

Gate, Globe & Check Valves



ASME Class 150 to 4500 | ½" to 42" (15 mm to 1050 mm)
ASME B16.34



L&T Valves

L&T Valves is a world-leader in flow-control solutions. Backed by a 50-year heritage of excellence, L&T Valves manufactures and markets a wide variety of industrial valves that find application in key sectors of the economy such as oil & gas and power.

Product Range:

- Gate, Globe & Check Valves
- Valves for Power
- Pipeline & Process Ball Valves
- Triple-offset Butterfly Valves
- Flanged & Wafer-type Butterfly Valves
- Plug Valves
- Control Valves
- Customised Solutions

Designs for the valves are created by an experienced team of valve experts who have a deep understanding of user-industry processes. An extensive manufacturing and quality assurance infrastructure ensure that world-class designs are transformed into high performance products. Every phase of manufacture is governed by an institutionalised environment, health and safety policy.

L&T Valves distribution network spans the globe, partnering some of the largest valve distribution companies in the world. In India, L&T Valves has a presence in every industrial centre through a network of offices, stockists, automation centres and service franchisees.



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Gate, Globe & Check Valves

L&T Valves manufactures a comprehensive range of Gate, Globe & Check Valves (GGC) in sizes up to 42" (1050 mm) and in ASME classes from 150 to 4500. The valves are offered in combination of size, pressure class, material, end-connection, etc., to suit myriad applications in power and hydrocarbon sectors.

Pressure-seal Range

Valve Type	ASME Class	2	3	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42
		50	80	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	900	950	1000	1050
Gate Valves	600											•	•	•	•	•	•	•	•	•	•	•	•
	900		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•						
	1500		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	2500		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	3100		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	3500		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	4100		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
Globe Valves	900		•	•	•	•	•	•	•	•													
	1500		•	•	•	•	•	•	•	•													
	2500		•	•	•	•	•	•	•	•	•												
	3100		•	•	•	•	•	•	•														
	3500		•	•	•	•	•	•	•														
	4100		•	•	•	•	•	•															
Check Valves	600											•	•	•	•	•	•	•	•	•	•	•	•
	900		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	1500		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	2500		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	3100		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	3500		•	•	•	•	•	•	•	•	•	•	•	•	•	•							
	4100		•	•	•	•	•	•	•	•	•	•	•	•	•	•							

Bolted-bonnet Range

Valve Type	ASME Class	2	3	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42
		50	80	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	900	950	1000	1050
Gate Valves	150	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
	300	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
	600	•	•	•	•	•	•	•	•	•	•												
Globe Valves	150	•	•	•	•	•	•	•	•	•	•												
	300	•	•	•	•	•	•	•	•	•	•												
	600	•	•	•	•	•	•	•	•	•	•												
Check Valves	150	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
	300	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
	600	•	•	•	•	•	•	•	•	•	•												

Forged Steel Range

Type	ASME Class	½	¾	1	1¼	1½	2	2½	3	4	6
		15	20	25	32	40	50	65	80	100	150
Globe & Check Valves	1500	•	•	•	•	•	•	•	•	•	•
	2500	•	•	•	•	•	•	•	•	•	•
	4500	•	•	•	•	•	•				

Compliance Standards

L&T Gate, Globe & Check Valves are designed in accordance with key international standards. They also meet the requirements of major power and oil & gas industry standards and customer specifications.

Parameter		Standard	
Design	Gate Valves	ASME B16.34	API 600
	Globe Valves		BS 1873
	Check Valves		BS 1868
Ends	Face-to-face/ End-to-end Dimensions	ASME B16.10	
	End Flange Dimensions	ASME B16.5	
	Butt-weld End Dimensions	ASME B16.25	
	Forged Fittings, Socket welding & Threading Dimensions	ASME B16.11	
Testing		MSS SP-61 or API 598	



Materials of Construction

The product portfolio encompasses valves in carbon steel, stainless steels and alloy steels, in cast and forged materials, in a number of trim options - suitable for line-fluids ranging from low temperature hydrocarbon to super-critical steam.

Material Classification	Body Materials	
	Cast Steel	Forged Steel
Carbon Steel	ASTM A 216 Gr. WCB/ WCC	ASTM A 105
1¼ Cr - ½ Mo	ASTM A 217 Gr. WC6	ASTM A 182 Gr. F11 Cl. 2
2¼ Cr - 1 Mo	ASTM A 217 Gr. WC9	ASTM A 182 Gr. F22 Cl. 3
5 Cr - ½ Mo	ASTM A 217 Gr. C5	ASTM A 182 Gr. F5a
9 Cr - 1 Mo	ASTM A 217 Gr. C12	ASTM A 182 Gr. F9
9 Cr - 1 Mo - ¼ V	ASTM A 217 Gr. C12A	ASTM A 182 Gr. F91
Low-temperature Steel	ASTM A 352 Gr. LCB/ LCC	ASTM A 350 Gr. LF2
Austenitic Stainless Steel 18-8 (Type 304)	ASTM A 351 Gr. CF8	ASTM A 182 Gr. F304
Austenitic Stainless Steel 16 Cr - 12 Ni - 2 Mo (Type 316)	ASTM A 351 Gr. CF8M	ASTM A 182 Gr. F316

*Valves in other materials available on demand

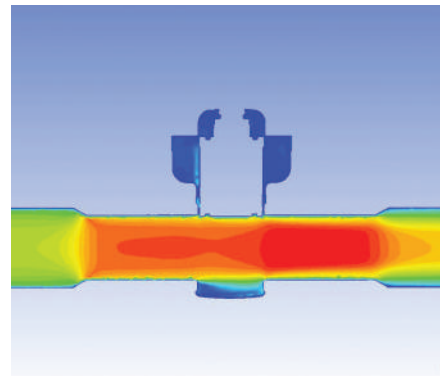
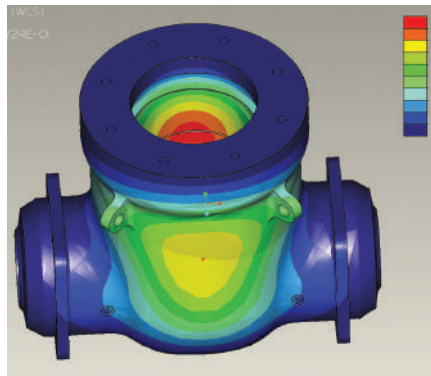
Trim Materials

API 600 Trim	Materials			
	Stem	Seat Surface	Disc Surface	Back Seat
1	13% Cr	13% Cr	13% Cr	13% Cr
2	SS 316	SS 304	SS 304	SS 316
5	13% Cr	HF	HF	13% Cr
8	13% Cr	HF	13% Cr	13% Cr
9	Monel	Monel	Monel	Monel
10	SS 316	SS 316	SS 316	SS 316
12	SS 316	HF	SS 316	SS 316
16	SS 316	HF	HF	SS 316

*Other trim combinations available on demand

Designs for L&T Gate, Globe & Check Valves are created in a 3D environment using the latest design and analysis software. Finite Element Analysis (FEA) and Computational Flow Dynamics (CFD) are extensively used to fine-tune product designs.

R&D




In-house Qualification Test Facilities:

- High temperature gas test
- Endurance & Cycle tests
- Seismic qualification tests
- Pipe-end load test
- Vacuum test
- Fugitive emission test

L&T Valves design team brings with them a deep understanding of user industry practices. This has aided development of valves in intermediate pressure classes such as 3100, 3500 and 4100 as well as specialized flow-control devices for the power industry.

At L&T Valves facility in Coimbatore, two pressure-seal gate valves (20 inch class 3100 Special WCC and 6 inch class 3100 C12A) were subjected to High Temperature High Pressure Gas Test under simulated super-critical power plant operating conditions.

