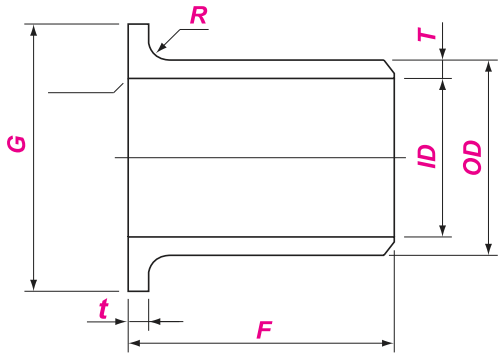
BUTT-WELDING LAP JOINT STUB END



Lap Joint Stub End

GB/T 12459、ASME B16.9、MSS SP-43

Nominal Size		OD of Cylinder		Length		Radius of Fillet		Diameter of Lap
DN	NPS	*OD*		*F*		*R*		
		Max.	Min.	Long Type	Short Type	A	B_{max}	*G*
15	1/2	22.8	20.5	76	51	3	0.8	35
20	3/4	28.1	25.9	76	51	3	0.8	43
25	1	35.0	32.6	102	51	3	0.8	51
32	1¼	43.6	41.4	102	51	5	0.8	64
40	1½	49.9	47.5	102	51	6	0.8	73
50	2	62.4	59.5	152	64	8	0.8	92
65	2½	75.3	72.2	152	64	8	0.8	105
80	3	91.3	88.1	152	64	10	0.8	127
90	3½	104.0	100.8	152	76	10	0.8	140
100	4	116.7	113.5	152	76	11	0.8	157
125	5	144.3	140.5	203	76	11	1.6	186
150	6	171.3	167.5	203	89	13	1.6	216
200	8	222.1	218.3	203	102	13	1.6	270
250	10	277.2	272.3	254	127	13	1.6	324
300	12	328.0	323.1	254	152	13	1.6	381
350	14	359.9	354.8	305	152	13	1.6	413
400	16	411.0	405.6	305	152	13	1.6	470
450	18	462.0	456.0	305	152	13	1.6	533
500	20	514.0	507.0	305	152	13	1.6	584
550	22	565.0	558.0	305	152	13	1.6	641
600	24	616.0	609.0	305	152	13	1.6	692

Notes:

1) When the short type is used on the larger flanges with PN 50 and PN 110 (300 and 600 LB) and on flanges with PN 150(900 LB) and above, or the long type is used on the larger flange with PN 260 and PN 420(1500 and 2500LB), the length of the cylinder may be added to be feasible the welding, the adding length shall be negotiated by manufacturer and purchaser.
2) The thickness of joint shall be added if the TG and MFM contact surface of flange are used, and the adding thickness shall increase (not be included in) the base length *F*.
3) The radius of fillet *R*(type A) shall conform to the ones of loose flanges according to GB/T 9118.1～9118.2 or ASME B16.5. The radius of fillet *R* (type B) is only applied for the standards of MSS SP-43 with short length *F*.
4) The lap joint diameter *G* shall conform to the standard machined face indicated in ASME B16.5 , and the back of joint shall be machined to conform to the surface of installation.When RJ used, the size *K* specified in ASME B 16.5 Shall apply.
5) The minimum lap joint thickness *t* shall not be less than the nominal pipe wall thickness.