



Standard Specification for the Performance of Fittings for Use with Gasketed Mechanical Couplings Used in Piping Applications¹

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1. Scope

1.1 This specification defines classification, materials, test requirements, inspection certification, marking and packaging of fittings for use with gasketed mechanical couplings complying to Specification F 1476.

2. Referenced Documents

2.1 ASTM Standards:

NOTE 1—See Table 1 for equivalency listing of applicable, equivalent specifications.

- A 47 Specification for Ferritic Maleable Iron Castings²
- A 48 Specification for Gray Iron Castings²
- A 53 Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated Welded and Seamless³
- A 153 Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware⁴
- A 216 Specification for Steel Castings, Carbon Suitable for Fusion for High-Temperature Service²
- A 234 Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and Elevated Temperatures³
- A 312 Specification for Seamless and Welded Austenitic Stainless Steel Pipe³
- A 403 Specification for Wrought Austenitic Stainless Steel Piping Fittings³
- A 536 Specification for Ductile Iron Castings²
- A 743 Specification for Castings, Iron-Chromium, Iron-Chromium-Nickel, Corrosion-Resistant for General Application²
- B 26 Specification for Aluminum-Alloy Sand Castings⁵
- B 75 Specification for Seamless Copper Tube⁶
- B 210 Specification for Aluminum and Aluminum-Alloy Drawn Seamless Tubes⁵
- B 369 Specification for Copper-Nickel Alloy Castings⁶
- B 584 Specification for Copper-Alloy Sand Castings for

TABLE 1 Specification Equivalency Table

Spec. Ref. Number	U.S. Designation ASTM	British Standard	ISO Standard
1	A 47	6681	5922
2	A 48	1452	—
3	A 53	3601	—
4	A 153	729	1459, 1460, 1461
5	A 216	3100	—
6	A 234	1640 Pt. 1	—
7	A 312	3605	—
8	A 403	1640 Pt. 2	—
9	A 536	4772	2531, 4179, 8179
10	A 743	3100	—
11	B 26	1490	3522, 7722
12	B 75	2871	—
13	B 210	1471	209
14	B 369	3071	—
15	B 584	1400	—
16	B 633	1706	2081
	ANSI		
17	B36.10	3600	4200
18	B36.19	3600	4200
	ANSI/AWWA		
19	C151/A21.51	4772	2531, 4179, 8179
20	C606	—	—
	MILITARY STANDARDS		
21	MIL-A-8625	—	—
22	MIL-T-704	—	—
23	MIL-STD-45662	5781	—

General Applications⁶

- B 633 Specification for Electrodeposited Coatings of Zinc on Iron and Steel⁷
- F 1476 Specification for the Performance of Gasketed Mechanical Couplings for Use in Piping Applications⁸

2.2 ANSI Standards:⁹

- B 36.10 Welded and Seamless Wrought Steel Pipe
- B 36.19 Stainless Steel Pipe

¹ This practice is under the jurisdiction of ASTM Committee F-25 on Ships and Marine Technology and is the direct responsibility of Subcommittee 25.13 on Piping Systems.

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² Annual Book of ASTM Standards, Vol 01.02.

³ Annual Book of ASTM Standards, Vol 01.01.

⁴ Annual Book of ASTM Standards, Vol 01.06.

⁵ Annual Book of ASTM Standards, Vol 02.02.

⁶ Annual Book of ASTM Standards, Vol 02.01.

⁷ Annual Book of ASTM Standards, Vol 02.05.

⁸ Annual Book of ASTM Standards, Vol 01.07.

⁹ Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

2.3 ANSI/AWWA Standards:⁹

C 151/A21.51 Ductile-Iron Pipe, Centrifugally Cast in Metal Molds or Sand-Lined Molds, for Water and Other Liquids

C 606-87 Grooved and Shouldered Joints

2.4 Military Standards:¹⁰

MIL-A-8625 Anodic Coatings, for Aluminum and Aluminum Alloys

MIL-T-704 Treatment and Painting of Material

MIL-STD-45662 Calibration System Requirements

2.5 British Standards:¹¹

BS 729 Specification for Hot Dip Galvanized Coatings on Iron and Steel Articles

BS 1400 Specification for Copper Alloy Ingots and Copper Alloy and High Conductivity Copper Castings

BS 1452 Specification for Flake Graphite Cast Iron

BS 1471 Specification for Wrought Aluminum and Aluminum Alloys for General Engineering Purposes—Drawn Tube

BS 1490 Specification for Aluminum and Aluminum Alloy Ingots and Castings for General Engineering Purposes

BS 1640 Pt. 1 Wrought Carbon and Ferritic Alloy Steel Fittings

BS 1640 Pt. 2 Wrought and Cast Austenitic Chromium—Nickel Steel Fittings

BS 1706 Method for Specifying Electroplated Coatings of Zinc and Cadmium on Iron and Steel

