PIPING CLASS: AC1P6B-FH

SECTION 1.0 – GENERAL

PIPE CLASS:	**AC1P6B-FH**	**DESIGN CODE:**	ASME B31.3
RATING:	150	**PWHT:**	YES(NOTE 59)
FLANGE FACE:	RF	**VALVE TRIM:**	13Cr+HF/ SS316+HF
BASIC MATERIAL:	CARBON STEEL (GROUP 1.1)	**SOUR:**	NO
CORROSION ALLOWANCE:	6.0 MM	**SPECIAL REQUIREMENT:**	AMINE SERVICE API RP 945

TEMPERATURE (DEG.C) AND PRESSURE (BARG) RATING - (NOTE-22)

TEMP.	-29	0	38	50	100	150	200	250	300
PRESS.	19.6	19.6	19.6	19.2	17.7	15.8	13.8	12.1	10.2

SERVICE

REFER TO PIPING CLASS INDEX

SIZE RANGE, PIPE WALL THICKNESS (MM) TABLE - (NOTE-80)

NPS	½	¾	1	1 ½	2	3	4	6	8	10	12
SCHEDULE	-	-	XXS	XXS	XXS	160	120	80	80	60	60
THICKNESS	8.70	8.70	9.09	10.15	11.07	11.13	11.13	10.97	12.70	12.70	14.27

NPS	14	16	18	20	24	30	36	42	48
SCHEDULE	40	40	XS	XS	XS	-	-	-	-
THICKNESS	11.13	12.70	12.70	12.70	12.70	CALC	CALC	CALC	CALC

PIPING CLASS: AC1P6B-FH

SECTION 2.0 - NOTES

GENERAL NOTES

1. IN LINE WITH AGES-GL-08-001 (PROCESS DESIGN BASIS) THE MINIMUM PIPING SIZE IS NPS 1. HOWEVER, THE LINE SIZE IN THIS CLASS NPS 3/4 & NPS 1/2 ARE INCLUDED FOR INSTRUMENT CONNECTIONS ONLY.
2. ALL BUTT-WELDED COMPONENT THICKNESSES SHALL MATCH THE PIPE THICKNESS.
3. FOR SPECTACLE BLINDS (FIG-8 FLANGES) & BLINDS REFER TO SPECIFICATION AGES-SP-09-002.

16. ALL VALVES IN SOUR OR TOXIC OR HYDROCARBON SERVICE SHALL MEET FUGITIVE EMISSION TESTING REQUIREMENTS AS PER BS EN ISO 15848 PART-1 & PART-2 WITH LEAKAGE CLASS 'BH' (REFER TO VALVE SPECIFICATION AGES-SP-09-003).

22. ALL PIPING COMPONENTS UPTO NPS 24 SHALL BE DESIGNED FOR VACUUM CONDITION AT AMBIENT TEMPERATURE. FOR HIGHER SIZES VACUUM DESIGN SHALL BE APPLICABLE IF INDICATED IN THE LINELIST.

31. FOR CS & LTCS WELDED PIPE USED IN DOWNSTREAM SOUR & SEVERE SERVICE APPLICATION I.E. NACE MR0103/ISO 17945, ASTM A671-CC65 CLASS 32 & ASTM A672-C65 CLASS 32 SHALL BE USED RESPECTIVELY IN PLACE OF ASTM A671-CC65 CLASS 22 & ASTM A672-C65 CLASS 22

33. TO BE USED FOR FLANGED CLASS 300 RF CONNECTION.

43. THREADED JOINTS ARE NOT PERMITTED.

54. COMPLETE ORIFICE ASSEMBLY SHALL BE SUPPLIED WITH PAIR OF ORIFICE FLANGES EACH HAVING ONE NPS 1/2 FLANGED TAP (RATING SAME AS PIPE CLASS).

59. FOR AMINE SERVICE, CARBON STEEL PIPING AND PIPING COMPONENT WELDS INCLUDING ATTACHMENTS IRRESPECTIVE OF WALL THICKNESS, DIAMETER, GEOMETRY AND KIND, THE WELD SHALL BE POST WELD HEAT TREATED. API RP945 RECOMMENDATIONS SHALL BE APPLIED FOR AMINE SERVICE PIPING INCLUDING CLOSURE WELDS.

