXX
6" x 1/2"	152.40	12.70	142.88	117.48	115.R.A-600.A-050.WEL.XX.XXX
6" x 3/4"	152.40	19.05	142.88	117.48	115.R.A-600.A-075.WEL.XX.XXX
6" x 1"	152.40	25.40	142.88	117.48	115.R.A-600.A-100.WEL.XX.XXX
6" x 1"1/2	152.40	38.10	142.88	117.48	115.R.A-600.A-150.WEL.XX.XXX
6" x 2"	152.40	50.80	142.88	123.83	115.R.A-600.A-200.WEL.XX.XXX
6" x 2"1/2	152.40	63.50	142.88	123.83	115.R.A-600.A-250.WEL.XX.XXX
6" x 3"	152.40	76.20	142.88	123.83	115.R.A-600.A-300.WEL.XX.XXX
6" x 4"	152.40	101.60	142.88	130.18	115.R.A-600.A-400.WEL.XX.XXX

.XX.XXX = .MB.SF1 - Mechanical polished SF1 - Ra max < 0.51 µm
 .XX.XXX = .EP.SF4 - Electropolished SF4 - Ra max < 0.38 µm

Welding Accessories

DT-4.1.3-1 (ex DT-11) CONCENTRIC REDUCERS



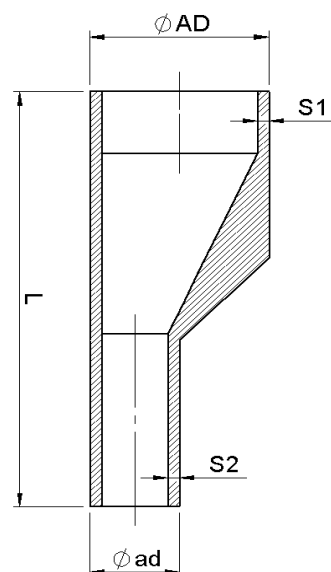
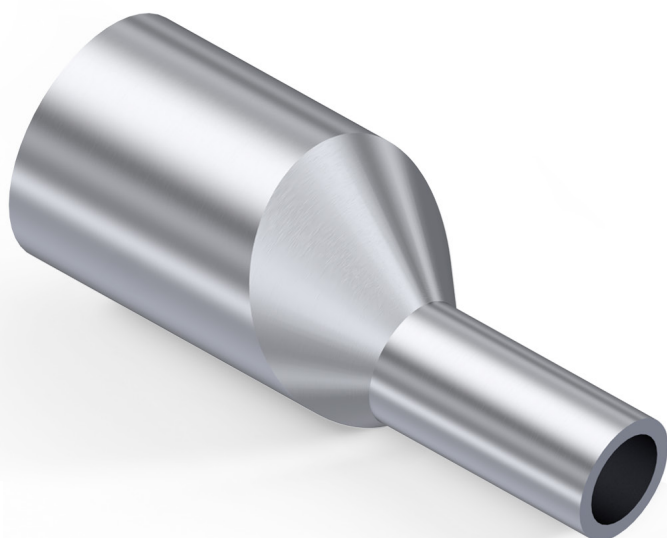
TECHNICAL SPECIFICATIONS CONCENTRIC REDUCERS DT-4.1.3-1

Nominal Size	AD (mm)	ad (mm)	L (mm)	Part Numbers
3/8" x 1/4"	9.53	6.35	41.28	108.BWE.A-0375.A-025.BWE.XX.XXX
1/2" x 1/4"	12.70	6.35	47.63	108.BWE.A-050.A-025.BWE.XX.XXX
1/2" x 3/8"	12.70	9.53	47.63	108.BWE.A-050.A-0375.BWE.XX.XXX
3/4" x 3/8"	19.05	9.53	50.80	108.BWE.A-075.A-0375.BWE.XX.XXX
3/4" x 1/2"	19.05	12.70	53.98	108.BWE.A-075.A-050.BWE.XX.XXX
1" x 1/2"	25.40	12.70	63.50	108.BWE.A-100.A-050.BWE.XX.XXX
1" x 3/4"	25.40	19.05	53.98	108.BWE.A-100.A-075.BWE.XX.XXX
1"1/2 x 3/4"	38.10	19.05	76.20	108.BWE.A-150.A-075.BWE.XX.XXX
1"1/2 x 1"	38.10	25.40	63.50	108.BWE.A-150.A-100.BWE.XX.XXX
2" x 1"	50.80	25.40	85.73	108.BWE.A-200.A-100.BWE.XX.XXX
2" x 1"1/2"	50.80	38.10	63.50	108.BWE.A-200.A-150.BWE.XX.XXX
2"1/2 x 1"1/2"	63.50	38.10	85.73	108.BWE.A-250.A-150.BWE.XX.XXX
2"1/2 x 2"	63.50	50.80	63.50	108.BWE.A-250.A-200.BWE.XX.XXX
3" x 1"1/2"	76.20	38.10	107.95	108.BWE.A-300.A-150.BWE.XX.XXX
3" x 2"	76.20	50.80	85.73	108.BWE.A-300.A-200.BWE.XX.XXX
3" x 2"1/2"	76.20	63.50	66.68	108.BWE.A-300.A-250.BWE.XX.XXX
4" x 2"	101.60	50.80	130.18	108.BWE.A-400.A-200.BWE.XX.XXX
4" x 2"1/2"	101.60	63.50	107.95	108.BWE.A-400.A-250.BWE.XX.XXX
4" x 3"	101.60	76.20	98.43	108.BWE.A-400.A-300.BWE.XX.XXX
6" x 3"	152.40	76.20	184.15	108.BWE.A-600.A-300.BWE.XX.XXX
6" x 4"	152.40	101.60	142.88	108.BWE.A-600.A-400.BWE.XX.XXX

