



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 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 Values stated in inch-pound units are to be regarded as the standard.

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 *American Water Works Association*:³
AWWA C207 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 A⁴
American Welding Society Publication, AWS D 1.1 Structural Welding Code⁵

Code of Federal Regulations Title 46, Subpart 56.30—10
(b) (5)⁶

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), 1401 New York Ave., NW, Suite 640, Washington, DC 20005.

⁴ Available from American Bureau of Shipping (ABS), ABS Plaza, 16855 Northchase Dr., Houston, TX 77060.

⁵ Available from The American Welding Society (AWS), 550 NW LeJeune Rd., Miami, FL 33126.

⁶ Available from Standardization Documents, Order Desk, Building 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

ASME Boiler and Pressure Vessel Code, Section IX, Welding Qualifications⁷

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 1/4 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.

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

⁷ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990.