70. LOW STRESS SPIRAL WOUND GASKET.

71. TO BE USED ONLY WHEN INDICATED ON THE P&ID.

73. NIPOFLANGE SHALL BE USED FOR THERMOWELL CONNECTION FOR HEADER NPS 4 AND ABOVE.

74. FOR BOLT COATING ABOVE 200 DEG C SUITABLE PROPRIETARY COATINGS WITH PRIOR COMPANY APPROVAL SHALL BE PROPOSED.

75. CORROSION ALLOWANCE OF PIPE CLASS IS ABOVE 3.0 MM. MINIMUM BODY WALL THICKNESS OF VALVES SHALL HAVE ADDITIONAL WALL THICKNESS CONSIDERING THE CORROSION ALLOWANCE SPECIFIED IN THE PIPE CLASS IN EXCESS OF ASME B16.34 REQUIREMENTS.

80. THE PIPE THICKNESS ARE CALCULATED BASED ON P-T RATING TABLE FOR THIS CLASS, HOWEVER FOR SIZES NPS 26 AND ABOVE THICKNESS SHALL BE CALCULATED BASED ON PROJECT PROCESS DESIGN PARAMETER.

81. PIPING CLASS COVERS ALL TYPES OF VALVES NORMALLY USED IN THE INDUSTRY. HOWEVER, VALVE TYPE SELECTION SHALL BE AS PER PROCESS ISOLATION PHILOSOPHY (AGES-PH-08-001, AGES-SP-09-003) AND P&ID.

82. WELDED PIPES AND WELDED FITTINGS SHALL BE 100% RADIOGRAPHED. WALL THICKNESS NEGATIVE TOLERANCES OF WELDED FITTINGS SHALL NOT BE LESS THAN WELDED PIPE.

83. WHEN SMALL END OF REDUCER IS NPS 16 & BELOW THE REDUCER SHALL BE SEAMLESS.

85. SMALL BORE PIPE THE MINIMUM SCHEDULE SHALL BE AS PER AGES-SP-09-001 APPENDIX A1.

86. DISSIMILAR FLANGE MATERIAL SHALL BE SEPERATED USING INSULATING GASKET, ONLY TO BE USED WHEN STATED IN CORROSION REPORT AND IN P&ID OR OTHERWISE WITH COMPANY APPROVAL. FOR HYDROCARBON SERVICE FIRE SAFE INSULATING GASKET IS MANDATORY (REFER AGES-SP-09-005 FOR INSULATING GASKET DETAILS).

87. ALL BUTTERFLY VALVES IN HYDROCARBON & CRITICAL SERVICE SHALL BE TRIPLE OFFSET TYPE. FOR TRIPLE OFFSET BUTTERFLY VALVE, SHORT / LONG PATTERN SHALL BE DECIDED BASED ON LAYOUT REQUIREMENTS. FOR UTILITY SERVICES DOUBLE OFFSET BUTTERFLY CAN BE CONSIDERED.

90. PIPING TO INSTRUMENT IDBB, FLANGED ON BOTH PROCESS SIDE AND INSTRUMENT SIDE.TO BE USED IN SOUR, TOXIC, SULPHURIC ACID AND VIBRATING SERVICE.