.XX.XXX = .MB.SF1 - Mechanical polished SF1 - Ra max < 0.51 μm
 .XX.XXX = .EP.SF4 - Electropolished SF4 - Ra max < 0.38 μm

Welding Accessories

DT-4.1.3-1 (ex DT-11) ECCENTRIC REDUCERS



TECHNICAL SPECIFICATIONS ECCENTRIC REDUCERS DT-4.1.3-1

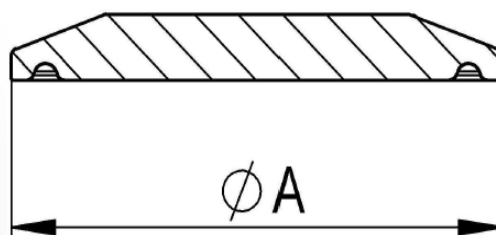
Nominal Size	AD (mm)	ad (mm)	L (mm)	part Numbers
3/8" x 1/4"	9.53	6.35	41.28	109.BWE.A-0375.A-025.BWE.XX.XXX
1/2" x 1/4"	12.70	6.35	47.63	109.BWE.A-050.A-025.BWE.XX.XXX
1/2" x 3/8"	12.70	9.53	47.63	109.BWE.A-050.A-0375.BWE.XX.XXX
3/4" x 3/8"	19.05	9.53	50.80	109.BWE.A-075.A-0375.BWE.XX.XXX
3/4" x 1/2"	19.05	12.70	53.98	109.BWE.A-075.A-050.BWE.XX.XXX
1" x 1/2"	25.40	12.70	63.50	109.BWE.A-100.A-050.BWE.XX.XXX
1" x 3/4"	25.40	19.05	53.98	109.BWE.A-100.A-075.BWE.XX.XXX
1"1/2 x 3/4"	38.10	19.05	76.20	109.BWE.A-150.A-075.BWE.XX.XXX
1"1/2 x 1"	38.10	25.40	63.50	109.BWE.A-150.A-100.BWE.XX.XXX
2" x 1"	50.80	25.40	85.73	109.BWE.A-200.A-100.BWE.XX.XXX
2" x 1"1/2"	50.80	38.10	63.50	109.BWE.A-200.A-150.BWE.XX.XXX
2"1/2 x 1"1/2"	63.50	38.10	85.73	109.BWE.A-250.A-150.BWE.XX.XXX
2"1/2 x 2"	63.50	50.80	63.50	109.BWE.A-250.A-200.BWE.XX.XXX
3" x 1"1/2"	76.20	38.10	107.95	109.BWE.A-300.A-150.BWE.XX.XXX
3" x 2"	76.20	50.80	85.73	109.BWE.A-300.A-200.BWE.XX.XXX
3" x 2"1/2"	76.20	63.50	66.68	109.BWE.A-300.A-250.BWE.XX.XXX
4" x 2"	101.60	50.80	130.18	109.BWE.A-400.A-200.BWE.XX.XXX
4" x 2"1/2"	101.60	63.50	107.95	109.BWE.A-400.A-250.BWE.XX.XXX
4" x 3"	101.60	76.20	98.43	109.BWE.A-400.A-300.BWE.XX.XXX
6" x 3"	152.40	76.20	184.15	109.BWE.A-600.A-300.BWE.XX.XXX
6" x 4"	152.40	101.60	142.88	109.BWE.A-600.A-400.BWE.XX.XXX

