

PIPE SPECIALS & FITTINGS

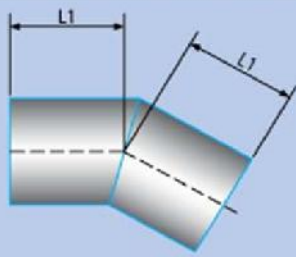


Figure 1: Gusseted bend type 1 not more than 30°

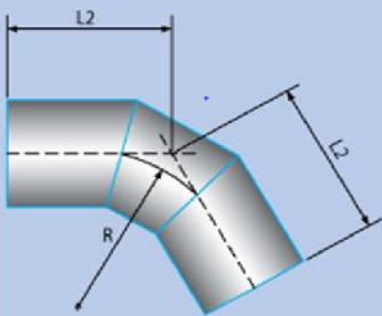


Figure 2: Gusseted bend type 2 over 30° upto 60°

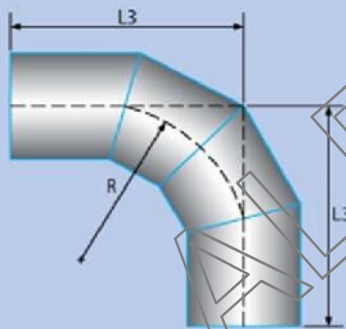


Figure 3: Gusseted bend type 3 over 60° up to 90°

Pipe N.D.	Pipe N.D.	Type 1	Type 2				Type 3	
		Not more than 30°	Over 30° to 45°		Over 45° to 60°		Over 60° to 90°	
mm	mm	L1	R	L2	R	L2	R	L3
100	114.3	175	150	200	150	250	150	300
150	168.3	225	225	300	225	300	225	400
200	219.1	300	300	350	300	400	300	500
250	273	375	375	450	375	500	375	650
300	323.9	375	450	450	450	500	450	700
350	355.6	450	525	550	525	600	525	800
400	406.4	450	600	600	600	600	600	850
450	457	450	675	600	450	600	450	850
500	508	450	750	600	500	600	500	850
550	559	450	825	650	550	600	550	850
600	610	550	900	750	600	750	600	1000
650	660	550	975	750	650	750	650	1000
700	711	550	1050	800	700	750	700	1100
750	762	600	1125	850	750	850	750	1100
800	813	600	1200	850	800	850	800	1200
850	864	600	1275	850	850	850	850	1200
900	914	600	1350	900	900	900	900	1300
1000	1016	750	1500	1100	1000	1100	1000	1500
1200	1219	850	1800	1200	1200	1200	1200	1700
1400	1422	850	2100	1300	1400	1300	1400	1900
1600	1626	900	2400	1400	1600	1400	1600	2100
1800	1829	900	2700	1500	1800	1500	1800	2200
2000	2032	1000	3000	1600	2000	1600	2000	2500
2200	2235	1000	3300	1700	2200	1700	2200	2600