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Welded Flange's Introduction

Welded flange is a kind of pipe flange, it means a flange has round pipe with neck and weld with pipe.

Range of application

Butt welding flange is not easy to deformation, good sealing, wide application, have corresponding rigid and elastic demand and reasonable butt thinning transition, joint good distance away from the joint face the faying surface from welding deformation temperature, it take more complex syndromes beep form structure, suitable for pressure or temperature fluctuations of pipeline or high temperature, high pressure and low temperature pipes, commonly used in PN is greater than 2.5 MPa pipe and valve connection;It is also used to transport expensive, flammable and explosive tubes.



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First, the level of welding flanges and their technical requirements shall comply with the corresponding requirements of JB4726-4728. 1, nominal pressure PN for 0.25MPa-1.0MPa carbon steel, austenitic stainless steel forgings, allowing the use of grade I forgings. 2, in addition to the following provisions, the nominal pressure of PN 1.6MPa-6.3MPa forgings shall meet the requirements of secondary or secondary forgings. 3, in line with one of the following conditions, and shall comply with the requirements of forging III: (1) PN = 10.0MPa nominal pressure flange forgings; (2) the nominal pressure $PN > 4.0\text{MPa}$ chrome molybdenum steel forgings; (3) $PN > 1.6\text{MPa}$ nominal pressure and the working temperature is less than or equal to -20 degrees Celsius ferritic steel forgings.

2 The welding flanges are usually made of forging or forging technology. The steel plate directly machined into the butt welding neck flange butt weld shall not;

3, the ring should be used in full penetration weld butt weld;

4, the ring should be post weld heat treatment, and 100% X-ray or ultrasonic inspection and radiographic inspection conforms to the II class JB4730 requirements, ultrasonic detection with JB4730 I request.

The outer slope of the neck of the butt weld flange shall not be greater than 70° . The welding flange strictly controls the technical parameters during production and welding, and ensures the full function and value of the welding flange in production and use.

Marks and uses

In the pipeline project, mainly used for pipeline flange connection. The need to connect the pipe, flange mounted with a low-pressure pipe can use wire connecting flange, the use of more than 4 kilograms of pressure welding flange. Between the two flange and gasket and bolt fastening.

Flange standard:

美标: ANSI B16.5 150LB,400LB, 300LB,600LB, 900LB, 1500LB, 2500LB

德标: DIN PN6, PN10, PN16, PN25, PN40, PN64, PN100

日标: JIS 5K, 10K, 16K,20K,30K,40K, 63K

英标: BS4504 PN6, PN10, PN16, PN25, PN40

意标: UNI PN6, PN10, PN16, PN25, PN40, PN64, PN100, PN160, PN250

欧标: EN1092 PN6, PN10, PN16, PN25, PN40, PN63, PN100

俄标: GOST PN0.6, PN1.0, PN1.6, PN2.5, PN4.0, PN6.3, PN10

国标: GB/T9115(9) PN0.25, PN0.6, PN1.0, PN1.6, PN2.0, PN2.5, PN4.0, PN5.0, PN6.3, PN10,PN15, PN16

ANSI CLASS	MPA	BAR
150	2.0	20
300	5.0	50
400	6.8	68
600	10.0	100
800	13.5	135
900	16.0	160
1500	25.0	250
2500	42.0	420
3000	50.5	505

公称压力MPa	0.6 MPa 1.0 MPa 1.6 MPa 2.0 MPa	2.5 MPa 4.0 MPa 5.0 MPa	6.4 MPa	10.0 MPa	15.0MPa	25.0MPa	42.0MPa
公称压力PN	PN 6 PN 10 PN 16 PN20	PN 25 PN 40 PN50	PN64	PN100	PN150	PN250	PN420