.XX.XXX = .MB.SF1 - Mechanical polished SF1 - Ra max < 0.51 μm

.XX.XXX = .EP.SF4 - Electropolished SF4 - Ra max < 0.38 μm

Tri-Clamp Connections

DT-4.1.5-2 (ex DT-31) TRI-CLAMP CAPS



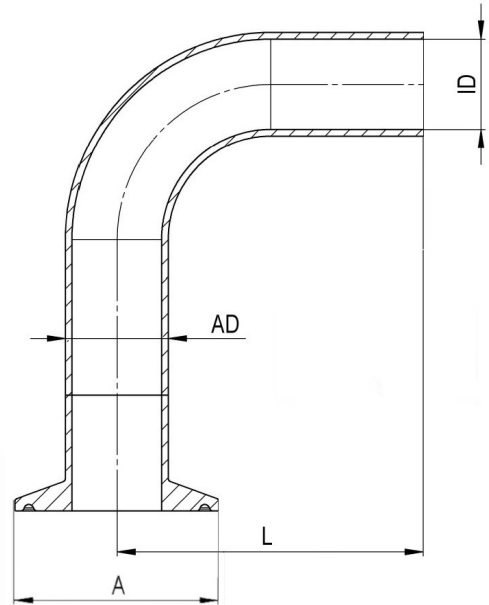
TECHNICAL SPECIFICATIONS TRI-CLAMP CAPS DT-4.1.5-2

Nominal Size	A (mm)	Part Numbers
1/4"	25.00	104.000.025.XXX
3/8"	25.00	104.000.025.XXX
1/2"	25.00	104.000.025.XXX
3/4"	25.00	104.000.025.XXX
1"	50.50	104.000.050.XXX
1 1/2"	50.50	104.000.050.XXX
2"	64.00	104.000.064.XXX
2 1/2"	77.50	104.000.077.XXX
3"	91.00	104.000.091.XXX
4"	119.00	104.000.119.XXX
6"	167.00	104.000.167.XXX

.XXX = .SF1 - Mechanical polished SF1 - Ra max < 0.51 μm
.XXX = .SF4 - Electropolished SF4 - Ra max < 0.38 μm

Tri-Clamp Accessories

DT-4.1.1-2 (ex DT-12) 90° ELBOWS BW X TC



TECHNICAL SPECIFICATIONS 90° ELBOWS BW x TC DT-4.1.1-2

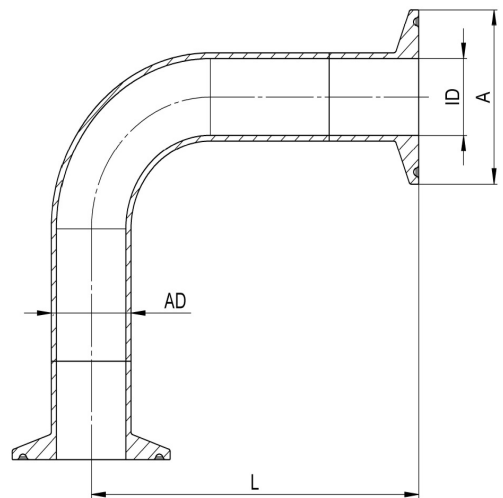
Nominal Size	AD (mm)	ID (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	66.68	116.090.A-025.TCBW.XXX
3/8"	9.53	7.75	66.68	116.090.A-0375.TCBW.XXX
1/2"	12.70	9.40	76.20	116.090.A-050.TCBW.XXX
3/4"	19.05	15.75	76.20	116.090.A-075.TCBW.XXX
1"	25.40	22.10	76.20	116.090.A-100.TCBW.XXX
1 1/2"	38.10	34.80	95.25	116.090.A-150.TCBW.XXX
2"	50.80	47.50	120.65	116.090.A-200.TCBW.XXX
2 1/2"	63.50	60.20	139.70	116.090.A-250.TCBW.XXX
3"	76.20	72.90	158.75	116.090.A-300.TCBW.XXX
4"	101.60	97.38	203.20	116.090.A-400.TCBW.XXX
6"	152.40	146.86	292.10	116.090.A-600.TCBW.XXX

.XXX = .SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XXX = .SF4 - Electropolished SF4 - Ra max < 0.38 µm

