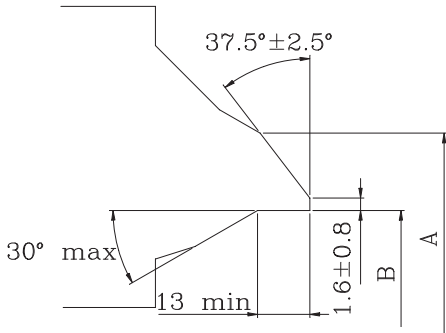
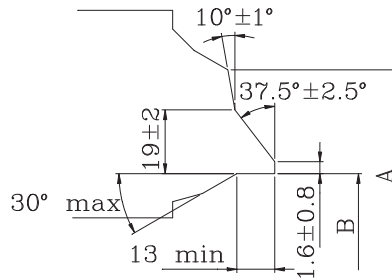


BUTT-WELDING ENDS --- ASME B16.25 -1997



t ≤ 22 mm

Fig.2 (b) Welding end detail for joint using split rectangular backing ring



t > 22 mm

Fig.3 (b) Welding end detail for joint using split rectangular backing ring

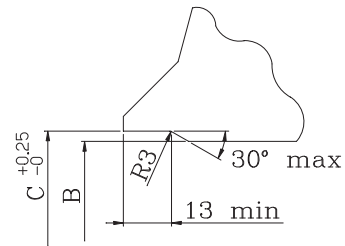


Fig.2.3 (c) Welding end detail for joint using continuous rectangular backing ring

Nominal Pipe Size	Schedule Number or wall	Outside Diameter Cast Steel Valves	Nominal Inside Diameter	Machined Inside Diameter	Nominal Wall Thickness
		A	B	C	t
2 1/2"	40	75	62.5	62.93	5.16
	80		59.0	59.69	7.01
	160		54.0	55.28	9.53
	XXS		45.0	47.43	14.02
3"	40	91	78.0	78.25	5.49
	80		73.5	74.53	7.62
	160		66.5	68.38	11.13
	XXS		58.5	61.19	15.24
3 1/2"	40	105	90.0	90.52	5.74
	80		85.5	86.42	8.08
4"	40	117	102.0	102.73	6.02
	80		97.0	98.28	8.56
	120		92.0	93.78	11.13
	160		87.5	89.65	13.49
	XXS		80.0	83.30	17.12
5"	40	144	128.0	128.80	6.55
	80		122.0	123.58	9.53
	120		116.0	118.04	12.70
	160		109.5	112.47	15.88
	XXS		103.0	106.92	19.05
6"	40	172	154.0	154.82	7.11
	80		146.5	148.06	10.97
	120		140.0	142.29	14.27
	160		132.0	135.31	18.26
	XXS		124.5	128.85	21.95
8"	40	223	203.0	203.75	8.18
	60		198.5	200.02	10.31
	80		193.5	195.84	12.70
	100		189.0	191.65	15.09
	120		182.5	186.11	18.26
	140		178.0	181.98	20.62
	XXS		174.5	179.16	22.23
	160		173.0	177.79	23.01
10"	40	278	254.5	255.74	9.27
	60		247.5	249.74	12.70
	80		243.0	245.55	15.09
	100		236.5	240.01	18.26
	120		230.0	234.44	21.44
	140		222.0	227.51	25.40
12"	160		216.0	221.95	28.58
	STD	329	305.0	306.08	9.53
	40		303.0	304.72	10.31
	XS		298.5	300.54	12.70
	60		295.0	297.79	14.27
	80		289.0	292.17	17.48
	100		281.0	285.24	21.44
	120		273.0	278.31	25.40
	140		266.5	272.75	28.58
	160		257.0	264.45	33.32
14"	STD	362	336.5	337.88	9.53
	40		333.5	335.08	11.13

Nominal Pipe Size	Schedule Number or wall	Outside Diameter Cast Steel Valves	Nominal Inside Diameter	Machined Inside Diameter	Nominal Wall Thickness
		A	B	C	t
14"	XS	362	330.0	332.34	12.70
	60		325.5	328.15	15.09
	80		317.5	321.22	19.05
	100		308.0	312.86	23.83
	120		300.0	305.93	27.79
16"	140		292.0	299.00	31.75
	160		284.0	292.07	35.71
	STD	413	387.5	388.68	9.53
	40		381.0	383.14	12.70
	60		373.0	376.21	16.66
18"	80		363.5	367.84	21.44
	100		354.0	359.53	26.19
	120		344.5	351.18	30.96
	140		333.5	341.43	36.53
	160		325.5	334.50	40.49
	STD	464	438.0	439.48	9.53
20"	XS		432.0	433.94	12.70
	40		428.5	431.19	14.27
	60		419.0	422.82	19.05
	80		409.5	414.46	23.83
	100		398.5	404.78	29.36
	120		387.5	395.03	34.93
	140		378.0	386.77	39.67
	160		366.5	376.99	45.24
22"	STD	516	489.0	490.28	9.53
	XS		482.5	484.74	12.70
	40		478.0	480.55	15.09
	60		467.0	470.88	20.62
	80		455.5	461.13	26.19
	100		443.0	450.02	32.54
	120		432.0	440.29	38.10
	140		419.0	429.17	44.45
	160		408.0	419.44	50.01
	24"	STD	567	539.0	541.08
XS			533.0	535.54	12.70
60			514.0	518.86	22.23
80			501.0	507.75	28.58
100			488.5	496.63	34.93
120			476.0	485.52	41.28
140			463.0	474.41	47.63
160			450.5	463.30	53.98
24"	STD	619	590.5	591.88	9.53
	XS		584.0	586.34	12.70
	30		581.0	583.59	14.27
	40		574.5	577.97	17.48
	60		560.5	565.49	24.61
	80		547.5	554.38	30.96
	100		532.0	540.49	38.89
	120		517.5	528.03	46.02
	140		505.0	516.91	52.37
	160		490.5	504.37	59.54

NOTE: Dimensions are in millimeters.