

**ASME B16.5-2009**  
(Revision of ASME B16.5-2003)

# Pipe Flanges and Flanged Fittings

NPS  $\frac{1}{2}$  Through NPS 24  
Metric/Inch Standard

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**AN AMERICAN NATIONAL STANDARD**



**The American Society of  
Mechanical Engineers**



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# CONTENTS

Foreword .....	vi
Committee Roster .....	ix
Correspondence With the B16 Committee .....	x
<b>1 Scope</b> .....	<b>1</b>
<b>2 Pressure–Temperature Ratings</b> .....	<b>2</b>
<b>3 Component Size</b> .....	<b>3</b>
<b>4 Marking</b> .....	<b>3</b>
<b>5 Materials</b> .....	<b>7</b>
<b>6 Dimensions</b> .....	<b>9</b>
<b>7 Tolerances</b> .....	<b>12</b>
<b>8 Pressure Testing</b> .....	<b>14</b>
<b>Figures</b>	
1 Method of Designating Location of Auxiliary Connections When Specified .....	15
2 Method of Designating Outlets of Reducing Fittings in Specifications .....	16
3 Thread Length for Connection Tapping .....	17
4 Socket Welding for Connections .....	17
5 Butt Welding for Connections .....	17
6 Bosses for Connections .....	17
7 End Flange Facings and Their Relationship to Flange Thickness and Center-to-End and End-to-End Dimensions .....	18
8 Bevel for Wall Thicknesses $t$ From 5 mm to 22 mm Inclusive .....	19
9 Bevel for Wall Thicknesses $t$ Greater Than 22 mm .....	20
10 Inside Contour for Use With Rectangular Backing Ring .....	20
11 Inside Contour for Use With Taper Backing Ring .....	21
12 Bevel for Outside Thickness .....	21
13 Bevel for Inside Thickness .....	21
14 Bevel for Combined Thickness .....	22
15 Straight Hub Welding Flanges .....	22
<b>Tables</b>	
A List of Material Specifications .....	4
1B List of Bolting Specifications Applicable ASTM Specifications .....	8
1C Flange Bolting Dimensional Recommendations .....	12
2-1.1 Pressure–Temperature Ratings for Group 1.1 Materials .....	23
2-1.2 Pressure–Temperature Ratings for Group 1.2 Materials .....	24
2-1.3 Pressure–Temperature Ratings for Group 1.3 Materials .....	25
2-1.4 Pressure–Temperature Ratings for Group 1.4 Materials .....	26
2-1.5 Pressure–Temperature Ratings for Group 1.5 Materials .....	27
2-1.7 Pressure–Temperature Ratings for Group 1.7 Materials .....	28
2-1.9 Pressure–Temperature Ratings for Group 1.9 Materials .....	29