Tri-Clamp Accessories

DT-4.1.1-3 (ex DT-16) 90° ELBOWS TC X TC



TECHNICAL SPECIFICATIONS 90° ELBOW TC x TC DT-4.1.1-3

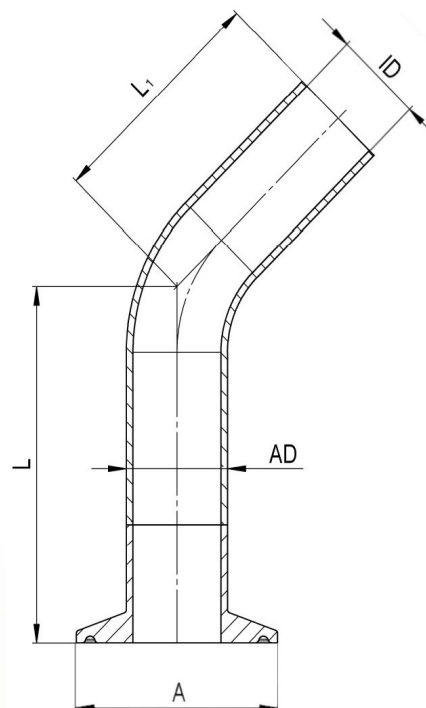
Nominal Size	AD (mm)	ID (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	41.28	123.090.A-025.025.BPE.XXX
3/8"	9.53	7.75	41.28	123.090.A-037.025.BPE.XXX
1/2"	12.70	9.40	41.28	123.090.A-050.025.BPE.XXX
3/4"	19.05	15.75	41.28	123.090.A-075.025.BPE.XXX
1"	25.40	22.10	50.80	123.090.A-100.050.BPE.XXX
1 1/2"	38.10	34.80	69.85	123.090.A-150.050.BPE.XXX
2"	50.80	47.50	88.90	123.090.A-200.064.BPE.XXX
2 1/2"	63.50	60.20	107.95	123.090.A-250.077.BPE.XXX
3"	76.20	72.90	127.00	123.090.A-300.091.BPE.XXX
4"	101.60	97.38	168.28	123.090.A-400.119.BPE.XXX
6"	152.40	146.86	266.70	123.090.A-600.167.BPE.XXX

.XXX = .SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XXX = .SF4 - Electropolished SF4 - Ra max < 0.38 µm

Tri-Clamp Accessories

DT-4.1.1-5 (ex DT-13) 45° ELBOWS BW X TC



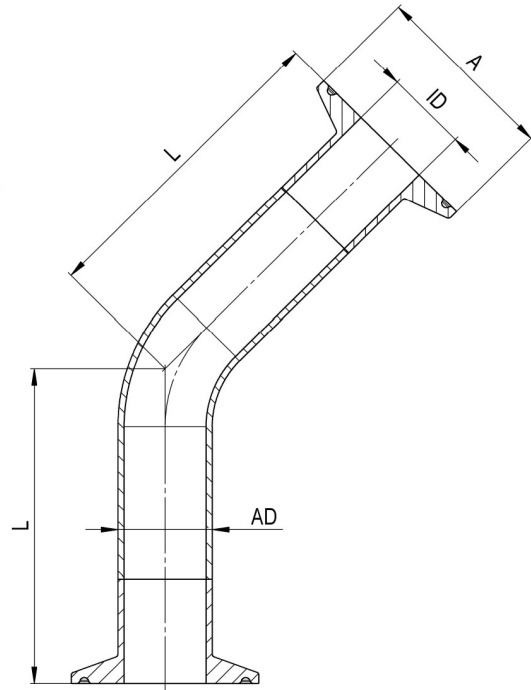
TECHNICAL SPECIFICATIONS 45° ELBOW BW x TC DT-4.1.1-5

Nominal Size	AD (mm)	ID (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	50.80	116.045.A-025.TCBW.XXX
3/8"	9.53	7.75	50.80	116.045.A-0375.TCBW.XXX
1/2"	12.70	9.40	57.15	116.045.A-050.TCBW.XXX
3/4"	19.05	15.75	57.15	116.045.A-075.TCBW.XXX
1"	25.40	22.10	57.15	116.045.A-100.TCBW.XXX
1"1/2	38.10	34.80	63.50	116.045.A-150.TCBW.XXX
2"	50.80	47.50	76.20	116.045.A-200.TCBW.XXX
2"1/2	63.50	60.20	85.73	116.045.A-250.TCBW.XXX
3"	76.20	72.90	92.08	116.045.A-300.TCBW.XXX
4"	101.60	97.38	114.30	116.045.A-400.TCBW.XXX
6"	152.40	146.86	158.75	116.045.A-600.TCBW.XXX