BS 2871 Specification for Copper and Copper Alloys—Tubes

BS 3071 Specification for Nickel—Copper Alloy Castings

BS 3100 Specification for Steel Castings for General Engineering Purposes

BS 3600 Specification for Dimensions of Steel Pipe for the Petroleum Industry

BS 3601 Specification for Carbon Steel Pipes and Tubes with Specified Room Temperature Properties for Pressure Purposes

BS 3605 Austenitic Stainless Steel Pipes and Tubes for Pressure Purposes

BS 4772 Specification for Ductile Iron Pipes and Fittings

BS 5781 Measurement and Calibration System

BS 6681 Specification for Malleable Cast Iron

2.6 International Standards Organization:¹²

209 Composition of Wrought Products of Aluminum and Aluminum Alloys . . . Chemical Composition (Percent)

1459 Metallic Coatings—Protection Against Corrosion by Hot Dip Galvanizing—Guiding Principles

1460 Metallic Coatings—Hot Dip Galvanized Coatings on Ferrous Materials—Determination of the Mass Per Unit Area—Gravimetric Method

1461 Metallic Coatings—Hot Dipped Galvanized Coatings on Fabricated Ferrous Products—Requirements

2081 Metallic Coatings—Electroplated Coatings of Zinc on Iron or Steel

2531 Ductile Iron Pipes, Fittings and Accessories for Pressure Pipe Lines

3522 Cast Aluminum Alloys—Chemical Composition and Mechanical Properties

4179 Ductile Iron Pipes for Pressure and Non-Pressure Pipelines—Centrifugal Cement Mortar Lining—General Requirements

4200 Plain End Steel Tubes, Welded and Seamless—General Tables of Dimensions and Masses Per Unit Length

5922 Malleable Cast Iron

7722 Aluminum Alloy Castings Produced by Gravity, Sand, or Chill Casting, or by Related Processes—General Conditions for Inspection and Delivery

8179 Ductile Iron Pipes—External Zinc Coating

3. Terminology

3.1 Definitions:

3.1.1 *fabricated fitting*—a fitting constructed by welding together sections of pipe or tube.

3.1.2 *fitting*—a device used in a piping system to change pipe direction, size, split or combine flows, or adapt to other joining methods.

3.1.3 *grooved end*—type of fitting or pipe end having a groove for use with grooved mechanical couplings (Type I) as defined in F 1476.

3.1.4 *pipe*—hollow tubular product conforming to Table 1 Specification Reference Nos. 17, 18, 19 and 12, Nominal Dimensions, or O.D. tube.

3.1.5 *plain end*—type of fitting or pipe end for use with a gasketed mechanical coupling (Type II) that is plain end as defined in Specification F 1476.

3.1.6 *tangent*—a section of straight pipe or tube integral to or welded to the end(s) of a fitting.

3.1.7 *wrought fitting*—a fitting made by shaping or shaping and welding.

4. Classification

4.1 These fittings are classified into the following design types:

4.1.1 *Type I*—Grooved end.

4.1.2 *Type II*—Plain end.

5. Ordering Information

5.1 Orders for fittings under this specification shall include the following:

5.1.1 Specification designation, title, number and year of issue.

5.1.2 Quantity.

5.1.3 Size and appropriate suffix (Example 8 in. IPS, 76.1 mm O.D.).

5.1.4 Fitting description (90° Elbow, Tee, Cross, etc.).

5.1.5 Type (I, II)—Type I must include groove style (that is, Standard, End Seal,¹³ AWWA Rigid, AWWA Flexible, or Copper).

⁹ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

¹¹ Available from British Standards Institution, 2 Park Street, London W1A 2BS.

¹² Available from ISO Central Secretariat, 1, rue de Varembe; Case postale 56; CH-1211 Geneve 20; Switzerland.

¹³ End seal is a registered trademark of the Victaulic Company of America.

5.1.6 Minimum pressure rating.

5.1.7 Material (ductile iron or steel, aluminum, copper nickel, copper, other, etc.) (see Section 6).

5.1.8 Finish (painted, galvanized, bare, plated, special coatings) (see Section 6).

5.1.9 Other requirements agreed to between purchaser and fitting manufacturer.

6. Materials and Manufacture

6.1 *Ferrous Materials*—Cast fittings shall be constructed of ductile iron in accordance with Table 1 Specification Reference 9 or Malleable Iron in accordance with Table 1 Specification Reference 1 or steel in accordance with Table 1 Specification Reference 5 or Cast Iron in accordance with Table 1 Specification Reference 2. Wrought fittings shall be made in accordance with Table 1 Specification Reference 6. Fabricated fittings and tangents shall be constructed of steel in accordance with Table 1 Specification Reference 3.

6.1.1 Fitting shall be bare, coated with manufacturer's standard preparation and paint, hot-dip galvanized in accordance with Table 1 Specification Reference 4 or other finish as agreed upon between purchaser and manufacturer.

6.2 *Aluminum Alloy Materials*—Fittings shall be constructed of aluminum alloy in accordance with Table 1 Specification Reference 11. Fabricated fittings shall be made from pipe in accordance with Table 1 Specification Reference 13.