PIPING CLASS: AC1P6B-FH

SECTION 3.0 – BRANCH TABLE

90^0 BRANCH CONNECTIONS

BRANCH PIPE (NPS)	1/2	3/4	1	1 ½	2	3	4	6	8	10	12	14	16	18	20	24	30	36	42	48
48																				E
42																			E	T
36																		E	T	T
30																	E	T	T	T
24																E	T	T	T	T
20															E	T	T	T	T	TR
18														E	T	T	T	T	T	TR
16													E	T	T	T	T	T	T	TR
14												E	T	T	T	T	T	TR	TR	TR
12											E	T	T	T	T	T	T	TR	TR	TR
10										E	T	T	T	T	T	T	T	TR	TR	TR
8									E	T	T	T	T	T	T	W	W	W	W	W
6								E	T	T	T	T	T	W	W	W	W	W	W	W
4							E	T	T	T	W	W	W	W	W	W	W	W	W	W
3						E	T	T	W	W	W	W	W	W	W	W	W	W	W	W
2					E	T	T	W	W	W	W	W	W	W	W	W	W	W	W	W
1 ½				E	T	T	T	W	W	W	W	W	W	W	W	W	W	W	W	W
1			E	T	T	W	W	W	W	W	W	W	W	W	W	W	W	W	W	W
3/4		E	T	T	T	W	W	W	W	W	W	W	W	W	W	W	W	W	W	W
1/2	E	T	T	T	TR	W	W	W	W	W	W	W	W	W	W	W	W	W	W	W
	1/2	3/4	1	1 ½	2	3	4	6	8	10	12	14	16	18	20	24	30	36	42	48
	HEADER PIPE (NPS)																			

LEGEND (STANDARD SYMBOLOGY)

C	CALCULATION IN ACCORDANCE WITH ASME B31.3
E	EQUAL TEE
T	REDUCING TEE
TR	REDUCING TEE + REDUCER
W	WELDOLET

PIPING CLASS: AC1P6B-FH

SECTION 4.0 – PIPING COMPONENTS

COMPONENT (TYP)	NPS (INCH)		END	DESCRIPTION	DIM/ MFG STD.	MATERIAL STD.	NOTES
	FROM	TO					
PIPE							
PIPE	½	16	BE	SEAMLESS	B36.10	ASTM A106 GR.B	1,27,85
PIPE	18	48	BE	WELDED	B36.10	ASTM A672 GR.C65 CL.22	27,31,82
NIPPLE	2	2	BE	AS PIPE, L=100mm	B36.10	ASTM A106 GR.B	27,85
FITTINGS							
ELBOW	½	16	BE	90 DEGREE, LR, WROUGHT, SEAMLESS	B16.9	ASTM A234 GR. WPB-S	2,27
ELBOW	18	48	BE	90 DEGREE, LR, WROUGHT, WELDED	B16.9	ASTM A234 GR. WPB-W	2,27,82
ELBOW	½	16	BE	45 DEGREE, LR, WROUGHT, SEAMLESS	B16.9	ASTM A234 GR. WPB-S	2,27
ELBOW	18	48	BE	45 DEGREE, LR, WROUGHT, WELDED	B16.9	ASTM A234 GR. WPB-W	2,27,82
REDUCER	¾	16	BE	CONCENTRIC, WROUGHT, SEAMLESS	B16.9	ASTM A234 GR. WPB-S	2,27
REDUCER	18	48	BE	CONCENTRIC, WROUGHT, WELDED	B16.9	ASTM A234 GR. WPB-W	2,27,82, 83
REDUCER	¾	16	BE	ECCENTRIC, WROUGHT, SEAMLESS	B16.9	ASTM A234 GR. WPB-S	2,27
REDUCER	18	48	BE	ECCENTRIC, WROUGHT, WELDED	B16.9	ASTM A234 GR. WPB-W	2,27,82, 83
CAP	½	48	BE	WROUGHT, SEAMLESS	B16.9	ASTM A234 GR. WPB-S	2,27