.XXX = .SF1 - Mechanical polished SF1 - Ra max < 0.51 µm
 .XXX = .SF4 - Electropolished SF4 - Ra max < 0.38 µm

Tri-Clamp Accessories

DT-4.1.1-6 (ex DT-17) 45° ELBOWS TC X TC



TECHNICAL SPECIFICATIONS 45° ELBOW TC x TC DT-4.1.1-6

Nominal Size	AD (mm)	ID (mm)	L (mm)	Part Numbers
1/4"	6.35	4.57	25.40	123.45.A-025.XXX
3/8"	9.53	7.75	25.40	123.45.A-0375.XXX
1/2"	12.70	9.40	25.40	123.45.A-050.XXX
3/4"	19.05	15.75	25.40	123.45.A-075.XXX
1"	25.40	22.10	28.58	123.45.A-100.XXX
1 1/2"	38.10	34.80	36.53	123.45.A-150.XXX
2"	50.80	47.50	44.45	123.45.A-200.XXX
2 1/2"	63.50	60.20	52.40	123.45.A-250.XXX
3"	76.20	72.90	60.33	123.45.A-300.XXX
4"	101.60	97.38	79.38	123.45.A-400.XXX
6"	152.40	146.86	133.35	123.45.A-600.XXX

.XXX = .SF1 - Mechanical polished SF1 - Ra max < 0.51 µm

.XXX = .SF4 - Electropolished SF4 - Ra max < 0.38 µm

ASME BPE C-22 WELD INSERTS

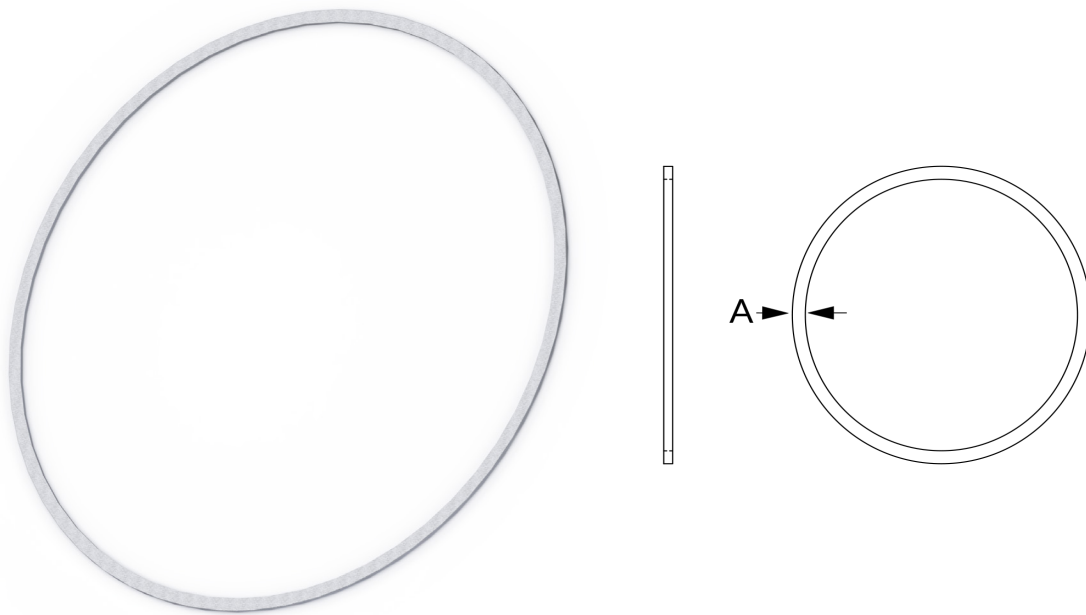


ASME BPE

C-22 Weld Inserts

C-22 weld insert rings are used for additional alloying when orbital or manual welding AL-6XN.

For most AL-6XN piping systems, the process of post-weld annealing is not feasible. In order to improve corrosion resistance of these welds, the practice of adding an alloy filler is required. The ring must have a higher molybdenum content than the AL-6XN alloy to compensate for alloys dilution on cooling.



TECHNICAL SPECIFICATIONS C-22 WELD INSERTS

Nominal Size	AD (mm)	ID (mm)	Thickness (mm)
1/2"	12.70	9.40	1.65
3/4"	19.05	15.75	1.65
1"	25.40	22.10	1.65
1" 1/2	38.10	34.80	1.65
2"	50.80	47.50	1.65
2" 1/2	63.50	60.20	1.65
3"	76.20	72.90	1.65
4"	101.60	97.38	2.11



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