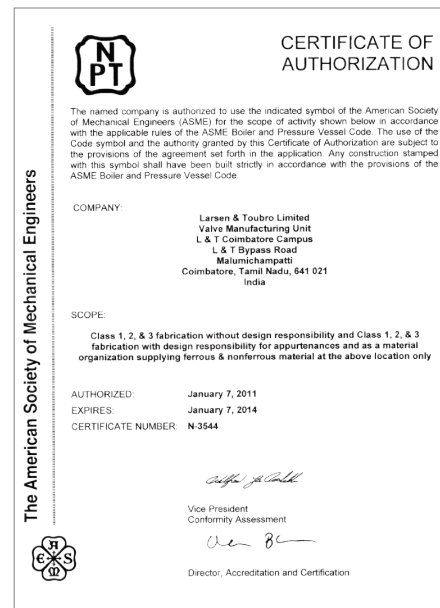
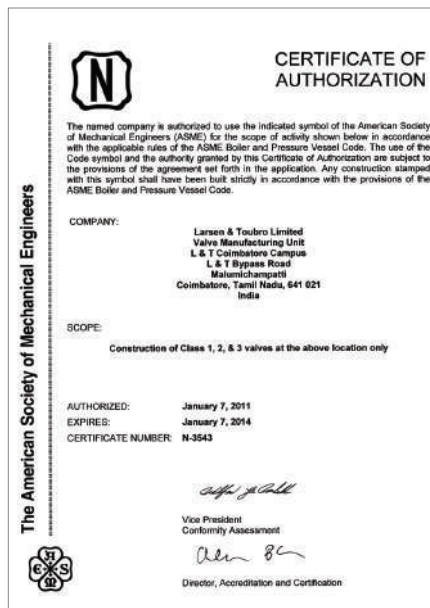
The valves were cycled at high temperature and pressure and the integrity of the pressure boundary as well as seat integrity was successfully established at ambient condition, at elevated temperature and pressure, and at re-ambient condition.

High Pressure and High Temperature Gas Test	
20" Class 3100 Special Carbon Steel Gate Valve (Prototype)	
Customer: M/s Larsen & Toubro Limited Customer PO: EPIC/COE/CI/1043-60238/MGV / Dated: 27.05.2010	TUV Job No.: 8197295004
End Client: Andhra Pradesh Power Development Corporation Limited	Dated: 27-Nov-2010
Manufacturer: M/s L&T Valves, Coimbatore	
Test Valve Description:	
Type	Pressure Seal Gate Valve
Size and Pressure Class Rating	20" (DN 500) Class 3100 Special
Material Specification	Body Material : ASTM A216 Gr WCC Bonnet Material : ASTM A216 Gr WCC + Gielite 6 (HF) Disc Material : ASTM A105 + Stellite 6 (HF) Seat Ring Material : ASTM A105 + Stellite 6 (HF)
End Type	Butt Weld End
Reference Documents:	
Valve Test Procedure No.	LTF-EP-03 Revision 2
General Assembly Drawing No	LT-HPHT-GAD-001 Revision 0
Valve Testing Arrangement Drawing No.	LT343051 Revision 0
Valve Test Report	LT-HPHT-003
Test Parameters / Conditions:	
Test Fluid - Nitrogen gas	
Gas Test Pressures at Temperatures	443 bar at 194°C - Allowable Leakage Rate: 90 cc/min 519 bar at 150°C - No Pressure Drop Allowed 588 bar at ambient - Allowable Leakage Rate: 9 cc/min
Mechanical Cycles	5 Cycles at 519 bar (Ambient) - No Pressure Drop Allowed 3 Cycles at 443 bar (194°C) - No Pressure Drop Allowed
Conclusions / Remarks:	
The above valve test has been witnessed and found to be acceptable as per test procedure.	
	
<small>Registered & Head Office: 88/1, Rajaji Plaza - 1, L.B.S. Marg, Gharkoper (W), Mumbai-400 086. Phone: (22) 8547 7000 • Fax: (22) 8547 7069 • E-mail: mumbai@tuvindia.com • Website: www.tuvindia.co.in</small>	



Commitment to customer satisfaction forms the foundation of L&T Valves quality management system. The QMS is certified to comply with ISO 9001: 2008 and CE PED/ 97/ 23/ EC. The QMS is also approved by the global majors in power and oil & gas domains.

L&T Valves is the first Indian valve manufacturer authorised by American Society of Mechanical Engineers (ASME) to use 'N' and 'NPT' stamps on its products for the nuclear power sector.



L&T Valves facility in Coimbatore, Tamil Nadu, forms a part of L&T's 300-acre high-tech manufacturing hub. The plant is designed for manufacture of complex large-size valves as well as high volume production of smaller valves.

Facilities:

- 5-axis Machining Centres
- CNC VTLs with table dia up to 4m
- CNC Rotary Surface Grinding Machines
- SMAW, MIG, Plasma Arc Welding Machines, table dia 60"
- EOT Cranes of capacity 40 tons

Occupational health and safety as well as environmental protection are accorded prime significance and guide all aspects of manufacturing at the plant. L&T Valves Coimbatore is a zero discharge unit and a pioneer in green initiatives.



Gate, Globe & Check Valves - ASME Class 600 to 4100

L&T high pressure range of gate, globe & check valves conform to ASME B16.34. The valves are of pressure-seal design and have innovative features that enhance performance and plant safety. The valves can be supplied with IBR certification.

Pillar-yoke Construction

L&T gate and globe valves are of pillar-yoke construction, where the yoke plate is connected to the body using steel pillars. This construction enables easy access to bonnet and gland packing for maintenance. Further, since the yoke is directly mounted on the body, unbalanced thrust does not compromise valve performance.

Pressure-seal Body-bonnet Design

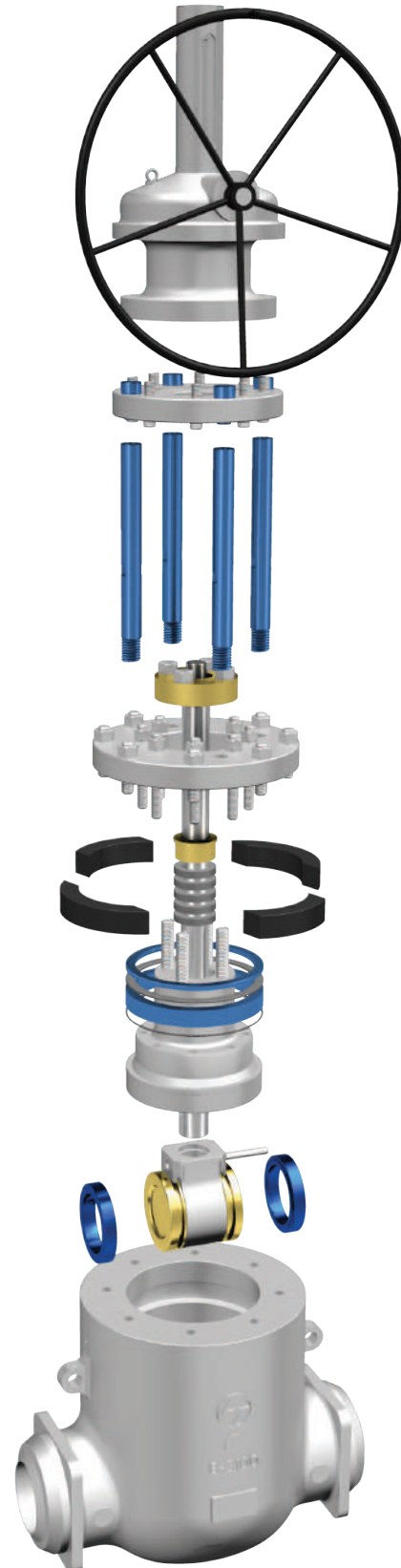
In this design, line pressure is used to create a high integrity body-bonnet seal - the higher the pressure, the better the sealing. The bonnet is held in place by a split-retainer and pre-loaded against it using the bonnet bolts and retainer plate. This arrangement provides tight seal at low pressures also.

Welded Seat Ring

In gate and check valves, seat rings are seal-welded to the body. This eliminates leakage path between seat ring and body as well as accidental loosening due to temperature fluctuations or vibrations.

Full-bore Design

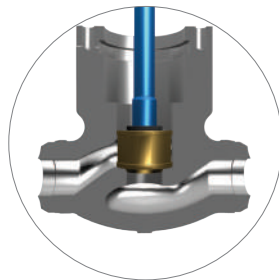
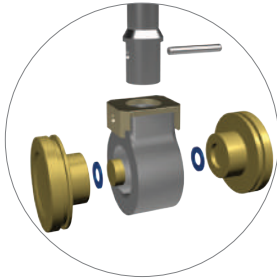
For gate valves, the standard product offering is full-bore as per ASME B16.34. Higher wall thickness and enhanced flow parameters are the characteristics of this design. Gate valves are offered in reduced-bore design also.



Parallel-slide Disc

The disc mechanism comprises two independent discs, a disc carrier and Belleville springs. The disc faces are parallel to each other and the springs keep the discs loaded against the body seats. Sealing occurs when line pressure forces the disc against the downstream seat.

Parallel-slide discs are position-seated and operating torques are considerably lower in this design. This design also eliminates chances of disc-jamming due to thermal binding.



Hard-faced Trim

Disc, seats and back-seat (for gate and globe valves) of high pressure valves are hard-faced with Stellite 6 or equivalent. As a standard, the valves are offered with a hard-facing thickness of 3 mm to ensure long and trouble-free service life.