PIPING CLASS: AC1P6B-FH

COMPONENT (TYP)	NPS (INCH)		END	DESCRIPTION	DIM/ MFG STD.	MATERIAL STD.	NOTES
	FROM	TO					
BRANCH FITTINGS							
TEE	½	16	BE	EQUAL, WROUGHT, SEAMLESS	B16.9	ASTM A234 GR. WPB-S	2,27
TEE	18	48	BE	EQUAL WROUGHT, WELDED	B16.9	ASTM A234 GR. WPB-W	2,27,82
TEE	¾	16	BE	REDUCING, WROUGHT, SEAMLESS	B16.9	ASTM A234 GR. WPB-S	2,27
TEE	18	48	BE	REDUCING, WROUGHT, WELDED	B16.9	ASTM A234 GR. WPB-W	2,27,82
WELDOLET	½	8	BE	FORGED, SCH AS PIPE	MSS SP-97	ASTM A105N	27
FLANGES							
WELDNECK	½	24	RF	CL.150	B16.5	ASTM A105N	2,27
WELDNECK	30	48	RF	CL.150	B16.47-A	ASTM A105N	2,27
WELDNECK	½	24	RF	CL.300	B16.5	ASTM A105N	2,27,33
WELDNECK	30	48	RF	CL.300	B16.47-A	ASTM A105N	2,27,33
NIPOFLANGE	1	2	RF	CL.150, L=150 MM	B16.5	ASTM A105N	2,27,73
BLIND	½	24	RF	CL.150	B16.5	ASTM A105N	27
BLIND	30	48	RF	CL.150	B16.47 – A	ASTM A105N	27
ORIFICE	2	24	RF	CL.300	B16.36	ASTM A105N	2,27,54
LINE BLINDS							
LINE BLIND	½	10	RF	CL.150, SPECTACLE BLIND	B16.48	ASTM A516 GR.70	3,27
LINE BLIND	12	24	RF	CL.150, SPADE & SPACER	B16.48	ASTM A516 GR.70	3,27
LINE BLIND	30	48	RF	CL.150, SPADE & SPACER	MFG STD.	ASTM A516 GR.70	3,27

PIPING CLASS: AC1P6B-FH

COMPONENT (TYP)	NPS (INCH)		END	DESCRIPTION	DIM/ MFG STD.	MATERIAL STD.	NOTES
	FROM	TO					
GASKETS							
GASKET	½	24	-	CL.150, SPIRAL WOUND, 4.5MM THK.	B16.20/ B16.5	SP. WINDING + INNER RING: SS316, FILLER: GRAPHITE, CS OUTER RING, LOW STRESS	70
GASKET	30	48	-	CL.150, SPIRAL WOUND, 4.5MM THK.	B16.20/ 16.47 – A	SP. WINDING + INNER RING: SS316, FILLER: GRAPHITE, CS OUTER RING, LOW STRESS	70
GASKET	½	24	-	CL.300, SPIRAL WOUND, 4.5MM THK.	B16.20/ B16.5	SP. WINDING + INNER RING: SS316, FILLER: GRAPHITE, CS OUTER RING	33
GASKET	30	48	-	CL.300, SPIRAL WOUND, 4.5MM THK	B16.20/ 16.47 – A	SP. WINDING + INNER RING: SS316, FILLER: GRAPHITE, CS OUTER RING	33
INSULATING GASKET	2	24	-	CL.150, RF FLANGE INSULATING GASKET SET, FULL FACE	MANF. STD.	GASKETS AND WASHERS SS316 CORE LAMINATED WITH DIELECTRIC COATING SUITABLE FOR DESIGN CONDTIONS	86
BOLTS							
STUD BOLT & NUTS	½	48	-	STUD BOLT C/W 2 HEAVY HEX. NUTS	B18.2.1/ B18.2.2	STUD: ASTM A193 GR. B7, ASTM A194 GR. 2H	15,74

