

Welded Joint

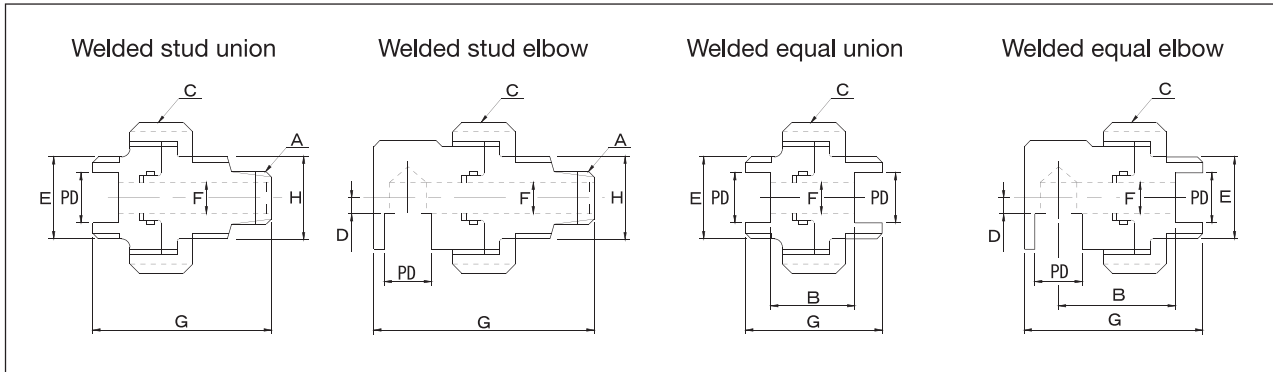


Description of the type Maximum operating pressure 70 MPa

S U W — **1 / 2** — Compatible pipe diameter

Shape

- SUW : Welded stud union
- SLW : Welded stud elbow
- EUW : Welded equal union
- ELW : Welded equal elbow

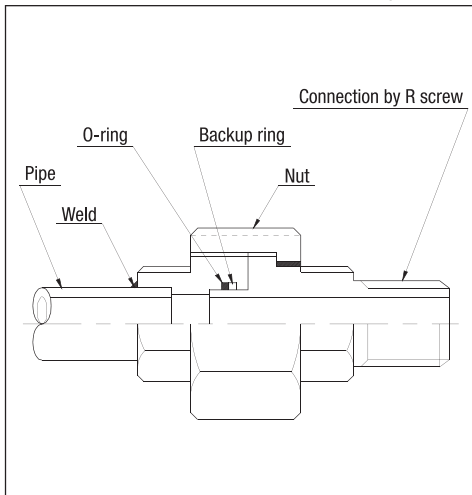


Dimension list

Item name	Welded stud union			Welded stud elbow			Welded equal union			Welded equal elbow		
Type	SUW-1/2	SUW-3/4	SUW-1	SLW-1/2	SLW-3/4	SLW-1	EUW-1/2	EUW-3/4	EUW-1	ELW-1/2	ELW-3/4	ELW-1
Pipe nominal diameter	1/2	3/4	1	1/2	3/4	1	1/2	3/4	1	1/2	3/4	1
PD	21.7	27.2	34.0	21.7	27.2	34.0	21.7	27.2	34.0	21.7	27.2	34.0
A (R)	1/2	3/4	1	1/2	3/4	1	-					
B	-						50	55	58	65	70	85
C (Width across flats)	54	65	79	54	65	79	54	65	79	54	65	79
D	-			7	8	12	-			7	8	12
E (Width across flats)	35	42	51	-			35	42	51	-		
φ F	11	14	18	11	14	18	11	14	18	11	14	18
G (Overall length)	105	110	120	125	135	155	80	85	90	100	110	125
H (Width across flats)	30	35	46	30	35	46	-					
O-ring	P20	P24	P30	P20	P24	P30	P20	P24	P30	P20	P24	P30

※The joint for a nominal pipe diameter of 1 1/4 is also available. Contact us for more details.

Work method of welded joint



- (1) After cutting the pipe, cut off the edges of the cut surface and clean it.
- (2) Remove the attached packing and keep it.
- (3) Set the position by tack welding.
- (4) Perform arc welding. A welding rod JISD5016 or D5826 improves workability.
Preheat the surface to 100 to 200° C before welding. Prevent the catching of slag or undercutting during welding. Weld the surface to a concave shape and disperse the concentration of stress, and fillet-weld fully to the corner of the joint body in two or three layers.
- (5) Clean the joint after welding and attach the O-ring and backup ring correctly after cooling to normal temperature.
- (6) Connect the joint.
- (7) When all the piping is completed, flush the pipe and conduct a pressure proof test. In the pressure proof test, apply the pressure in several stages from the low-pressure to high-pressure stages and check the oil leakage. Tighten the cap nut after applying the pressure a couple of times at maximum pressure.
- (8) After starting operation, check the oil leakage and cap nut looseness on a regular basis, and if any trouble is found, take appropriate measures immediately.