



Standard Specification for Gage Piping Assemblies¹

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

1. Scope

1.1 This specification covers details of gage piping assemblies for pressure gages with optional provisions for additional gages, pressure switches, transmitters, and so forth, for use with steam, steam drains, feed water, condensate, fresh water, salt water, compressed air, fuel oil, and lubricating oil systems.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only. ~~Mathematical conversions to SI units that are provided for information only and are not considered 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

- A105/A105M Specification for Carbon Steel Forgings for Piping Applications
- A106/A106M Specification for Seamless Carbon Steel Pipe for High-Temperature Service
- A108 Specification for Steel Bar, Carbon and Alloy, Cold-Finished
- A182/A182M Specification for Forged or Rolled Alloy and Stainless Steel Pipe Flanges, Forged Fittings, and Valves and Parts for High-Temperature Service
- A276 Specification for Stainless Steel Bars and Shapes
- A335/A335M Specification for Seamless Ferritic Alloy-Steel Pipe for High-Temperature Service
- A576 Specification for Steel Bars, Carbon, Hot-Wrought, Special Quality
- B16/B16M Specification for Free-Cutting Brass Rod, Bar and Shapes for Use in Screw Machines
- B61 Specification for Steam or Valve Bronze Castings
- B62 Specification for Composition Bronze or Ounce Metal Castings
- B75 Specification for Seamless Copper Tube
- B124/B124M Specification for Copper and Copper Alloy Forging Rod, Bar, and Shapes
- B453/B453M Specification for Copper-Zinc-Lead Alloy (Leaded-Brass) Rod, Bar, and Shapes
- B466/B466M Specification for Seamless Copper-Nickel Pipe and Tube

2.2 ANSI Standards:³

- B16.11 Forged Steel Fittings, Socket Weld, and Threaded
- B16.15 Cast Bronze Threaded Fittings

2.3 Federal Specifications:~~SAE International.~~⁴

- ~~QQ-S-637 Steel Bar, Carbon, Cold-Finished (Standard Quality, Free Machining)~~
- ~~QQ-S-763 AMS-QQ-S-763 Steel-Steel, Corrosion Resistant, Bars, Wire, Shapes, and Forgings, Corrosion-Resisting Forgings~~

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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 National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS, SAE International (SAE), 400 Commonwealth Dr., Warrendale, PA 15096, http://www.sae.org.

3. List of Assemblies

3.1 This specification incorporates 13 gage piping assemblies as described in [Table 1](#).

4. General Requirements and Guidelines

4.1 [Fig. 1](#) shows a typical piping assembly for bottom-connected gages and [Fig. 2](#) a typical piping assembly for back-connected gages.

4.2 A siphon shall be used as shown in all gage applications for steam systems to maintain a protective water seal between the gage and the steam supply.

4.3 Each assembly includes a test connection beyond the gage valve which consists of a tee with a ¼-in. NPT threaded plug in the branch. The plug is removable for the purpose of installing a test gage for calibration. As an alternative, a gage valve that incorporates a built-in test connection integral with the valve may be substituted for the gage valve and test tee.

4.4 Root connections should be kept to a minimum by connecting other instruments at the tee between the root and gage valves. There is no limit to the number of dead-end-type instruments that can be served from a single root connection. However, each instrument should have its own shutoff valve and, if desired, a test tee may be fitted at each instrument.

4.5 Two shutoff valves are generally used in each assembly, a root valve and a gage cutout valve. The gage valve may be eliminated and a single shutoff valve may serve as both a root and gage valve provided the gage is within 6 ft (1.8 m) of the root connection and readily accessible and the single shutoff valve is fitted within 12 in. (300 mm) of the root connection.

4.6 Pulsation dampeners are shown for certain assemblies between the test tee and gage and should be used in other assemblies in which the gage may be subjected to pulsating pressures, as from a reciprocating pump, air compressor, quick-acting solenoid valves, and high-frequency vibrations of high-pressure feed pumps.

4.7 Isolation devices (diaphragm seals) should be installed where system fluid viscosity and fuel isolation is a consideration.

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TABLE 1 Gage Piping Assemblies^{A,B}

Assembly No.	Service	Maximum Pressure, psi (kPa)	Maximum Temperature, °F (°C)
1	Superheated steam	1125 (7757)	960 (516)
2	High-pressure desuperheated steam and high-pressure extractions	1100 (7584)	580 (304)
3	Low-pressure extractions, gland seal, auxiliary exhaust, and 150-psig (1034-MPa) steam	900 (6205)	563 (295)
4	Low-pressure steam	125 (861)	353 (178)
5	Boiler feed discharge	1500 (10 342)	450 (232)
6	Feed suction and condensate	165 (1138)	300 (149)
7	Compressed air above 165 psi (1.14 MPa)	900 (6205)	563 (295)
8	Compressed air	165 (1138)	300 (149)
9	Fresh and potable water	200 (1379)	150 (66)
10	Main and auxiliary salt water circulating, salt water service, and wet firemain	200 (1379)	150 (66)
11	Dry firemain and deck washdown	200 (1379)	150 (66)
12	Fuel oil and lube oil	900 (6205)	250 (121)
13	Diesel oil	900 (6205)	563 (295)

^A For typical piping assemblies see [Fig. 1](#) and [Fig. 2](#).

^B For materials required see [Table 2](#) and [Table 3](#).