PIPING CLASS: AC1P6B-FH

SECTION 5.0 - VALVES

COMPONENT (TYP)	NPS (INCH)		END	DESCRIPTION	DIM/ MFG STD.	MATERIAL STD.	NOTES
	FROM	TO					
VALVES (NOTE -81)							
CHECK	½	1 ½	RF	CL.150, FLGD TO B16.5, SPRING LOADED LIFT CHECK, BOLTED COVER	BS 1868 + ASME B16.34	BODY: ASTM A105N TRIM:13Cr+HF	75
CHECK	2	48	RF	CL.150, DUAL PLATE, TYPE A, RF DOUBLE FLGD TO B16.5 / B16.47-A	API 594	BODY: ASTM A216 GR.WCB TRIM: 13Cr+HF	75
CHECK	2	24	RF	CL.150, SWING CHECK FLGD TO B16.5	API 6D	BODY: ASTM A216 GR.WCB TRIM: 13Cr+HF	75
GATE	½	1 ½	RF	CL.150, FLGD TO B16.5, SOLID WEDGE, STD PORT, OS & Y, BOLTED BONNET, HANDWHEEL	API 602 + ASME B16.34	BODY: ASTM A105N TRIM: 13Cr+HF	16,75
GATE	2	24	RF	CL.150, FLGD TO B16.5, FLEXIBLE WEDGE, STD PORT, OS & Y, BOLTED BONNET, HANDWHEEL / GEAR	API 600 + ASME B16.34	BODY: ASTM A216 GR.WCB TRIM: 13Cr+HF	16,75
GATE	30	48	RF	CL.150, FLGD TO B16.47-A , FLEXIBLE WEDGE, STD PORT, OS & Y, BOLTED BONNET, GEAR	API 6D	BODY: ASTM A216 GR.WCB TRIM: 13Cr+HF	16,75
GLOBE	½	1 ½	RF	CL.150, FLGD TO B16.5, SWIVEL PLUG DISC, OS & Y, BOLTED BONNET, HANDWHEEL	API 602 + ASME B16.34	BODY: ASTM A105N TRIM: 13Cr+HF	16,75
GLOBE	2	12	RF	CL.150, FLGD TO B16.5, SWIVEL PLUG DISC, OS & Y, BOLTED BONNET, HANDWHEEL / GEAR	API 623 + ASME B16.34	BODY: ASTM A216 GR.WCB TRIM: 13Cr+HF	16,75
BUTTERFLY	14	48	RF	CL.150, TRIPLE OFFSET, DOUBLE FLGD TO B16.5 / B16.47-A, GEAR	API 609, CAT.B	BODY: ASTM A216 GR.WCB TRIM & SEAT: 13Cr+HF	16,75,87

PIPING CLASS: AC1P6B-FH

COMPONENT (TYP)	NPS (INCH)		END	DESCRIPTION	DIM/ MFG STD.	MATERIAL STD.	NOTES
	FROM	TO					
VALVES – CONT, D (NOTE -81)							
BALL	2	6	RF	CL.150, FLGD TO B16.5, REDUCED BORE, FLOATING BALL, LEVER / GEAR	API 6D	BODY: ASTM A216 GR.WCB TRIM & SEAT: SS316 + HF	16,75
BALL	8	36	RF	CL.150, FLGD TO B16.5 / B16.47-A, REDUCED BORE, TRUNNION MOUNTED, GEAR	API 6D	BODY: ASTM A216 GR.WCB TRIM & SEAT: SS316 + HF	16,75
BALL	42	48	RF	CL.150, FLGD TO B16.47-A, REDUCED BORE, TRUNNION MOUNTED, GEAR	API 6D + MANF STD	BODY: ASTM A216 GR.WCB TRIM & SEAT: SS316 + HF	16,75
BALL	½	1 ½	RF	CL.150, FLGD TO B16.5, FULL BORE, FLOATING BALL, LEVER	API 6D	BODY: ASTM A105N TRIM & SEAT: SS316 + HF	16,75
BALL	2	4	RF	CL.150, FLGD TO B16.5, FULL BORE, FLOATING BALL, LEVER	API 6D	BODY: ASTM A216 GR.WCB TRIM & SEAT: SS316 + HF	16,71,75
BALL	6	36	RF	CL.150, FLGD TO B16.5 / B16.47-A, FULL BORE, TRUNNION MOUNTED, GEAR	API 6D	BODY: ASTM A216 GR.WCB TRIM & SEAT: SS316 + HF	16,71,75
BALL	42	48	RF	CL.150, FLGD TO B16.47-A, FULL BORE, TRUNNION MOUNTED, GEAR	API 6D + MANF STD	BODY: ASTM A216 GR.WCB TRIM & SEAT: SS316 + HF	16,71,75
IDBB VALVE (FLG X FLG)	¾	2	RF	CL. 150, BALL TYPE BLOCK, REDUCING BODY DESIGN, FLOATING BALL AND ½" NEEDLE TYPE BLEED VALVE, LEVER OPERATED MIN.14MM BORE	API 6D + MANF STD	BODY: ASTM A105N / ASTM A216 GR. WCB TRIM & SEAT: SS316 + HF BLEED VALVE: BODY- ASTM A105N, TRIM- SS316+HF	16,75,90