2-1.10	Pressure–Temperature Ratings for Group 1.10 Materials	30
2-1.11	Pressure–Temperature Ratings for Group 1.11 Materials	31
2-1.13	Pressure–Temperature Ratings for Group 1.13 Materials	32
2-1.14	Pressure–Temperature Ratings for Group 1.14 Materials	33
2-1.15	Pressure–Temperature Ratings for Group 1.15 Materials	34
2-1.17	Pressure–Temperature Ratings for Group 1.17 Materials	35
2-1.18	Pressure–Temperature Ratings for Group 1.18 Materials	36
2-2.1	Pressure–Temperature Ratings for Group 2.1 Materials	37
2-2.2	Pressure–Temperature Ratings for Group 2.2 Materials	38
2-2.3	Pressure–Temperature Ratings for Group 2.3 Materials	39
2-2.4	Pressure–Temperature Ratings for Group 2.4 Materials	40
2-2.5	Pressure–Temperature Ratings for Group 2.5 Materials	41
2-2.6	Pressure–Temperature Ratings for Group 2.6 Materials	42
2-2.7	Pressure–Temperature Ratings for Group 2.7 Materials	43
2-2.8	Pressure–Temperature Ratings for Group 2.8 Materials	44
2-2.9	Pressure–Temperature Ratings for Group 2.9 Materials	45
2-2.10	Pressure–Temperature Ratings for Group 2.10 Materials	46
2-2.11	Pressure–Temperature Ratings for Group 2.11 Materials	47
2-2.12	Pressure–Temperature Ratings for Group 2.12 Materials	48
2-3.1	Pressure–Temperature Ratings for Group 3.1 Materials	49
2-3.2	Pressure–Temperature Ratings for Group 3.2 Materials	49
2-3.3	Pressure–Temperature Ratings for Group 3.3 Materials	50
2-3.4	Pressure–Temperature Ratings for Group 3.4 Materials	50
2-3.5	Pressure–Temperature Ratings for Group 3.5 Materials	51
2-3.6	Pressure–Temperature Ratings for Group 3.6 Materials	52
2-3.7	Pressure–Temperature Ratings for Group 3.7 Materials	53
2-3.8	Pressure–Temperature Ratings for Group 3.8 Materials	54
2-3.9	Pressure–Temperature Ratings for Group 3.9 Materials	55
2-3.10	Pressure–Temperature Ratings for Group 3.10 Materials	56
2-3.11	Pressure–Temperature Ratings for Group 3.11 Materials	56
2-3.12	Pressure–Temperature Ratings for Group 3.12 Materials	57
2-3.13	Pressure–Temperature Ratings for Group 3.13 Materials	58
2-3.14	Pressure–Temperature Ratings for Group 3.14 Materials	59
2-3.15	Pressure–Temperature Ratings for Group 3.15 Materials	60
2-3.16	Pressure–Temperature Ratings for Group 3.16 Materials	61
2-3.17	Pressure–Temperature Ratings for Group 3.17 Materials	62
2-3.19	Pressure–Temperature Ratings for Group 3.19 Materials	62
3	Permissible Imperfections in Flange Facing Finish for Raised Face and Large Male and Female Flanges	63
4	Dimensions of Flanges (Other Than Ring Joints, All Pressure Rating Classes)	64
5	Dimensions of Ring-Joint Facings (All Pressure Rating Classes)	66
6	Reducing Threaded and Slip-On Flanges for Classes 150 Through 900	70
7	Templates for Drilling Class 150 Pipe Flanges and Flanged Fittings	71
8	Dimensions of Class 150 Flanges	72
9	Dimensions of Class 150 Flanged Fittings	75
10	Templates for Drilling Class 300 Pipe Flanges and Flanged Fittings	80
11	Dimensions of Class 300 Flanges	81
12	Dimensions of Class 300 Flanged Fittings	84
13	Templates for Drilling Class 400 Pipe Flanges	88
14	Dimensions of Class 400 Flanges	89
15	Templates for Drilling Class 600 Pipe Flanges and Flanged Fittings	91
16	Dimensions of Class 600 Flanges	92
17	Templates for Drilling Class 900 Pipe Flanges and Flanged Fittings	94
18	Dimensions of Class 900 Flanges	95



19	Templates for Drilling Class 1500 Pipe Flanges .....	97
20	Dimensions of Class 1500 Flanges .....	98
21	Templates for Drilling Class 2500 Pipe Flanges .....	100
22	Dimensions of Class 2500 Flanges .....	101

**Mandatory Appendices**

I	Threading of Pipe for American National Standard Threaded Flanges .....	103
II	Pressure–Temperature Ratings and Dimensional Data for Classes 150, 300, 400, 600, 900, 1500, and 2500 Flanges and Classes 150 and 300 Flanged Fittings in U.S. Customary Units .....	105
III	References .....	193

**Nonmandatory Appendices**

A	Method Used for Establishing Pressure–Temperature Ratings .....	106
B	Limiting Dimensions of Gaskets Other Than Ring Joint Gaskets .....	200
C	Method for Calculating Bolt Lengths .....	202
D	Quality System Program .....	204
E	Dimensions of Classes 400, 600, 900, 1500, and 2500 Flanged Fittings in U.S. Customary Units .....	205



## FOREWORD

In 1920, the American Engineering Standards Committee [later the American Standards Association (ASA)] organized Sectional Committee B16 to unify and further develop standards for pipe flanges and fittings (and later for valves and gaskets). Cosponsors of the B16 Committee were ASME, the Heating and Piping Contractors National Association [now Mechanical Contractors Association of America (MCAA)], and the Manufacturers Standardization Society of the Valve and Fittings Industry (MSS). Cosponsors were later designated as cosecretariat organizations.