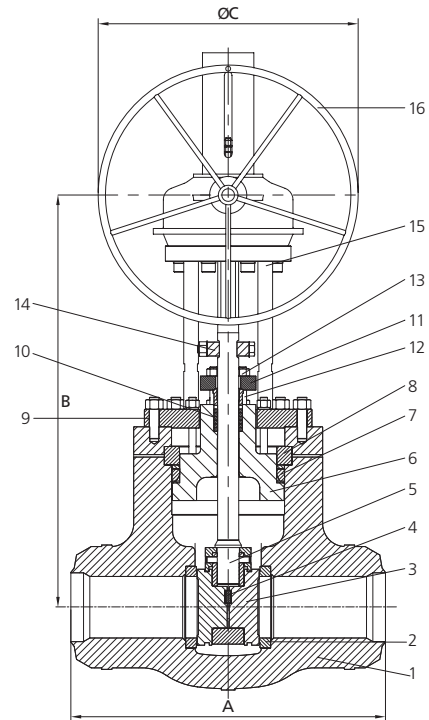
Globe Valves - Insitu Seat & Body-guided Disc

High pressure globe valves have integral seats that are machined and hard-faced insitu to improve wear resistance.

The discs of L&T globe valves are guided during opening/ closing to minimise effects of side thrust and this prevents seat damage.

Gate Valves - ASME Class 600 to 4100 (ASME B16.34)

L&T gate valves in classes ranging from 600 to 4100 conform to ASME B16.34. The valves feature a high integrity pressure-seal body-bonnet connection and are of pillar-yoke construction. The parallel-slide disc is another innovative feature of this range.



Materials of Construction

No.	Components	Materials			
		WCC	WC6	WC9	C12A
1	Body	A 216 Gr. WCC	A 217 Gr. WC6	A 217 Gr. WC9	A 217 Gr. C12A
2	Seat Ring (Seal-welded)	A 105 + HF	A 182 Gr. F11 + HF	A 182 Gr. F22 + HF	A 182 Gr. F91 + HF
3	Disc	A 105 + HF	A 182 Gr. F11 + HF	A 182 Gr. F22 + HF	A 182 Gr. F91 + HF
4	Spring	Inconel X750			
5	Stem	A 182 Gr. F6a	A 182 Gr. F6a	A182 Gr. F6a	A 479 Type 431
6	Bonnet	A 216 Gr. WCC + HF	A 217 Gr. WC6 + HF	A 217 Gr. WC9 + HF	A 217 Gr. C12A + HF
7	Gasket	Graphite			
8	Segmental Retainer	A 182 Gr. F6a	A 182 Gr. F6a	A 182 Gr. F6a	A 479 Type 431
9	Retainer Plate	A 516 Gr. 70	A 182 Gr. F11	A 182 Gr. F22	A 182 Gr. F91
10	Packing	Die-moulded Graphite Packing with Braided end-rings			
11	Gland Flange	A 105	A 105	A 105	A 105
12	Stud	A 193 Gr. B7	A 193 Gr. B16	A 193 Gr. B16	A 193 Gr. B16
13	Heavy Hex Nut	A 194 Gr. 2H	A 194 Gr. 7	A 194 Gr. 7	A 194 Gr. 7
14	Guide Plate	A 276 Type 410	A 276 Type 410	A 276 Type 410	A 276 Type 410
15	Pillar	A 182 Gr. F6a	A 182 Gr. F6a	A 182 Gr. F6a	A 479 Type 431
16	Handwheel	IS 1865 Gr. SG400/15/ Steel			
--	Identification Plate	Stainless Steel			

HF - Hard-Faced with Stellite 6 or equivalent

Dimensions

Size		Class 600			
inch	mm	A	B	ØC	Wt.
20	500	1195	1855	800	2320
22	550	1250	2045	800	3100
24	600	1397	2380	800	3535
26	650	1448	2520	800	4600
28	700	1549	2695	800	5345
30	750	1651	2835	900	7700
32	800	1778	3180	1000	8035
34	850	1900	3250	900	8850
36	900	1900	3375	1000	9500
38	950	1900	3415	1000	11500
40	1000	1900	3855	900	14000
42	1050	1900	3960	1000	16500

Gate valves of sizes 20" and above in class 600 are offered in pressure-seal design.



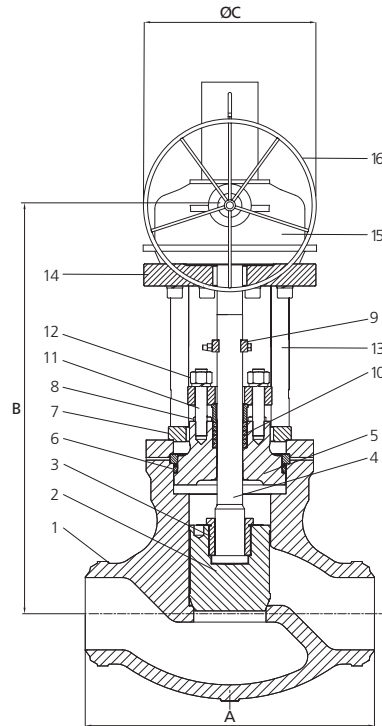
Size		Class 900				Class 1500				Class 2500				Class 3100			
inch	mm	A	B	ØC	Wt.	A	B	ØC	Wt.	A	B	ØC	Wt.	A	B	ØC	Wt.
3	75	305	620	350	72	305	618	350	81	368	666	450	125	368	738	328	130
4	100	356	767	450	105	406	767	450	139	457	653	500	185	457	871	400	220
6	150	508	845	630	280	559	880	630	290	610	863	710	400	610	1153	710	485
8	200	660	1020	710	445	711	1020	710	568	762	1050	800	780	762	1455	630	920
10	250	787	1280	630	695	864	1280	630	849	914	1280	710	1180	914	1639	710	1350
12	300	914	1420	710	971	991	1420	710	1248	1041	1520	500	1720	1041	1896	800	2100
14	350	991	1405	900	1150	1067	1560	800	1846	1118	1710	630	2450	1118	2045	630	2900
16	400	1092	1570	900	1647	1194	1930	630	2485	1245	1830	800	3500	1245	2194	800	3900
18	450	1219	1870	500	1965	1346	2145	710	3399	1397	2115	710	4540	1397	2412	900	5450
20	500	1321	2170	630	2780	1473	2275	710	4418	1473	2410	800	6280	1524	2712	800	7000
22	550	1549	2360	800	4350	1549	2675	800	6640	1549	2680	900	9260	1625	2801	1000	8550
24	600	1549	2360	800	4350	1549	2675	800	6640	1549	2680	900	9260	1727	3217	900	10800
26	650	1651	2430	900	5050	1651	3200	900	7550	1651	3600	900	9460	1727	3380	900	13000
28	700	1651	2890	900	6510	1727	3450	900	8900	1727	4100	900	10205	1900	3450	1000	16100
30	750	1900	3005	900	7826												

All dimensions in mm and weights in kg

Dimensions of valves in ASME Classes 3500 & 4100 available on demand

Globe Valves - ASME Class 900 to 4100 (ASME B16.34)

L&T manufactures high-pressure globe valves in ASME classes ranging from 600 to 4100. These valves conform to ASME B16.34 and feature a pressure-seal body-bonnet connection.



Materials of Construction

No.	Components	Materials			
		WCC	WC6	WC9	C12A
1	Body	A 216 Gr. WCC + HF	A 217 Gr. WC6 + HF	A 217 Gr. WC9 + HF	A 217 Gr. C12A + HF
2	Disc	A 105 + HF	A 182 Gr. F11 + HF	A 182 Gr. F22 + HF	A 182 Gr. F91 + HF
3	Disc Nut	A 276 Type 410		A 276 Type 410	
4	Stem	A 182 Gr. F6a	A 182 Gr. F6a	A 182 Gr. F6a	A 479 Type 431
5	Bonnet	A 216 Gr. WCC + HF	A 217 Gr. WC6 + HF	A 217 Gr. WC9 + HF	A 217 Gr. C12A + HF
6	Gasket	Graphite			
7	Retainer Plate	A 216 Gr. WCC	A 217 Gr. WC6	A 217 Gr. WC9	A 217 Gr. C12A
8	Hex. Screw	A 193 Gr. B7	A 193 Gr. B16	A 193 Gr. B16	A 193 Gr. B16
9	Guide Plate	A 276 Type 410			
10	Packing	Die-moulded Graphite Packing with Braided end-rings			
11	Stud	A 193 Gr. B7	A 193 Gr. B16	A 193 Gr. B16	A 193 Gr. B16
12	Heavy Hex Nut	A 194 Gr. 2H	A 194 Gr. 7	A 194 Gr. 7	A 194 Gr. 7
13	Pillar	A 182 Gr. F6a	A 182 Gr. F6a	A 182 Gr. F6a	A 479 Type 431
14	Yoke	A 216 Gr. WCB	A 217 Gr. WCB	A 216 Gr. WCB	A 216 Gr. WCB
15	Gear Unit	Bevel Type			
16	Handwheel	Steel			
--	Identification Plate	Stainless Steel			

HF - Hard-Faced with Stellite 6 or equivalent

Globe – Disc Options

Globe valves are supplied with customised discs with complex profiles to produce specific flow characteristics.



