



Standard Practice for Use of Branch Connections¹

This standard is issued under the fixed designation F681; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This practice lists commonly used types of branch connections for carbon steel, chromium-molybdenum steel pipe and copper-nickel alloy tubing. Branch to run size applications are given in [Table 1](#), [Table 2](#), and [Table 3](#). Other types of branch connections ([Fig. 1](#)) may be used provided they comply with the requirements of Title 46 CFR Subparts 56.07-10(f) and 56.70-15(g) of the USCG Regulations.

2. Referenced Documents

2.1 ASTM Standards:²

[F722 Specification for Welded Joints for Shipboard Piping Systems](#)

2.2 ANSI Standard:³

[B31.1 Power Piping](#)

2.3 Other Document:⁴

[Title 46 Code of Federal Regulations \(CFR\) Shipping, Parts 41 to 69](#)

3. General Requirements

3.1 Weld joint designs shall be in accordance with Specification [F722](#) and the limitations therein.

3.2 Fabricated branch connections shall meet the reinforcement requirements of Section 104.3 of ANSI B31.1 as modified by Title 46, CFR Subparts 56.07-10(f) and 56.70-15(g) of the USCG regulations.

3.3 Threaded fittings shall be subject to the limitations of Title 46 CFR, Subpart 56.30-20 of the USCG Regulations.

4. Keywords

4.1 branch connections; carbon steel connections; chromium-molybdenum steel pipe; copper-nickel alloy tubing

¹ This practice 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.

Current edition approved Aug. 1, 2014. Published September 2014. Originally approved in 1980. Last previous edition approved in 2008 as F681 – 82 (2008). DOI: 10.1520/F0681-82R14.

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 National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁴ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.



F681 – 82 (2014)

TABLE 1 Branch Connection Matrix for Carbon Steel Piping

LEGEND (see Fig. 1)

- 1 = Tee or lateral (butt weld)
- 2 = Tee or lateral (socket weld or threaded)
- 3 = Welded outlet (butt weld end)
- 4 = Welded outlet (socket weld or threaded end)
- 5 = Fabricated joint (cut-in branch)

BRANCH SIZE (NPS), in.

		1/4	3/8	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	3 1/2	4	5	6	8	10	12	14	16	18		
MAIN OR RUN SIZE (NPS), in.	1/4		2																				
	3/8	2																					
	1/2	2	2																				
	3/4	2	2	2																			
	1	2	2	2	2																		
	1 1/4	2	2	2	2	2																	
	1 1/2	2	2	2	2	2	2																
	2	2	2	2	2	2	2	2															
	2 1/2	4	4	4	4	4	4	4	4														
	3	4	4	4	4	4	4	4	4, 5	1	1	1	1										
	3 1/2	4	4	4	4	4	4	4	4, 5	1	1	1	1	1	1								
	4	4	4	4	4	4	4	4	4, 5	1	1	1	1	1	1	1							
	5	4	4	4	4	4	4	4	4, 5	1	1	1	1	1	1	1	1						
	6	4	4	4	4	4	4	4	4, 5	1	1	1	1	1	1	1	1	1					
	8	4	4	4	4	4	4	4	4, 5	1	1	1	1	1	1	1	1	1	1				
	10	4	4	4	4	4	4	4	4, 5	3	3	3	3	3	3	3	3	3	3				
	12	4	4	4	4	4	4	4	4, 5	3	3	3	3	3	3	3	3	3	3	1	1	1	1
	14	4	4	4	4	4	4	4	4, 5	3	3	3	3	3	3	3	3	3	3	1	1	1	1
	16	4	4	4	4	4	4	4	4, 5	3	3	3	3	3	3	3	3	3	3	1	1	1	1
	18	4	4	4	4	4	4	4	4, 5	3	3	3	3	3	3	3	3	3	3	1	1	1	1

<https://standards.itec.org>

1-822014