The Committee soon recognized the need for standardization of steel pipe flanges. In May, 1923, Subcommittee 3 was organized to develop such standards for pressures in the 250-psi to 3,200-psi range and for elevated temperatures. Active work began in October, including steel flanged fittings. The first proposed standard was submitted to the Committee in April, 1926 and approved by letter ballot in December. After favorable review by the three sponsor organizations, the Standard was approved as American Tentative Standard B16e in June 1927.

Experience in using the Standard showed the need for hub dimensions of companion flanges and for other changes, including rerating of 250-lb and 1,350-lb flanges and development of flanged fittings with integral bases. An investigation was made into the factors determining stiffness of flanges and flange hubs. The revised edition was approved as ASA B16E-1932.

A revision was initiated in 1936, stimulated by suggestions from Committee members and industrial users. The resulting 1939 edition contained standards for welding neck flanges (completed in March 1937), 1,500-lb flanges in the 14-in. through 24-in. range, 2,500-lb flanges and flanged fittings in the ½-in. through 12-in. range, and dimensions for a full line of ring joint flanges developed by the American Petroleum Institute. Pressure-temperature ratings for alloy steel flanges and fittings, developed by Subcommittee 4, were included for the first time.

In August 1942, the War Production Board requested a review of measures to conserve vital materials in piping components. A special War Committee of B16 was appointed and, operating under War Standard Procedure, developed revised pressure-temperature ratings for all materials and pressure classes. The ratings were published as American War Standard B16e5-1943. In 1945, under normal procedures, Subcommittee 3 and 4 reviewed the 1939 standard and 1943 ratings and recommended adoption of the war time ratings. Their report was approved as Supplement No. 1 to B16e-1939 and published as ASA B16e6-1949. In addition to ratings, the supplement updated material specification references and added a table of metal wall thickness for welding-end valves.

Subcommittee 3 then began a revision of the entire standard. Technically, the 1949 Supplement was absorbed, new materials were recognized, a general rating method was developed and added as an appendix, and welding end preparations were expanded. Editorially, a new style of presentation was worked out, including tables rearranged for easier use. Approval by Sectional Committee, cosponsors, and ASA resulted in the publication of ASA B16.5-1953 (designation changed from B16e).

Work soon began on further revisions. Class B ratings were deleted, and Class A ratings were clarified in the standard. An appendix defined qualifications for gaskets, other than ring joint, which would merit the ratings. Another appendix defined the method for calculating bolt lengths, including the measurement of stud bolt length between thread ends instead of points. Pressure-temperature ratings for several new materials were added, the table of welding end dimensions was expanded, and the temperatures used in determining ratings were redefined. The resulting new edition, after approval, was published as ASA B16.5-1957.

The more modest revision approved as ASA B16.5-1961 changed the text to clarify the intent or to make requirements easier to administer. The next revision began in 1963 with nearly 100 comments and suggestions. No fundamental changes were made, but the text was further clarified, and wall thicknesses less than ¼ in. for flanged fittings were recognized in the 1968 edition.

A new joint study of ratings between Subcommittees 3 and 4 was initiated before the next revision. Based on the Subcommittee 4 report, the rating procedure was revised, and a rating



basis for Class 150 (150 lb) flanges was developed. New product forms, bar and plate, were added for special applications, including fabricated flanged valves and fittings. Reference to welding-end valves was not included, because a separate standard for them was. Bolt length calculations based on worst case tolerances led to a revision of tabulated lengths. Testing of valves subsequently published by SC 15 closure members was added to the test requirements. Following final approval on October 23, the Standard was published as ANSI B16.5-1973.