Tapered Disc (Quick-opening Disc)

We offer the Tapered Disc design as a standard. In this design, when the valve is opened, close-to-maximum discharge is obtained very quickly. These valves are used in services that require quick opening.



Special Profile Discs

- Linear Characteristic Disc
- Equal Percentage Disc

Dimensions

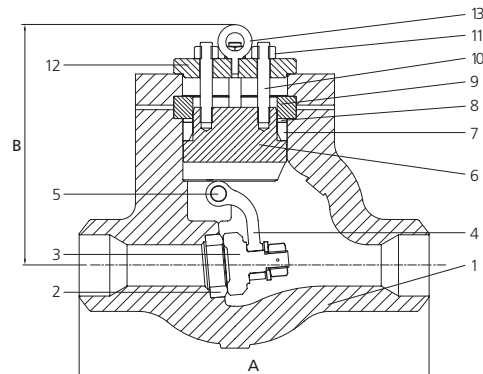
Size		Class 900				Class 1500				Class 2500				Class 3100			
inch	mm	A	B	ØC	Wt.	A	B	ØC	Wt.	A	B	ØC	Wt.	A	B	ØC	Wt.
3	80	381	570	450	85	381	570	450	85	578	610	450	145	368	600	328	150
4	100	457	610	450	115	546	610	450	130	673	800	710	270	457	710	630	450
6	150	610	729	630	245	705	830	450	350	914	1040	800	555	610	950	900	810
8	200	737	1091	710	455	832	1210	500	670	1022	1365	800	805	762	1211	1000	1540
10	250	838	1213	630	695	991	1436	630	965	1270	1725	710	930	914	1405	800	1890
12	300	965	1475	710	955	1130	1792	710	1225	1422	2059	710	1035	1041	1650	800	2210
14	350	1029	1690	800	1155	1257	2235	800	1425	1610	2291	800	1526				
16	400	1115	1835	630	1675	1380	2425	630	1945	1725	2523	800	1915				
18	450	1215	2195	710	1910	1535	2620	710	2180	1829	2755	800	2218				

All dimensions in mm and weights in kg

Dimensions of valves in ASME Classes 3500 & 4100 available on demand

Check Valves - ASME Class 900 to 4100 (ASME B16.34)

L&T's high-pressure check valves are of pressure-seal design. As a standard, these valves are supplied with internal hinge-pins.



Materials of Construction

No.	Components	Materials			
		WCC	WC6	WC9	C12A
1	Body	A 217 Gr. WCC	A 217 Gr. WC6	A 217 Gr. WC9	A 217 Gr. C12A
2	Seat Ring	A 105 + HF	A 182 Gr. F11 + HF	A 182 Gr. F22 + HF	A 182 Gr. F91 + HF
3	Disc	A 105 + HF	A 182 Gr. F11 + HF	A 182 Gr. F22 + HF	A 182 Gr. F91 + HF
4	Hinge	A 217 Gr. WCC	A 217 Gr. WC6	A 217 Gr. WC9	A 217 Gr. C12A
5	Hinge-pin	A 182 Gr. F6a	A 479 Type 410	A 479 Type 410	A 479 Type 431
6	Cover	A 105	A 182 Gr. F11	A 182 Gr. F22	A 182 Gr. F91
7	Gasket with anti-extrusion caps	Graphite			
8	Spacer	A 105	A 182 Gr. F11	A 182 Gr. F22	A 182 Gr. F91
9	Segmental Retainer	A 182 Gr. F6a	A 182 Gr. F6a	A 182 Gr. F6a	A 182 Gr. F91
10	Stud	A 193 Gr. B7	A 193 Gr. B16	A 193 Gr. 16	A 193 Gr. B16
11	Heavy Hex Nut	A 194 Gr. 2H	A 194 Gr. 7	A 194 Gr. 7	A 194 Gr. 7
12	Cap	A 105	A 182 Gr. F11	A 182 Gr. F22	A 182 Gr. F91
13	Eye Bolt	Carbon Steel			
--	Identification Plate	Stainless Steel			

HF - Hard-Faced with Stellite 6 or equivalent

Dimensions

Size		Class 900			Class 1500			Class 2500			Class 3100		
inch	mm	A	B	Wt.	A	B	Wt.	A	B	Wt.	A	B	Wt.
3	80	305	250	45	305	250	45	368	250	60	368	280	112
4	100	356	260	40	406	260	60	457	275	100	457	314	150
6	150	508	350	90	559	350	135	610	380	220	610	440	235
8	200	660	400	185	711	400	240	762	450	370	762	520	486
10	250	787	510	310	864	510	465	914	560	695	914	600	946
12	300	914	590	460	991	590	700	1041	660	1100	1041	706	1376
14	350	991	650	700	1067	650	940	1118	760	1530	1241	832	1700
16	400	1092	720	950	1194	735	1415	1245	890	2250	1245	778	2593
18	450	1240	790	1350	1366	850	1800	1397	890	2790	1395	861	3659
20	500	1321	850	1890	1473	900	2500	1420	920	2920	1524	933	4223
22	550	1549	900	2410	1549	900	2745	1549	1100	5770	1625	988	5500
24	600	1549	900	2410	1549	990	3550	1549	1100	5770	1727	1041	6700
26	650	1650	1050	2630	1650	1070	3290	1710	1120	6525	1750	1125	7400
28	700	1650	1120	3400	1650	1150	3420	1710	1200	7400	1750	1180	7900

All dimensions in mm and weights in kg

Dimensions of valves in ASME Classes 3500 & 4100 available on demand

Ordering Information

Series	Type	Class	Ends	API Trim
L	H - ASME B16.34 Gate	6 - 600	B - Butt-weld	5 - Trim 5
	Q - ASME B16.34	9 - 900		8 - Trim 8
	S - ASME B16.34 Check	A - 1500		12 - Trim 12
		B - 2500		16 - Trim 16
		C - 3100		
		D - 3500		
		E - 4100		
		F - 4500		



High pressure gate valves can be supplied with a variety of arrangements to equalize upstream and downstream pressures. Typically globe valves are used as bypass valves.

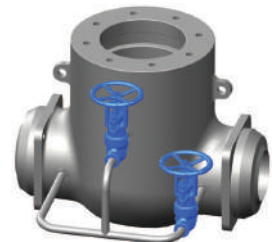
Further, to prevent centre cavity over-pressurization, the cavity is connected to the upstream side of the valve. This connection may be done with or without a pressure equalizing valve.



The upstream and downstream sides of the valve are connected by a bypass pipe fitted with a globe valve. The gate valve is bidirectional.



There is an additional connection between centre cavity and upstream for cavity relief. The gate valve is unidirectional.



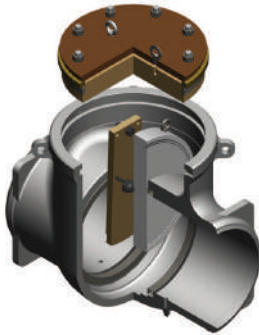
In this arrangement, the centre cavity is connected to a bypass pipe. Globe valves are provided on the downstream side and the connection between centre cavity and bypass. Entrapped fluid is relieved using the centre cavity valve. The gate valve is unidirectional.



The arrangement consists of a connection between the centre cavity and a bypass pipe, with one valve each on the upstream and downstream of the bypass pipe. Based on the flow direction, one valve can act as bypass valve and the other, as a pressure equalizing valve. The gate valve is thus bidirectional.



An additional valve is provided on the connection between the centre cavity and the bypass pipe. The gate valve is bidirectional.



Bellow Seal Valves

Bellow Seal Valves are used in services where leakage through stem packing area needs to be eliminated. These valves find application in lines handling hazardous fluids in nuclear and thermal power as well as hydrocarbon industries. The bellows conform to MSS SP 117 and can be offered in stainless steel, Inconel or Hastelloy.

