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R 1128

STEEL TUBES

BUTT WELDING BENDS 5D (90° AND 180°)

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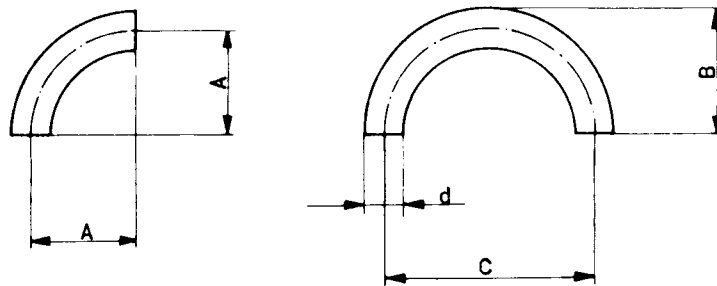
STEEL TUBES

BUTT WELDING BENDS 5D (90° and 180°)

1. SCOPE

This ISO Recommendation specifies the dimensions of steel butt welding bends (90° and 180°).

2. DIMENSIONS



$$B = A + \frac{d}{2}$$

$$C = 2A$$

The ratio between the radius of the bend and the outside diameter of the tube is approximately 2.5.

TABLE -- Dimensions of butt welding bends

Outside diameter <i>d</i>			Dimension A				Dimension B*				Dimension C			
mm	in		mm	in	mm	in	mm	in	mm	in	mm	in	mm	in
26.9	1.059		57.5	2.264			71	2.795			115	4.528		
30	—		62.5	2.461			77	3.032			125	4.921		
31.8	1.250		67.5	2.657			83	3.268			135	5.315		
33.7	1.327		72.5	2.854			89	3.504			145	5.709		
38	1.500		82.5	3.248			101	3.976			165	6.496		
42.4	1.669		92.5	3.642			114	4.488			185	7.283		
44.5	1.750		97.5	3.839			120	4.724			195	7.677		
48.3	1.900		107.5	4.232			132	5.197			215	8.465		
51	2.000		115	4.528	± 2.5	± 0.098	140	5.512			230	9.055	± 5	± 0.197
57	2.250		127.5	5.020			156	6.142			255	10.039		
60.3	2.375		135	5.315			165	6.496			270	10.630		
63.5	2.500		142.5	5.610			174	6.850			285	11.220		
70	2.750		160	6.299			195	7.677	± 8	± 0.315	320	12.598		
76.1	3.000		175	6.890			213	8.386			350	13.780		
82.5	3.250		190	7.480			231	9.094			380	14.961		
88.9	3.500		205	8.071			249	9.803			410	16.142		
101.6	4.000		237.5	9.350			288	11.339			475	18.701		
108	—		252.5	9.941			306	12.047			505	19.882		
114.3	4.500		270	10.630			327	12.874			540	21.260		
133	—		312.5	12.303	± 5	± 0.197	379	14.921			625	24.606	± 10	± 0.394
139.7	5.500		330	12.992			400	15.748			660	25.984		
159	—		375	14.764			454	17.874			750	29.528		
168.3	6.625		390	15.354	± 10	± 0.394	474	18.661			780	30.709	± 20	± 0.787
193.7	7.625		455	17.913			552	21.732			910	35.827		
219.1	8.625		510	20.079	± 12.5	± 0.492	619	24.370			1020	40.158	± 25	± 0.984
244.5	9.625		580	22.835			702	27.638			1160	45.669		
267	10.500		635	25.000			768	30.236			1270	50.000		
273	10.750		650	25.591	± 15	± 0.591	786	30.945			1300	51.181	± 30	± 1.181
323.9	12.750		775	30.512	± 17.5	± 0.689	937	36.890	± 12	± 0.472	1550	61.024	± 35	± 1.378
355.6	14.000		850	33.465			1028	40.472			1700	66.929		
368	14.500		880	34.646	± 20	± 0.787	1064	41.889			1760	69.291	± 40	± 1.575
406.4	16.000		970	38.189	± 25	± 0.984	1173	46.188			1940	76.378	± 50	± 1.968
419	16.500		1000	39.370			1209	47.598			2000	78.740		

* Dimension B is not adhered to except by special request.