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ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 1128

STEEL TUBES

BUTT WELDING BENDS 5D (90° AND 180°)

1st EDITION

October 1969

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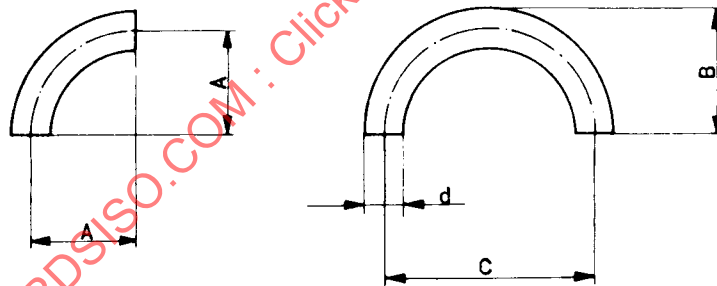
STEEL TUBES

BUTT WELDING BENDS 5D (90° and 180°)

1. SCOPE

This ISO Recommendation specifies the dimensions of steel butt welding bends (90° and 180°).

2. DIMENSIONS



$$B = A + \frac{d}{2}$$

$$C = 2A$$

The ratio between the radius of the bend and the outside diameter of the tube is approximately 2.5.

TABLE -- Dimensions of butt welding bends

Outside diameter <i>d</i>		Dimension A				Dimension B*				Dimension C			
mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in
26.9	1.059	57.5	2.264	71	2.795	115	4.528	115	4.528	115	4.528	115	4.528
30	—	62.5	2.461	77	3.032	125	4.921	125	4.921	125	4.921	125	4.921
31.8	1.250	67.5	2.657	83	3.268	135	5.315	135	5.315	135	5.315	135	5.315
33.7	1.327	72.5	2.854	89	3.504	145	5.709	145	5.709	145	5.709	145	5.709
38	1.500	82.5	3.248	101	3.976	165	6.496	165	6.496	165	6.496	165	6.496
42.4	1.669	92.5	3.642	114	4.488	185	7.283	185	7.283	185	7.283	185	7.283
44.5	1.750	97.5	3.839	120	4.724	195	7.677	195	7.677	195	7.677	195	7.677
48.3	1.900	107.5	4.232	132	5.197	215	8.465	215	8.465	215	8.465	215	8.465
51	2.000	115	4.528	140	5.512	230	9.055	230	9.055	230	9.055	230	9.055
57	2.250	127.5	5.020	156	6.142	255	10.039	255	10.039	255	10.039	255	10.039
60.3	2.375	135	5.315	165	6.496	270	10.630	270	10.630	270	10.630	270	10.630
63.5	2.500	142.5	5.610	174	6.850	285	11.220	285	11.220	285	11.220	285	11.220
70	2.750	160	6.299	195	7.677	320	12.598	320	12.598	320	12.598	320	12.598
76.1	3.000	175	6.890	213	8.386	350	13.780	350	13.780	350	13.780	350	13.780
82.5	3.250	190	7.480	231	9.094	380	14.961	380	14.961	380	14.961	380	14.961
88.9	3.500	205	8.071	249	9.803	410	16.142	410	16.142	410	16.142	410	16.142
101.6	4.000	237.5	9.350	288	11.339	475	18.701	475	18.701	475	18.701	475	18.701
108	—	252.5	9.941	306	12.047	505	19.882	505	19.882	505	19.882	505	19.882
114.3	4.500	270	10.630	327	12.874	540	21.260	540	21.260	540	21.260	540	21.260
133	—	312.5	12.303	379	14.921	625	24.606	625	24.606	625	24.606	625	24.606
139.7	5.500	330	12.992	400	15.748	660	25.984	660	25.984	660	25.984	660	25.984
159	—	375	14.764	454	17.874	750	29.528	750	29.528	750	29.528	750	29.528
168.3	6.625	390	15.354	474	18.661	780	30.709	780	30.709	780	30.709	780	30.709
193.7	7.625	455	17.913	552	21.732	910	35.827	910	35.827	910	35.827	910	35.827
219.1	8.625	510	20.079	619	24.370	1020	40.158	1020	40.158	1020	40.158	1020	40.158
244.5	9.625	580	22.835	702	27.638	1160	45.669	1160	45.669	1160	45.669	1160	45.669
267	10.500	635	25.000	768	30.236	1270	50.000	1270	50.000	1270	50.000	1270	50.000
273	10.750	650	25.591	786	30.945	1300	51.181	1300	51.181	1300	51.181	1300	51.181
323.9	12.750	775	30.512	937	36.890	1550	61.024	1550	61.024	1550	61.024	1550	61.024
355.6	14.000	850	33.465	1028	40.472	1700	66.929	1700	66.929	1700	66.929	1700	66.929
368	14.500	880	34.646	1064	41.889	1760	69.291	1760	69.291	1760	69.291	1760	69.291
406.4	16.000	970	38.189	1173	46.188	1940	76.378	1940	76.378	1940	76.378	1940	76.378
419	16.500	1000	39.370	1209	47.598	2000	78.740	2000	78.740	2000	78.740	2000	78.740

* Dimension B is not adhered to except by special request.

BRIEF HISTORY

The ISO Recommendation R 1128, *Steel tubes – Butt welding bends 5D (90° and 180°)*, was drawn up by Technical Committee ISO/TC 5, *Pipes and fittings*, the Secretariat of which is held by the Association Suisse de Normalisation (SNV).

Work on this question led to the adoption of a Draft ISO Recommendation.

In January 1968, this Draft ISO Recommendation (No. 1494) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	India	Spain
Belgium	Israel	Sweden
Brazil	Italy	Switzerland
Canada	Netherlands	Thailand
Chile	New Zealand	Turkey
Colombia	Norway	U.A.R.
Denmark	Poland	U.S.S.R.
France	Portugal	
Germany	South Africa, Rep. of	

Three Member Bodies opposed the approval of the Draft :

Czechoslovakia
Hungary
United Kingdom

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in October 1969, to accept it as an ISO RECOMMENDATION.

cancelled

ISO

ORGANISATION INTERNATIONALE DE NORMALISATION

RECOMMANDATION ISO R 1128

TUBES EN ACIER

COURBES À SOUDER 5D (90° ET 180°)

1^{ère} ÉDITION

Octobre 1969

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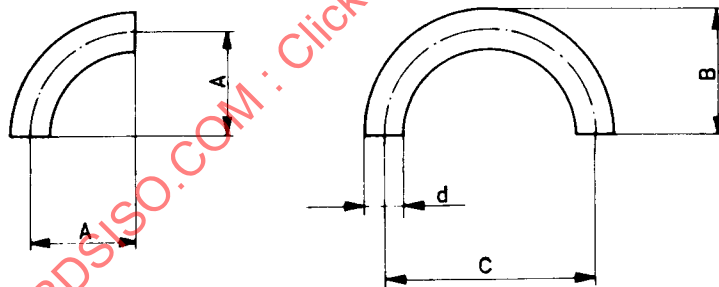
TUBES EN ACIER

COURBES À SOUDER 5D (90° et 180°)

1. OBJET

La présente Recommandation ISO fixe, comme suit, les dimensions des courbes à souder en acier (90° et 180°).

2. DIMENSIONS



$$B = A + \frac{d}{2}$$

$$C = 2A$$

Le rapport entre le rayon de courbure et le diamètre extérieur du tube est d'environ 2,5.