Reheat Isolation Device

Reheat Isolation Device (RID) is used to isolate reheat lines during hydrostatic tests. The device has a disc that can be inserted from the top between hard-faced seat rings to effect sealing. After hydrostatic tests, the disc is removed and the device effectively becomes an integral part of the piping. RID eliminates the need to physically isolate lines during tests.

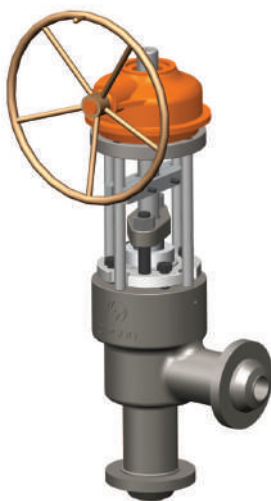
The body-bonnet connection of this device is of pressure-seal design.

Quick Closing Non-return Valve

Quick Closing Non-Return Valves (QCNRV) are swing check valves where quick closing is achieved using special actuation mechanisms. These are used to protect turbines and compressors from damage due to back flow.

Vacuum Service Valves

Vacuum Service Valves are offered in a variety of sizes and pressure classes. Stem finish and integrity of gland packing are crucial for these valves. The valves can also be offered with lantern-ring arrangement based on customer demand.



Angle Globe Valves

In Angle Globe Valves, the inlet and outlet are at right angles to each other. These valves find application in lines where pipe configuration or pressure drop is a concern.

Angle Globe Valves can be offered in pressure-seal as well as bolted bonnet designs based on line pressure.

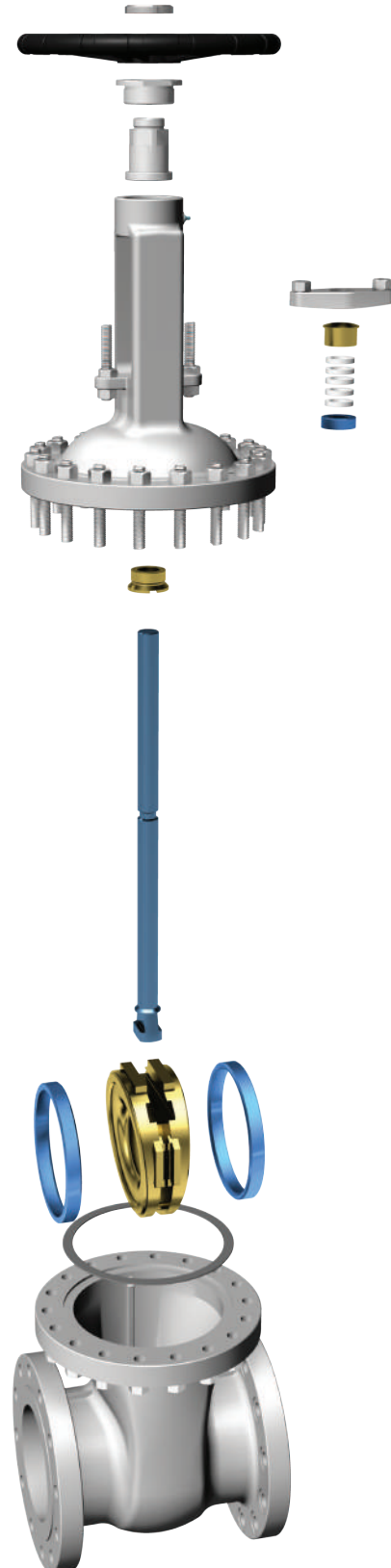
Accessories

L&T Gate, Globe & Check Valves are supplied with a range of accessories to address process and plant requirements.

- Electric, Pneumatic and Hydraulic Actuators
- Position Indicators
- Extension Spindle
- Gear Units
- Locking Arrangement
- Live Loading

Gate, Globe & Check Valves - ASME Class 150 to 600

L&T offers a versatile range of cast steel gate, globe and check valves in bolted bonnet construction. The gate and globe valves are of outside screw-and-yoke design. The check valves are swing-type. This range is available with flanged and butt-weld ends and can be supplied with IBR certification.



Stem

Single-piece forged stems are used in gate and globe valves for superior strength. In a gate valve, the forged T-head engages with a slot in the disc. The globe valve disc is fitted to the stem using a disc nut, which allows the disc to swivel and align with the seat.

Disc

Gate valve discs are of single-piece cast flexible wedge design. In these torque-seated valves, the flexible wedge compensates for seat distortion and eliminates disc-jamming.

Seat

In gate and check valves, seat rings are seal-welded to the body. This eliminates leakage path between seat ring and body as well as accidental loosening due to temperature fluctuations or vibrations.

Body-bonnet Joint

Class 150 gate valves in sizes 3" and above are offered with oval-shaped body-bonnet joints. As a standard, 2" gate valves as well as globe and check valves have circular body-bonnet joints.

Ordering Information

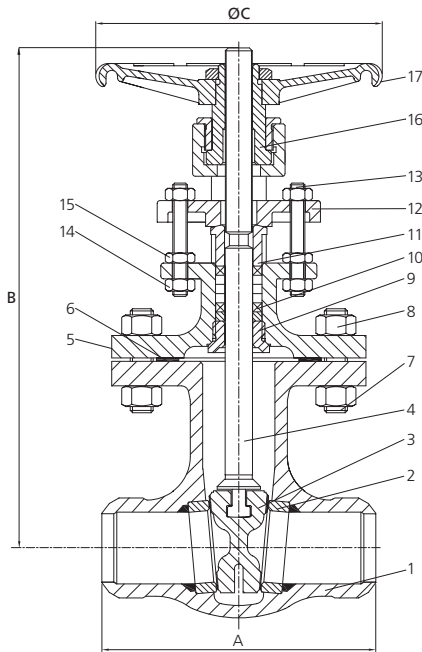
Series	Type	Class	Ends*	API Trim
L	K - ASME B16.34 Gate	1 - 150	B - Butt-weld	5 - Trim 5
	D - ASME B16.34 Globe	3 - 300	F - Flanged	8 - Trim 8
	E - ASME B16.34 Check	6 - 600		12 - Trim 12
	G - API 600 Gate			16 - Trim 16
	R - BS 1873 Globe			
	N - BS 1868 Check			

*ASME B16.34 valves are available with Butt-weld ends only



Gate Valves - ASME Class 150, 300 & 600 (API 600, ASME B16.34)

L&T Gate Valves with bolted bonnet and flexible wedge are available in ASME classes 150 to 600. The valves are offered with flanged and butt-weld ends in sizes up to 24", above which butt-weld end is the standard.



No.	Components	Materials
1	Body	A 216 Gr. WCB
2	Seat Ring	A 105 + HF
3	Disc	A 217 Gr. CA15/ A 216 Gr. WCB + 13% Cr
4	Stem	A 182 Gr. F6a
5	Bonnet	A 216 Gr. WCB
6	Gasket - Cl. 150	Corrugated soft steel with Graphite Filler
6	Gasket - Cl. 300 & Cl. 600	Spirally-wound SS316 with Graphite filler
7	Stud	A 193 Gr. B7
8	Hex. Nut	A 194 Gr. 2H
9	Bonnet Bush	A 276 Type 410
10	Packing	Die-moulded Graphite packing with braided end-rings
11	Gland	A 276 Type 410
12	Gland Flange	A 105
13	Stud	A 193 Gr. B7
14	Hex. Nut	A 194 Gr. 2H
15	Lock Nut	A 194 Gr. 2H
16	Yoke Sleeve	B 148 UNS C95400
17	Handwheel	IS:1865 Gr. SG400/15/ Steel
--	Identification Plate	Stainless Steel

HF - Hard-Faced with Stellite 6 or equivalent
Valves in other materials available on demand

Dimensions

Size		Class 150						Class 300					
inch	mm	A		B	ØC	Wt.		A		B	ØC	Wt.	
		FL	BW			FL	BW	FL	BW			FL	BW
2	50	178	216	379	200	20	20	216	216	406	200	23	20
3	80	203	282	486	250	32	30	282	282	507	250	50	44
4	100	229	305	591	250	47	46	305	305	600	250	72	63
6	150	267	403	795	350	93	85	403	403	815	350	155	120
8	200	292	419	995	350	151	120	419	419	1015	400	236	190
10	250	330	457	1040	400	198	200	457	457	1035	400	340	280
12	300	356	502	1100	400	294	270	502	502	1080	630	510	400
14	350	381	572	1200	400	430	379	762	762	1180	630	834	728
16	400	406	610	1350	400	500	570	838	838	1350	710	1080	990
18	450	432	660	1490	500	630	603	914	914	1480	710	1200	1140
20	500	457	711	1580	630	840	808	991	991	1625	900	1480	1355
22	550		762	1580	630		850		1092	1625	900		1375
24	600	508	813	1875	710	1170	1160	1143	1143	1940	900	2320	1800
26	650		864	1875	710		1179		1245	1965	900		1950
28	700		914	2320	900		2175		1346	2450	1000		3000
30	750		914	2320	900		2062		1397	2460	1000		3600
32	800		965	2625	900		2100		1496	3365	1000		4650
34	850		1016	3670	900		3001		1626	4100	1000		5500
36	900		1016	2715	900		3100		1727	2890	1000		6800
38	950		1042	2715	900		3175		1900	4450	1000		7500
40	1000		1067	3200	1000		4700		1900	4550	1000		7800
42	1050		1100	4400	1000		6000		1900	3450	1000		8100