Subcommittee N (formerly 15) was assigned responsibility for all valve standards in late 1973. Subcommittee C (formerly 3) continues to have responsibility for flange standards. A revision was accordingly initiated to remove all references to valves. At the same time, comments from users and changes in the ASME Boiler and Pressure Vessel Code led to significant revisions in the Class 150 rating basis and in the ratings of stainless steel and certain alloy steel flanges and flanged fittings in all rating classes. Extensive public review comments led to the addition of considerations for bolting and gaskets for flanged joints and of marking requirements. To avoid frequent and confusing changes in ratings as further changes in Code allowable stresses are made, it was agreed with Subcommittee N to leave ratings alone unless the relevant Code stress values are changed by more than 10%. After final approval by the Standards Committee, sponsors, and ANSI, ANSI B16.5-1977, Steel Pipe Flanges and Flanged Fittings, was published on June 16, 1977.

In 1979, work began on another new edition. Materials coverage was expanded by the addition of nickel and nickel alloys. Bolting rules were revised to cover nickel alloy bolts. Bolt hole and bolting were changed to provide interchangeability between inch and metric dimensions. Metric dimensional tables were made informational rather than alternative requirements of the Standard. Final approval was granted for ANSI B16.5-1984, Pipe Flanges and Flanged Fittings on August 14.

In 1982, American National Standards Committee B16 was reconstituted as an ASME Committee operating under procedures accredited by ANSI. The 1986 edition of the Standard extended nickel alloy ratings to higher temperatures, clarifying flange requirements, and included other minor revisions. The Committee determined that a metric standard for flanges will stand alone, with metric bolting and gaskets; hence, metric equivalents have been deleted. Following approval by the Standard Committee and ASME approval as an American National Standard was given by ANSI on April 7, 1988, with the new designation ASME/ANSI B16.5-1988.

The 1996 Edition allowed flanges marked with more than one material grade or specification, revised flange facing finish requirements, revised pressure-temperature ratings for several material groups, added a nonmandatory quality system annex, and included several other revisions. The 1996 Edition was approved by ANSI on October 3, 1996, with the new designation ASME B16.5-1996.

The 2003 Edition included metric units as the primary reference units while maintaining U.S. Customary units in either parenthetical or separate forms. New materials were added while some materials were shifted from one group to another, and new material groups were established.

All pressure-temperature ratings were recalculated using data from the latest edition of the ASME Boiler and Pressure Vessel Code, Section II, Part D. Annex F was added to cover pressure-temperature ratings and dimensional data for Class 150 through 2500 flanges and Class 150 and 300 flanged fittings in U.S. Customary units. Table and figure numbers in Annex F were prefixed by the letter F and corresponded to table and figure numbers in the main text for the metric version, with the exception of some table and figure numbers that were not used in Annex F. Of note, the flange thickness designations for Class 150 and 300 were revised with reference to their raised faces. For these classes, the flange thickness dimensional reference planes were altered; however, required flange thickness remained unchanged. The minimum flange thickness designation was changed from C to  $t_f$ , and it did not include 2.0 mm (0.06 in.) raised face for Class 150 and 300 raised face flanges and flanged fittings. Because of diminished interest, flanged end fittings conforming to ASME Class 400 and higher were listed only with U.S. Customary units in Annex G. In addition, straight hub welding flanges were incorporated as a new set of flanges in Classes 150 through 2500. Also, there were numerous requirement clarifications and editorial revisions.

Following the approval of the Standards Committee and ASME, approval for the new edition was granted by the American National Standards Institute on July 9, 2003.

The 2009 Edition adds new materials, updates some pressure-temperature ratings, and designates the annexes as mandatory and nonmandatory appendices. The mandatory appendices have



been numbered using roman numerals, and the nonmandatory appendices are now referenced using capital letters.

Following approval of the Standards Committee and ASME, approval for the new edition was granted by the American National Standards Institute on February 19, 2009.

Requests for interpretations or suggestions for revisions should be sent to the Secretary, B16 Standards Committee, Three Park Avenue, New York, NY 10016-5990.