6.2.1 Finish for aluminum alloy fittings shall be bare, anodized in accordance with Table 1 Specification Reference 21, painted in accordance with Table 1 Specification Reference 22 or as otherwise agreed between purchaser and manufacturer.

6.3 *Iron-Chromium-Nickel, Corrosion Resistance Materials*—Fittings shall be constructed of iron-chromium-nickel alloy in accordance with Table 1 Specification Reference 10, or Table 1 Specification Reference 8. Welded tangents and fabricated fittings shall be in accordance with Table 1 Specification Reference 7.

6.3.1 Finish for iron-chromium-nickel shall be bare or as otherwise agreed between purchaser and manufacturer.

6.4 Copper or brass, cast fittings shall be constructed of brass in accordance with Table 1 Specification Reference 15. Wrought fittings shall be constructed of copper in accordance with Table 1 Specification Reference 12.

6.4.1 Finish for copper or brass fittings shall be bare or as otherwise agreed between purchaser and manufacturer.

6.5 Copper-nickel cast fittings shall be constructed of copper-nickel in accordance with Table 1 Specification Reference 14 as applicable.

6.5.1 Finish for copper-nickel fittings shall be bare or as otherwise agreed between purchaser and manufacturer.

6.6 *Other Materials*—Where other materials are required, the material, mechanical properties and finish of the products shall be as agreed upon by the fitting manufacturer and the purchaser.

6.7 *Material Quality:*

6.7.1 The material shall be of such quality and purity that the finished product shall have the properties and characteristics to meet the performance requirements of this standard.

6.7.2 The manufacturer is encouraged to use materials produced from recovered materials to the maximum extent

practicable without jeopardizing the intended use. The term "recovered materials" means: "Materials which have been collected or recovered from solid waste and reprocessed to become a source of raw material, as opposed to virgin raw materials." Used or rebuilt products shall not be used.

7. Other Requirements

7.1 *Design Requirements:*

7.1.1 The design of the fittings may be qualified by mathematical analysis in accordance with piping codes agreed to by manufacturer and purchaser or by testing. Fittings that are tested shall be tested with gasketed mechanical couplings in accordance with the test requirements of Specification F 1476.

7.2 *Qualification Requirements:*

7.2.1 *Mathematical Analysis:*

7.2.1.1 A mathematical analysis, where appropriate, shall be performed as required by the governing piping code. Records of the analysis shall be available at the manufacturer's facility for inspection by the purchaser.

7.2.2 *Test:*

7.2.2.1 The fittings shall be tested, where appropriate, with gasketed mechanical couplings in accordance with the requirements of Specification F 1476. Unless otherwise noted herein, all requirements of Specification F 1476 apply. Records of successful tests shall be available at the manufacturer's facility for inspection by the purchaser.

7.2.3 Each type, pressure class, and material of fitting offered for sale must be qualified. Interpolation between qualified sizes is allowed as defined in Specification F 1476. Qualification of the fitting requires successful completion of the analysis or required testing. Each fitting design is only qualified for use with the GMC design on which it was tested or analyzed.

8. Dimensions, Mass and Permissible Variations

8.1 *Fitting Dimensions*—Fitting dimensions and tolerance shall be as specified by the manufacturer.

9. Workmanship, Finish and Appearance

9.1 All fitting surfaces shall be free from scale, blisters, fins, folds, seams, laps, burrs and cracks, which would affect the suitability for the intended service.

10. Inspection

10.1 *Terms of Inspection:*

10.1.1 Inspection of the fittings shall be in accordance with the manufacturer's standard inspection procedure or as agreed upon between the purchaser and the manufacturer or supplier as part of the purchase contract.

10.2 *Raw Material Inspection:*

10.2.1 Raw material shall be inspected for compliance with its material specification.

10.3 *Quality Conformance Inspection:*

10.3.1 Fitting samples shall be visually and dimensionally examined to verify compliance with the manufacturer's appropriate drawings.

10.4 *Process Control Inspection:*

10.4.1 Fittings shall be inspected throughout the entire manufacturing and processing cycle. Methods of inspection

shall be in compliance with manufacturer's quality assurance procedures.

10.5 Inspection Records:

10.5.1 Inspection records shall be maintained by the manufacturer. The length of time on file shall be in accordance with the manufacturer's quality assurance procedures.

11. Certification

11.1 Material Certification:

11.1.1 A certification of compliance shall be obtained from the materials supplier, when applicable. This certificate shall state that applicable requirements for the raw material have been satisfied.

12. Product Markings

12.1 Each fitting shall be marked with the manufacturer's

name or trademark, size, and markings traceable to the material and pressure rating.

13. Packaging

13.1 The fitting shall be boxed, crated, wrapped and otherwise protected during shipment and storage in accordance with manufacturer's standard practice. Care shall be taken to properly protect the fitting from damage during shipment and storage.

14. Keywords

14.1 fitting; grooved; marine; ship; tangent

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