All dimensions in mm and weights in kg



Size		Class 600					
inch	mm	A		B	ØC	Wt.	
		FL	BW			FL	BW
2	50	292	292	425	200	31	31
3	80	356	356	524	250	62	56
4	100	432	432	605	350	114	100
6	150	559	559	850	300	220	243
8	200	660	660	870	500	470	524
10	250	787	787	972	710	680	761
12	300	838	838	1100	710	910	875
14	350	893	889	1275	800	1140	985
16	400	991	991	1440	900	1690	1690
18	450	1096	1092	1595	1000	2035	1865

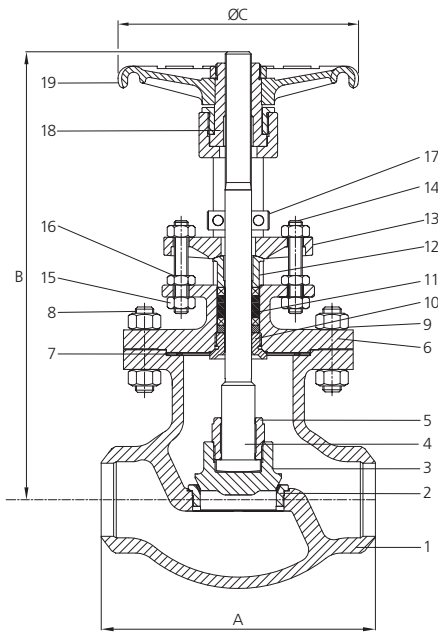
All dimensions in mm and weights in kg

L&T Gate Valves of size 20" and above in ASME class 600 are offered with pressure-seal bonnet and pillar-yoke design as a standard. Please refer page no. 11 for dimensional details of valves 20" and above.

Globe Valves - ASME Class 150, 300 & 600 (BS1878, ASME B16.34)

L&T Globe Valves with bolted bonnet and plug-type disc are available in ASME classes 150 to 600.

Up to 12", the valves are offered with flanged and butt-weld ends, above which butt-weld end is the standard.



No.	Components	Materials
1	Body	A 216 Gr. WCB
2	Seat Ring	A 182 Gr. F6a + HF
3	Disc	A 182 Gr. F6a/ A 216 Gr. WCB + 13% Cr
4	Stem	A 182 Gr. F6a
5	Disc Nut	A 276 Type 410
6	Bonnet	A 216 Gr. WCB
7	Gasket	Spirally-wound SS316 with Graphite filler
8	Stud	A 193 Gr. B7
9	Hex. Nut	A 194 Gr. 2H
10	Bonnet Bush	A 276 Type 410
11	Packing	Die-moulded Graphite packing with braided end-rings
12	Gland	A 276 Type 410
13	Gland Flange	A 105
14	Stud	A 193 Gr. B7
15	Hex. Nut	A 194 Gr. 2H
16	Lock Nut	A 194 Gr. 2H
17	Stem Guide	A 276 Type 410
18	Yoke Sleeve	B 148 UNS C95400
19	Handwheel	IS:1865 Gr. SG400/ 15
--	Grease Nipple	Steel
--	Identification Plate	Stainless Steel

HF - Hard-Faced with Stellite 6 or equivalent
Valves in other materials available on demand

Dimensions

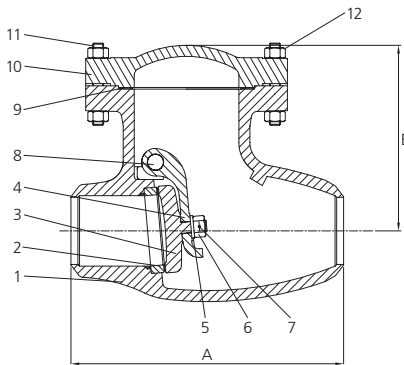
Size		Class 150						Class 300						Class 600					
		A		B	ØC	Wt.		A		B	ØC	Wt.		A		B	ØC	Wt.	
inch	mm	FL	BW			FL	BW	FL	BW			FL	BW	FL	BW			FL	BW
2	50	203	203	375	200	22	18	267	267	390	200	31	28	295	292	425	250	38	34
3	80	241	241	420	250	37	36	318	318	430	250	50	45	356	356	650	350	81	72
4	100	292	292	510	350	63	60	356	356	570	350	88	67	432	432	810	500	138	110
6	150	406	406	610	350	104	95	444	444	735	450	180	163	599	559	895	710	440	347
8	200	495	495	795	450	208	195	559	559	875	710	405	363	663	660	930	900	680	365
10	250	622	622	895	710	356	337	622	622	950	800	555	493	787		1315	900		439
12	300	698	698	913	800	579	579	711	711	1050	900	820	611	838		1550	900		765
14	350		775	930	900			838	1200	1000			985	889		1700	1000		985
16	400		914	1019	900			864	1300	1000			1419	991		1895	1000		1459
18	450		978	1291	1000			978	1540	1000			1925	1092		1925	1000		1950

All dimensions in mm and weights in kg

Check Valves - ASME Class 150, 300 & 600 (BS1868, ASME B16.34)

L&T Check Valves with bolted cover, swing-type disc and internal hinge are available in ASME classes 150 to 600.

The valves are offered with flanged and butt-weld ends in sizes up to 24", above which butt-weld end is the standard. Valves are also offered with dashpot arrangement based on customer demand.



No.	Components	Materials
1	Body	A 216 Gr. WCB
2	Seat Ring	A 105 + HF
3	Disc	A 217 CA15/ A216 Gr.WCB + 13% Cr
4	Hinge	A 216 Gr. WCB
5	Washer	SS 304
6	Hinge Nut	SS 304
7	Split Pin	SS 304
8	Hinge-pin	A 276 Type 410
9	Gasket	Spirally-wound SS316 with Graphite filler
10	Cover	A 216 Gr. WCB
11	Stud	A 193 Gr. B7
12	Hex. Nut	A 194 Gr. 2H
--	Identification Plate	Stainless Steel

HF - Hard-Faced with Stellite 6 or equivalent
Valves in other materials available on demand

