GUJARAT GAS

DATA SHEET FOR FITTINGS

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DATA SHEET FOR SEAMLESS FITTINGS

Sr. No.	Description	Specification
GENERAL		
1	Size	0.5 to 24" NB
2	Schedule no./ Pressure Rating	
a)	Butt-welded fittings/ Weld-o-let	STD/XS/ XXS SCH.40, SCH 80, SCH 160
b)	Socket welded fittings, sock-o-let	3000#, 6000#
3	Design Standard	ASME B 16.9/ASME B 16.11/MSS SP 75/ MSS-SP 97/ ASME B1.20.1/ ASME B 16.48
4	Corrosion allowance	1.5MM
5	Design Factor	0.4
SERVICE CONDITIONS		
6	Service Fluid	Natural Gas
7	Design Pressure	19 Bar-g /49 Bar-g/98 Bar-g
8	Design Temperature	1. 150# : 0 to 65°C 2. 300# & 600# : -10 to 65°C
9	Operating Pressure(Maximum)	1. 150# = 16 Bar-g 2. 300# = 42 Bar-g 3. 600# = 90 Bar-g
10	Operating temp.	1. 150# = 0 to 50 °C 2. 300#,600#= -10 to 50 °C
CONSTRUCTION DESIGN		
11	Bevel angle	ASME B 31.8
MATERIAL SPECIFICATION		
	Part	**Specified Material**
12	Material of Construction	1. 150# = ASTM A 105, ASTM A 234 WPB, MSS SP 75 WPHY 52 2. 300# = ASTM A 350 Gr. LF2, ASTM A 420 Gr. WPL6, MSS SP 75 WPHY 52 3. 600# = ASTM A 350 Gr. LF2, ASTM A 420 Gr. WPL6, MSS SP 75 WPHY 52, MSS SP 75 WPHY 65 4. The carbon content is greater than 0.12% in product analysis, the CE (IIW) shall not exceed 0.40% and if The carbon content is less than 0.12% in product analysis, the CE (Pcm) shall not exceed 0.20%.

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TESTING & INSPECTION		
13	Proof test (Type Test)	ASME B 16.9
14	Charpy Impact Test	As per Material of construction standard. In case Charpy test value not specified in relevant codes and standards than charpy shall be carried out at 0 °C and absorbed energy value shall be average 35 j and minimum 28 j respectively.
15	Hardness test	• ASTM A 105 – 137 to 187 HB • ASTM A 350 Gr. LF2, A420 Gr. WPL6 & ASTM A 234 WPB – 197 HBW max • MSS SP 75 – 235 BHN max In case hardness value not given in MOC then hardness value shall not exceed 235 HBN
16	Tensile test	As per relevant code and standard
17	Yield strength (Minimum)	As per relevant code and standard
18	Elongation	As per relevant code and standard
20	UT	100% Surface
21	MPT	100% at Bevel Ends
22	DPT	100% bevel end for 50 mm width
23	Marking	MSS SP 25 and GGL Specification
NOTE:-		
1. Bidder shall clearly mention deviation, if any.		
2. Inspection and Testing shall be as per this Data Sheet, GGL Specification. Inspection shall be carried out by TPI at Manufacture's work as per QAP approved by GGL		
3. Vendor to submit QAP for approval prior to commencement of manufacturing		
4. Welded fittings shall be normalized and 100% radio-graphed.		
5. Welded fitting for size 16 inch and above may be acceptable subject to GGL review and approval		

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