



Standard Specification for Large-Diameter Fabricated Carbon Steel Flanges¹

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1. Scope

1.1 This specification provides design and construction criteria for large diameter flanges sizes 14 NPS to 144 NPS, for use in high temperature (1000 °F), low pressure service (25 psig), such as internal combustion engine exhaust and forced ventilation systems.

1.2 The values stated in inch-pound units are to be regarded as standard. No other units of measurement are included in this standard.

1.3 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[A36/A36M Specification for Carbon Structural Steel](#)
[F1155 Practice for Selection and Application of Piping System Materials](#)

2.2 *AWWA Standards:*³

[AWWA C 207 Steel Pipe Flanges for Waterwork Service 4 in. through 144 in.](#)

2.3 *Other Documents:*

[American Bureau of Shipping Rules for Building and Classing of Steel Vessels, ABS Grade A](#)⁴

[American Welding Society Publication, AWS D 1.1 Structural Welding Code](#)⁵

¹ This specification is under the jurisdiction of ASTM Committee F25 on Ships and Marine Technology and is the direct responsibility of Subcommittee F25.11 on Machinery and Piping Systems.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American Water Works Association (AWWA), 6666 W. Quincy Ave., Denver, CO 80235, <http://www.awwa.org>.

⁴ Available from American Bureau of Shipping (ABS), ABS Plaza, 16855 Northchase Dr., Houston, TX 77060, <http://www.eagle.org>.

⁵ Available from American Welding Society (AWS), 8669 NW 36 St., #130, Miami, FL 33166-6672, <http://www.aws.org>.

[Code of Federal Regulations Title 46, Subpart 56.30—10\(b\) \(5\)](#)⁶
[ASME Boiler and Pressure Vessel Code, Section IX, Welding Qualifications](#)⁷

3. Classification

3.1 *Type I*—Plate flanges, for sizes 14 in. inside diameter up to and including 144 in. inside diameter (see Fig. 1).

3.2 *Type II*—Rolled angle flanges, for sizes 14 in. up to and including 108 in. inside diameter (see Fig. 1).

4. Ordering Information

4.1 Flanges ordered under this specification shall include the following:

- 4.1.1 ASTM designation, title, number, and date of this specification,
- 4.1.2 Type and material,
- 4.1.3 Nominal pipe size,
- 4.1.4 Quantity, and
- 4.1.5 Inspection of items shall be agreed upon between the purchaser and the supplier.

5. Dimensions and Tolerances

5.1 *Dimensions*—Dimensions shall be in accordance with Table 1.

5.2 *Tolerances:*

5.2.1 Plus or minus ¼ in. on outside and inside diameters shall apply on flanges of 22 in. nominal pipe size and above. The tolerance for flanges for 20 in. nominal size and below shall be $\pm 1/8$ in.

5.2.2 Plus or minus 1/16 in. on bolting circle.

6. Drilling

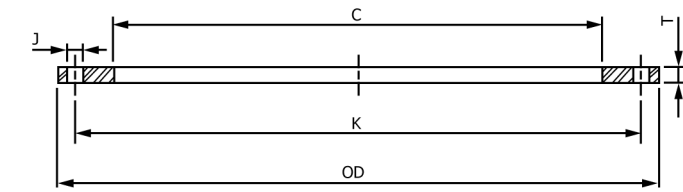
6.1 Number of holes, hole diameter, and bolt circle are identical for both Type I and Type II flanges.

6.2 Bolt holes shall be equally spaced on the bolt circle.

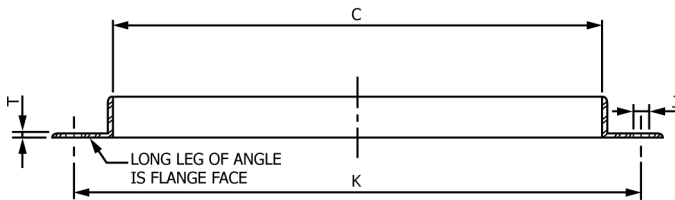
6.3 Bolt holes provide for 1/8 in. diameter clearance on bolts.

⁶ Available from DLA Document Services, Building 4/D, 700 Robbins Ave., Philadelphia, PA 19111-5094, <http://quicksearch.dla.mil>.

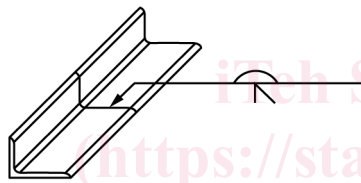
⁷ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.



TYPE I
SECTIONAL VIEW



TYPE II
SECTIONAL VIEW



WELD DETAIL
TYPE II

NOTE 1—1 in. = 25.4 mm

FIG. 1 Flanges, Types I and II

6.4 Drilling of flanges shall be in accordance with Table 1.

7. Workmanship, Finish, and Appearance

7.1 Flanges manufactured under this specification shall be free of all sharp edges, burrs, projections, weld spatter, and other defects that might be hazardous to personnel or equipment, or both.

7.2 Welding shall be in accordance with the American Bureau of Shipping Rules for Building and Classing of Steel Vessels, ABS Grade A, American Welding Society Publications D 1.1, or ASME Code Section IX.

7.3 Flange faces shall be smooth and free of projections or indentations that would prevent effective gasket seals.

7.4 Flanges when completed shall have no distortion, roundness, or flatness exceeding a tolerance of $\pm 1/8$ in.

7.5 The surface finish shall be a minimum of 500 $\mu\text{in.}$ to ensure proper sealing surface for the gasket.

7.6 The material to be used for this specification shall be in accordance with Specification A36/A36M, unless prolonged high temperatures will be required; in that case ABS Grade A steel shall be specified in Section 4. For further guidance for selection of materials, see Practice F1155 and CFR 56.30-10(b)(5).

8. Rejection and Rehearing

8.1 Flanges that fail to conform to the requirements of this specification may be rejected. Rejection may be reported to the producer or the supplier promptly in writing. In case of dissatisfaction with the damaged items, the producer or the supplier may make claim for a rehearing.

9. Certification

9.1 When specified in the purchase order or the contract, the purchaser shall be furnished with certification that samples representing the flanges have been inspected to meet the requirements of this specification. When specified in the purchase order or contract, a report of the results shall be furnished.

10. Packaging and Package Marking

10.1 Flanges shall be marked on the edge of each flange showing the purchase order number, ASTM designation number, material and type, size, and name of manufacturer.

10.2 The flanges shall be packaged in a manner acceptable for shipment by common carrier.

11. Keywords

11.1 carbon steel; flanges; large-diameter flanges; low pressure service flanges; marine technology; ships