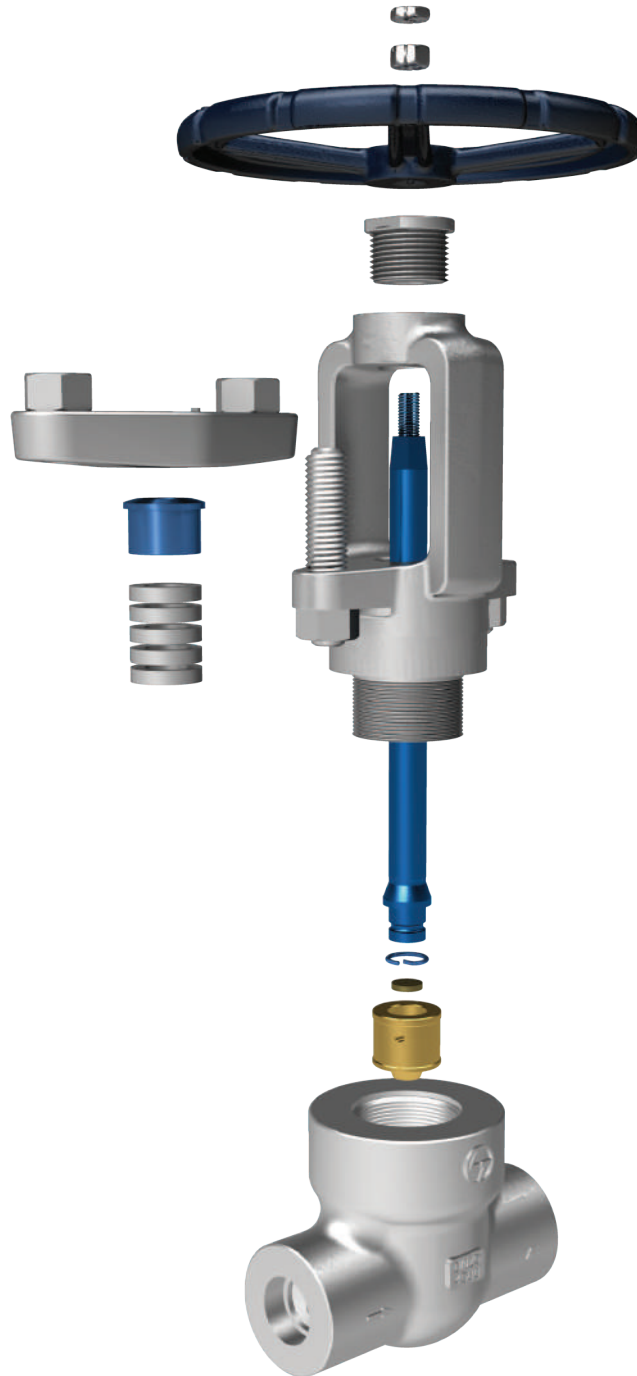
Dimensions

Size		Class 150					Class 300					Class 600				
		A		B	Wt.		A		B	Wt.		A		B	Wt.	
inch	mm	FL	BW		FL	BW	FL	BW		FL	BW	FL	BW		FL	BW
2	50	203	203	135	17	15	267	267	145	23	18	292	292	165	32	29
3	80	241	241	150	27	25	318	318	170	38	34	356	356	195	45	40
4	100	292	292	190	43	40	356	356	210	62	45	432	432	248	86	78
6	150	356	356	270	68	64	444	444	260	117	111	559	559	306	320	120
8	200	495	495	310	118	95	533	533	370	190	171	660	660	383	420	210
10	250	622	622	350	195	150	622	622	357	265	215	787	787	423	547	347
12	300	698	698	380	310	255	711	711	450	405	235	838	838	468	780	520
14	350	787	787	383	395	395	838	838	418	510	260	889	889	502	893	580
16	400	864	914	428	615	615	864	864	495	665	635		991	601		850
18	450	978	978	466	650	650	978	978	622	890	840		1092	665		1150
20	500	978	978	503	750	680	1016	1016	595	1085	900		1125	812		1425
22	550		1067	562		810		1118	586		950		1295	908		1610
24	600	1295	1295	595	1035	965	1346	1346	695	1750	1500		1397	980		1690
26	650		1295	569		1070		1346	695		1550		1448	1115		1780
28	700		1448	740		1450		1499	779		2300		1600	1190		1850
30	750		1524	824		2200		1594	1050		2700		1651	1230		1920
32	800		1524	824		2300		1700	1120		2950		1780	1290		1995
34	850		1900	1023		4050		1850	1120		3170		1900	1350		2205
36	900		1900	1023		4100		1900	1250		3350		1900	1410		2890
38	950		1900	1023		4400		1900	1350		3570		1900	1450		3250
40	1000		1900	1200		4800		1900	1400		3890		1900	1510		3990
42	1050		1900	1200		4850		1900	1410		4120		1900	1510		4200

All dimensions in mm and weights in kg

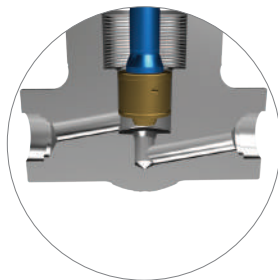
Forged Steel Globe & Check Valves - ASME Class 1500, 2500 & 4500 (ASME B16.34)

L&T forged steel globe and check valves in sizes up to 2" complement the high pressure gate, globe and check valves range. The T-pattern valves are IBR-certified and are available in a variety of materials.



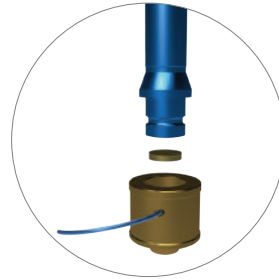
Body-bonnet Connection

The body-bonnet connection of these valves is of threaded construction. To enhance the seal, the body-bonnet joint is seal-welded.



Stem-disc Assembly

The disc of a globe valve is connected to the stem using a wire inserted through a hole in the disc. This unique stem-disc connection enables the disc to rotate freely on the stem, align perfectly with the seat and produce a tight seal.

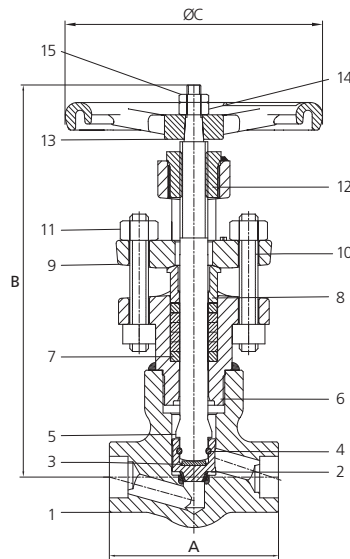


Seat and Disc

Forged steel valves have integral seats that are machined and hard-faced insitu for longer service life. As a standard, the valves are offered with 3 mm hard-facing.

The discs are guided during opening/ closing to ensure proper sealing and to minimize seat damage.

Forged Steel Globe Valves - ASME Class 1500, 2500 & 4500 (ASME B16.34)



Dimensions

Size		Class 1500/ 2500				Class 4500			
inch	mm	A	B	ØC	Wt.	A	B	ØC	Wt.
½	15	115	273	175	7.2	130	210	175	11
¾	20	115	273	175	7.2	130	210	175	11
1	25	130	297	225	10	165	305	225	14
1 ¼	32	178	372	275	17.6	188	407	275	27
1 ½	40	178	372	275	17.6	188	435	275	27
2	50	202	425	300	26	230	435	300	30

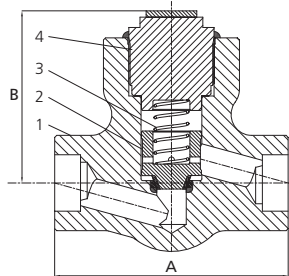
Valves in ASME Classes 1500 & 2500 are available in sizes up to 6"

Materials of Construction

No.	Components	Materials			
		A105	F22	F91	F304
1	Body (Integral Seat)	A 105	A 182 Gr. F22 Cl. 3	A 182 Gr. F91	A 182 Gr. F304
2	Disc	A 479 Type 410 + HF	A 479 Type 410 + HF	A 479 Type 316 + HF	A 479 Type 316 + HF
3	Disc Washer	A 479 Type 410	A 479 Type 410	A 479 Type 431	A 479 Type XM19
4	Retainer Wire	A 479 Type 430	A 479 Type 430	A 479 Type 430	A 479 Type 316
5	Stem	A 479 Type 410	A 479 Type 410	A 479 Type 431	A 479 Type XM19
6	Bonnet	A 105	A 182 Gr. F22 Cl. 3	A 182 Gr. F91	A 182 Gr. F304
7	Packing	Die-moulded Graphite Packing with Braided end-rings			
8	Gland	A 276 Type 410			
9	Gland Flange	A 105	A 105	A 105	A 182 Gr. F304
10	Stud	A 193 Gr. B7	A 193 Gr. B16	A 193 Gr. B16	A 193 Gr. B8 Cl. 1
11	Heavy Hex Nut	A 194 Gr. 2H	A 194 Gr. 7	A 194 Gr. 7	A 194 Gr. 8
12	Yoke Bush	A 582 Type 416	A 582 Type 416	A 582 Type 416	Aluminium Bronze
13	Handwheel	IS 1865 Gr. SG400/ 15			
14	Heavy Hex Nut	A 194 Gr. 2H	A 194 Gr. 7	A 194 Gr. 7	A 194 Gr. 8
15	Lock Nut	A 194 Gr. 2H	A 194 Gr. 7	A 194 Gr. 7	A 194 Gr. 8
--	Identification Plate	Stainless Steel			

HF - Hard-Faced with Stellite 6 or equivalent

Forged Steel Check Valves - ASME Class 1500, 2500 & 4500 (ASME B16.34)



Dimensions

Size		Class 1500/ 2500			Class 4500		
inch	mm	A	B	Wt.	A	B	Wt.
½	15	115	83	9.1	130	85	5
¾	20	115	83	3	130	85	5
1	25	130	95	3.3	165	97	8
1 ¼	32	178	122	8.3	188	127	15.7
1 ½	40	178	122	8.3	188	127	15.7
2	50	202	140	13	230	146	28.7

Valves in ASME Classes 1500 & 2500 are available in sizes up to 6"

