

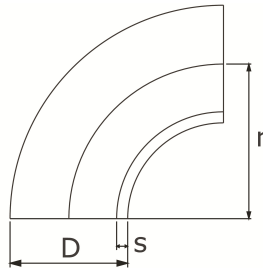


Bend 90° Type 3D

welded from two half shells

EN 10253-3, matte pickled

short name: 3B.2*



technical product sheet

D	s	r	kg	Art.-Nr.
457,2	3,0	686,0	36,760	3B-457-030
457,2	4,0	686,0	48,910	3B-457-040
508,0	4,0	762,0	62,000	3B-508-040
508,0	5,0	762,0	75,000	3B-508-050
610,0	4,0	914,0	87,000	3B-610-040
610,0	5,0	914,0	108,000	3B-610-050
711,2	4,0	1067,0	119,000	3B-711-040
711,2	5,0	1067,0	152,000	3B-711-050

available material: ask

Bends > Type 3D, $r=1,5 \times D$ > 3D 90° > DN > 400



Welded bends 90°

Feature

- welded form 2 half shells acc. DIN EN 10253 Part 3
- Design A (reduced utilization factor)
- Type 3D (bend radius = ca. 1,5x clear pipe diameter)
- materials 1.4307/ AISI 304L - 1.4571
- matte pickled
- without heat treatment, without pressure test
- smooth, square-cut ends acc. EN 29 692 1.2
- with certificate 3.1

Dimensional range

DN	Outer-Ø (mm)	Wall thickness (mm)
125	139,7	2,0 - 6,0
150	168,3	2,0 - 6,0
200	216 und 219,1	2,0 - 8,0
250	267 und 273,0	2,0 - 8,0
300	318 und 323,9	2,0 - 10,0
350	368 und 355,6	2,0 - 10,0
400	406,4 und 419	2,5 - 10,0
450	457,2	2,5 - 10,0
500	508,0	3,0 - 10,0
600	609,6	4,0 - 10,0
700	711,2	5,0 - 10,0

EN 10253

Butt-welding Fittings

This European Standard specifies the technical delivery conditions for welded fittings for butt welding made of austenitic and austenitic-ferritic (duplex-) stainless steel, intended for pressure- and corrosion-resistant applications at ambient temperature, low temperature, or elevated temperatures.

Comparison of designations according to the old DIN and new EN standards:

DIN	EN
DIN 2605	EN 10253-3
DIN 2609	EN 10253-4

Weld factor

Norm	Weld factor
EN 10253-3	V=0,7
EN 10253-4	V=1,0

Utilization factor

Norm	Utilization factor*
Typ A	reduced
Typ B	full

(*) = Wall thickness at the reduced section

Design pressure

Outer-Ø	Wall thickness	bar
139,7	2,0	20
139,7	2,6	26
139,7	3,0	29
139,7	4,0	40
154,0	2,0	19
156,0	3,0	28
158,0	4,0	38
168,3	2,0	16
168,3	2,6	21
168,3	3,0	24
168,3	4,0	33
168,3	5,0	42
204,0	2,0	14
205,0	2,5	18
206,0	3,0	21
208,0	4,0	27
210,0	5,0	34
219,1	2,0	13
219,1	2,6	17
219,1	3,0	18
219,1	4,0	26
219,1	5,0	32
254,0	2,0	11
255,0	2,5	14
256,0	3,0	14
258,0	4,0	22
260,0	5,0	27
273,0	2,0	10
273,0	2,5	13
273,0	3,0	15
273,0	4,0	20
273,0	5,0	26
273,0	6,0	31

The design pressure was determined for material 1.4307 at +20°C in acc. with EN 10253-3, Type A

Design pressure

Outer-Ø	Wall thickness	bar
304,0	2,0	9
305,0	2,5	11
306,0	3,0	14
308,0	4,0	19
310,0	5,0	23
312,0	6,0	25
323,9	2,0	8
323,9	3,0	12
323,9	4,0	17
323,9	5,0	22
323,9	6,0	26
355,6	3,0	11
355,6	4,0	16
355,6	5,0	20
355,6	6,0	24
358,0	4,0	16
406,4	3,0	10
406,4	4,0	14
406,4	5,0	17
406,4	6,0	21
408,0	4,0	14
456,0	3,0	9
457,0	3,0	9
457,0	4,0	12
457,0	5,0	15
457,0	6,0	17
506,0	3,0	8
508,0	4,0	11
508,0	5,0	14
508,0	6,0	17
606,0	3,0	8
608,0	4,0	9
610,0	3,0	7
610,0	4,0	9
610,0	5,0	12
610,0	6,0	14
610,0	8,0	17

The design pressure was determined for material 1.4307 at +20°C in acc. with EN 10253-3, Type A

Tolerances

Description	Tolerance limits
[D] Diameter	$\pm 1,0 \%$ or $0,5 \text{ mm}^{**}$ (EN tolerance class D2)
[R] Radius	$\leq D \ 219,1 \text{ mm} \ \pm 2,0 \text{ mm} \ / \ \leq D \ 762 \text{ mm} \pm 5,0 \text{ mm}$
[T] Wall thickness	$-12,5\% \ / \ +15\%$
[X] Squareness, Axiality	1% of the outer- $\varnothing$ or 1 mm^{**}

* $\leq D \ 610 \text{ mm}$

** the higher value applies Wert