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Secretary, B16 Standards Committee  
The American Society of Mechanical Engineers  
Three Park Avenue  
New York, NY 10016-5990

As an alternative, inquiries may be submitted via e-mail to: [SecretaryB16@asme.org](mailto:SecretaryB16@asme.org)

**Proposing Revisions.** Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

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Subject: Cite the applicable paragraph number(s) and the topic of the inquiry.  
Edition: Cite the applicable edition of the Standard for which the interpretation is being requested.  
Question: Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary device or situation. The inquirer may also include any plans or drawings that are necessary to explain the question; however, they should not contain proprietary names or information.

Requests that are not in this format will be rewritten in this format by the Committee prior to being answered, which may inadvertently change the intent of the original request.

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# PIPE FLANGES AND FLANGED FITTINGS

## NPS $\frac{1}{2}$ THROUGH NPS 24 METRIC/INCH STANDARD

### 1 SCOPE

#### 1.1 General

(a) This Standard covers pressure–temperature ratings, materials, dimensions, tolerances, marking, testing, and methods of designating openings for pipe flanges and flanged fittings. Included are

(1) flanges with rating class designations 150, 300, 400, 600, 900, and 1500 in sizes NPS  $\frac{1}{2}$  through NPS 24 and flanges with rating class designation 2500 in sizes NPS  $\frac{1}{2}$  through NPS 12, with requirements given in both metric and U.S. Customary units with diameter of bolts and flange bolt holes expressed in inch units

(2) flanged fittings with rating class designation 150 and 300 in sizes NPS  $\frac{1}{2}$  through NPS 24, with requirements given in both metric and U.S. Customary units with diameter of bolts and flange bolt holes expressed in inch units

(3) flanged fittings with rating class designation 400, 600, 900, and 1500 in sizes NPS  $\frac{1}{2}$  through NPS 24 and flanged fittings with rating class designation 2500 in sizes  $\frac{1}{2}$  through NPS 12 that are acknowledged in Nonmandatory Appendix E in which only U.S. Customary units are provided

(b) This Standard is limited to

(1) flanges and flanged fittings made from cast or forged materials

(2) blind flanges and certain reducing flanges made from cast, forged, or plate materials

Also included in this Standard are requirements and recommendations regarding flange bolting, gaskets, and joints.

#### 1.2 References

Codes, standards, and specifications, containing provisions to the extent referenced herein, constitute requirements of this Standard. These reference documents are listed in Mandatory Appendix III.

#### 1.3 Time of Purchase, Manufacture, or Installation

The pressure–temperature ratings in this Standard are applicable upon its publication to all flanges and flanged fittings within its scope, which otherwise meet its requirements. For unused flanges or flanged fittings maintained in inventory, the manufacturer of the flange

or flanged fittings may certify conformance to this Edition, provided that it can be demonstrated that all requirements of this Edition have been met. Where such components were installed in accordance with the pressure–temperature ratings of an earlier edition of this Standard, those ratings are applicable except as may be governed by the applicable code or regulation.

#### 1.4 User Accountability

This Standard cites duties and responsibilities that are to be assumed by the flange or flanged fitting user in the areas of, for example, application, installation, system hydrostatic testing, operation, and material selection.

#### 1.5 Quality Systems

Requirements relating to the product manufacturer's Quality System Program are described in Nonmandatory Appendix D.

#### 1.6 Relevant Units

This Standard states values in both metric and U.S. Customary units. As an exception, diameter of bolts and flange bolt holes are expressed in inch units only. These systems of units are to be regarded separately as standard. Within the text, the U.S. Customary units are shown in parentheses or in separate tables. The values stated in each system are not exact equivalents; therefore, it is required that each system of units be used independently of the other. Except for diameter of bolts and flange bolt holes, combining values from the two systems constitutes nonconformance with the Standard.

#### 1.7 Selection of Materials

Criteria for selection of materials suitable for particular fluid service are not within the scope of this Standard.

#### 1.8 Convention

For the purpose of determining conformance with this Standard, the convention for fixing significant digits where limits, maximum and minimum values, are specified shall be rounded as defined in ASTM Practice E 29. This requires that an observed or calculated value shall be rounded off to the nearest unit in the last right-hand digit used for expressing the limit. Decimal values and tolerances do not imply a particular method of measurement.