Materials of Construction

No.	Components	Materials			
		A105	F22	F91	F304
1	Body (Integral Seat)	A 105	A 182 Gr. F22 Cl. 3	A 182 Gr. F91	A 182 Gr. F304
2	Disc	A 479 Type 410 + HF	A 479 Type 410 + HF	A 479 Type 316 + HF	A 479 Type 316 + HF
3	Spring	Inconel X750			
4	Cover	A 105	A 182 Gr. F22 Cl. 3	A 182 Gr. F91	A 182 Gr. F304
--	Identification Plate	Stainless Steel			

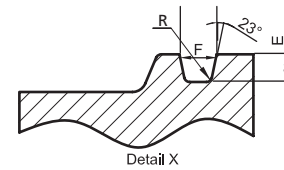
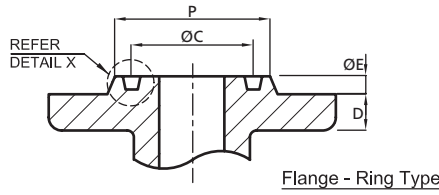
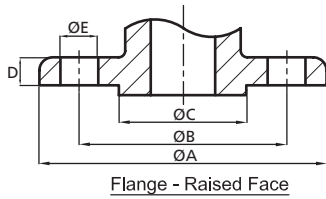
All dimensions in mm and weights in kg
HF - Hard-Faced with Stellite 6 or equivalent

Ordering Information

Series	Type	Class	Ends	API Trim
L	F - Forged Steel Globe	A - 1500	L - Socket weld	5 - Trim 5
	L - Forged Steel Check	B - 2500	B - Butt-weld	16 - Trim 16
		F - 4500		

Flange & Butt-Weld Dimensions

Flanged as per ASME B16.5, 2009



Valve Size		ASME Class 150 Raised Face (in mm)						ASME Class 300 Raised Face (in mm)							
		ØA	ØB	ØC	D*	ØE	Bolt		ØA	ØB	ØC	D*	ØE	Bolt	
No.	Dia						No.	Dia							
2	50	152	120	92	19.1 (15.9)	19	4	5/8"	165	127	92	22.3	19	8	5/8"
3	80	190	152	127	23.9 (19.1)	19	4	5/8"	210	168	127	28.6	22	8	3/4"
4	100	229	190	157	23.9	19	8	5/8"	254	200	157	31.8	22	8	3/4"
5	125	254	216	186	23.9	22	8	3/4"	279	235	186	35	22	8	3/4"
6	150	279	241	216	25.4	22	8	3/4"	318	270	216	36.6	22	12	3/4"
8	200	343	298	270	28.6	22	8	3/4"	381	330	270	41.3	25	12	7/8"
10	250	406	362	324	30.2	25	12	7/8"	444	387	324	47.7	29	16	1"
12	300	483	432	381	31.8	25	12	7/8"	521	451	381	50.8	32	16	1 1/8"
14	350	533	476	413	35	29	12	1"	584	514	413	54	32	20	1 1/8"
16	400	597	539	470	36.6	29	16	1"	648	571	470	57.2	35	20	1 1/4"
18	450	635	578	533	39.7	32	16	1 1/8"	711	628	533	60.4	35	24	1 1/4"
20	500	698	635	584	42.9	32	20	1 1/8"	775	686	584	63.5	35	24	1 1/4"
24	600	813	749	692	47.7	35	20	1 1/4"	914	813	692	69.9	41	24	1 1/2"

* Inclusive of raised face 2 mm each. Dimensions within brackets are for integral flanges

Size		ASME Class 600 Raised Face						Bolt	
		ØA	ØB	ØC	D*	ØE	No.		
inch	mm						No.	Dia	
2	50	165	127	92	25.4	19	8	5/8"	
3	80	210	168	127	31.8	22	8	3/4"	
4	100	273	216	157	38.1	25	8	7/8"	
5	125	330	266	186	44.5	29	8	1"	
6	150	356	292	216	47.7	29	12	1"	
8	200	419	349	270	55.6	32	12	1 1/8"	
10	250	508	432	324	63.5	35	16	1 1/4"	
12	300	559	489	381	66.7	35	20	1 1/4"	
14	350	603	527	413	69.9	38	20	1 3/8"	
16	400	686	603	470	76.2	41	20	1 1/2"	
18	450	743	654	533	82.6	45	20	1 5/8"	
20	500	813	724	584	88.9	45	24	1 5/8"	
24	600	940	838	692	102	51	24	1 7/8"	

Height of raised face is 7 mm each.

Size		ASME Class 600 Ring Type									
		ØA	ØB	ØC	D*	ØE	Pitch	Depth E	Width F	Bottom Rad. R	
inch	mm										
2	50	165	127	108	25.4	R23	83	8.0	12.0	0.76	
3	80	210	168	146	31.8	R31	124	8.0	12.0	0.76	
4	100	273	216	171	38.1	R37	150	8.4	8.7	0.76	
5	125	330	266	209	44.5	R41	181	8.0	12.0	0.76	
6	150	356	292	241	47.7	R45	211	8.0	12.0	0.76	
8	200	419	349	302	55.6	R49	270	8.0	12.0	0.76	
10	250	508	432	356	63.5	R53	324	8.0	12.0	0.76	
12	300	559	489	413	66.7	R57	381	8.0	12.0	0.76	
14	350	603	527	457	69.9	R61	419	8.0	12.0	0.76	
16	400	686	603	508	76.2	R65	470	8.0	12.0	0.76	
18	450	743	654	575	82.6	R69	533	8.0	12.0	0.76	
20	500	813	724	635	88.9	R73	584	9.5	13.5	1.52	
24	600	940	838	749	101.6	R77	692	11.1	16.6	1.52	

* Inclusive of raised face 2 mm each.

Flanged as per ASME B16.47, 2011 Series A (MSS SP 44)

ASME Class	Size		ØA	ØB	ØC	D*	ØE	Bolt	
	inch	mm						No	Dia
Cl.150	28	700	927	864	800	71	35	28	1 3/8"
	30	750	984	914	857	75	35	28	1 3/8"
	34	850	1111	1029	965	83	41	32	1/2"
	36	900	1168	1086	1022	90	41	32	1/2"
	42	1050	1346	1257	1194	97	41	36	1/2"
	48	1200	1511	1422	1359	108	41	44	1/2"

Flanged as per ASME B16.47, 2011 Series B (API 605)

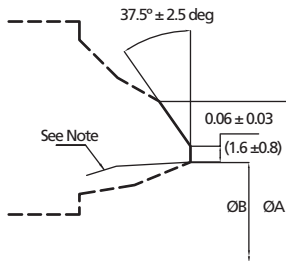
ASME Class	Size		ØA	ØB	ØC	D*	ØE	Bolt	
	inch	mm						No	Dia
Cl.150	28	700	837	795	762	48	22	40	3/4"
	30	750	887	846	813	51	22	44	3/4"
	34	850	1005	957	921	57	25	40	7/8"
	36	900	1057	1010	972	59	25	44	7/8"
	42	1050	1226	1171	1130	68	28	48	1"
	48	1200	1392	1335	1289	75	28	44	1 1/8"

* Inclusive of raised face 2 mm each.

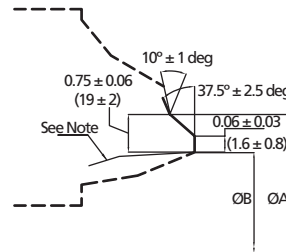
Butt-weld Ends as per ASME B16.25, 2007

Welding end detail for joint without backing ring

Intended for use on 22 mm (0.88") and thinner nominal wall thickness.



Intended for use on wall thickness greater than 22 mm (0.88").



Note : Internal surface may be reformed or machined for dimensions B at root face. Contour within the envelope is manufacturer's option, unless otherwise specifically ordered for.

Size		ØA	ØB										
Inch	mm		STD	XS	30	40	60	80	100	120	140	160	XXS
3	80	91	-	-	-	78	-	74	-	-	-	67	58
4	100	117	-	-	-	102	-	97	-	92	-	87	80
5	125	144	-	-	-	128	-	122	-	116	-	110	103
6	150	172	-	-	-	154	-	148	-	140	-	132	124
8	200	223	-	-	-	203	198	194	189	183	178	173	175
10	250	278	-	-	-	255	247	242	237	230	222	216	-
12	300	329	305	298	-	303	295	289	281	273	267	257	-
14	350	362	337	330	-	333	325	318	308	300	292	284	-
16	400	413	387	-	-	381	373	364	354	344	333	325	-
18	450	464	438	432	-	429	419	410	398	387	378	367	-
20	500	516	489	483	-	478	467	456	443	432	419	408	-
24	600	619	591	584	581	575	560	548	532	518	505	491	-

sales@apsales.in