

ASME B16 SC F WEBSITE PUBLISHED INTERPRETATIONS
ASME B16.9 Factory-Made Wrought Buttwelding Fittings

Interpretation 1-1:

Subject: B16.9 (1978 Edition);
Date Issued: February 19, 1986
File Number: B16-85-019

Question: Are straight cone taper and step reducers included in the scope of ANSI B16.9-1978?

Reply: Yes. See para. 1.2 of the Standard.

Interpretation 1-2:

Subject: B16.9 (1986 Edition);
Date Issued: April 8, 1987
File Number: B16-86-005

Question: Do fabricated fittings employing intersection welds fall within the scope of ASME/ANSI B16.9-1986?

Reply: No. See para. 1.3.

Interpretation 1-3:

Subject: B16.9 (1978 Edition);
Date Issued: June 10, 1987
File Number: B16.87-002

Question (1): What is the definition or intended meaning of the term “factory-made” as used in ANSI B16.9-1978, Section 1, Scope, para. 1.1?

Reply (1): “Factory-made” means production facilities, manufacturing methods (using tools, dies, jigs, and fixtures), and inspection procedures to a quality control system of standard line of butt-welding fittings.

Question (2): Section 1, Scope, para. 1.3 considers fabricated laterals, or other fittings employing intersection welds, as pipe fabrications to be designed in accordance with ANSI B31.1. Is the intent of this provision to exclude fabricated fittings from the provisions of ANSI B16.9?

Reply (2): Yes.

Question (3): Do elbows with miter joints meet the provisions of Section 7, Surface Contours, para. 7.1?

Reply (3): No.

Interpretation 1-4:

Subject: B16.9 (1978 Edition);
Date Issued: February 27, 1990
File Number: B16-88-002

Question: Does ANSI B16.9-1978 place any minimum dimensional requirements on the inside of fittings at a position other than welding ends?

Reply: No.

Interpretation 1-5:

Subject: Paragraph 9, Design Proof Test
Date Issued: February 27, 1990
File Number: B16-88-003

Question (1): Does para. 9 of ASME/ANSI B16.9-1986 require you to use the nominal wall thickness of the pipe that that test fitting marking identifies when calculating the burst pressure “P”?

Reply (1): Yes.

Question (2): Is the actual wall thickness of the pipe used in the test required to be greater than the nominal wall thickness of the pipe that the fitting marking identifies?

Reply (2): ASME/ANSI B16.9-1986 does not address the requirement for wall thickness of the pipe used in the test.

Interpretation 1-6:

Subject: Table A1, Tolerances
Date Issued: February 27, 1990
File Number: B16-88-004

Question: Does a NPS 30 butt weld long radius elbow that has an out-of-roundness value of 10 mm (major outside diameter 814 mm and a minor outside diameter of 804 mm) meet the dimensional tolerance requirements of ASME/ANSI B16.9-1986, Table A1?

Reply: No. The O.D. of a NPS 32 long radius elbow has a nominal outside diameter at the weld bevel of 813 mm with a +7 mm, -5 mm tolerance and an out-of-roundness tolerance of 12 mm. The minor outside diameter of the fitting is out of tolerance.

Interpretation 1-7:

Subject: Table 2 Dimensions of 45° Elbows
Date Issued: February 27, 1990
File Number: B16-88-006

Question: Does ASME/ANSI B16.9-1986 require dimensions of 45° elbows that would permit two (2) to be welded in series and meet the dimensional requirements of the corresponding size 90° elbow?

Reply: No.

Interpretation 1-8:

Subject: Paragraph 9.3.5, Proof Tests
Date Issued: February 27, 1990
File Number: B16-88-008

Question: Are fittings made to ASME/ANSI B16.9-1986, that were designed by successful proof tests which fulfilled the requirements of earlier editions of B16.9, considered as fulfilling the requirements of the 1986 edition?

Reply: Yes, provided the test data has been reviewed and meets the B16.9-1986 requirements.

Interpretation: 1-9

Subject: Tolerances in Parallelism
Date Issued: May 10, 1990
File: B16-90-003

Question: Do Table 7 and/or Table 1 of ASME/ANSI B16.9-1986 have a tolerance on parallelism between face and backface of the lap of a Lap Joint Stub End?

Reply: No.

Interpretation: 1-10

Subject: Paragraph 11.2, Dimensions
Date Issued: May 10, 1990
File: B16-90-004

Question: Do the provisions of para. 11.2, ANSI B16.9-1978, prohibit the use of vernier, micrometer, electronic read-out equipment, etc. for the determination of actual dimensions of B16.9 fittings?

Reply: No.

Interpretation: 1-11

Subject: Design Proof Test
Date Issued: August 8, 1990
File: B16-90-008

Question: Does ASME/ANSI B16.9-1986 cover Design Proof Test requirements for branch fittings (other than tees or crosses covered in Tables 5 and 6) in which reinforcement consideration must be analyzed?

Reply: No.

Interpretation: 1-12

Subject: Paragraph 9.2.3, Design Proof Test
Date Issued: June 27, 1990
File: B16-90-014

Question: What value of “S” shall be used in the formulae for P (Adj) (adjusted proof test pressure, psig) and P (computed bursting pressure of pipe which the fitting’s marking identifies, psig) presented in para. 9.2.3, ANSI B16.9-1978?

Reply: The value of “S” is the same for both equations as follows: S= Minimum specified tensile strength of the pipe which the fittings marking identifies, psi.

Interpretation 1-13:

Subject: Tolerances
Date Issued: January 23, 1991
File Number: B16-90-028

Question (1): According to ASME/ANSI B16.9-1986, must all inside diameter, outside diameter, and wall thickness tolerances (see Table 1 and A1) be met for each fitting?

Reply (1): Yes.

Question (2): Is there any precedence under which the tolerance must be applied?

Reply (2): No.

Question (3): In ASME/ANSI B16.9-1986, is there a maximum tolerance on wall thickness?

Reply (3): No.

Interpretation 1-14:

Subject: Taper Boring
Date Issued: January 23, 1991
File Number: B16-90-029

Question (1): According to ASME/ANSI B16.9-1986, when a B16.9 fitting dimension is short-ended due to taper boring, what tolerances apply?

Reply (1): Those in Table 1, Tolerances. See also para. 1.3.

Question (2): According to ASME/ANSI B16.28-1986, when a B16.28 fitting dimension is short-ended due to taper boring, what tolerances apply?

Reply (2): Those in Table 1, Tolerances.

Interpretation 1-15:

Subject: Table A1, Tolerances
Date Issued: January 24, 1991
File Number: B16-90-019

Question: Does Table A1, ASME/ANSI B16.9-1986, specify tolerances for inside diameter out-of-roundness?

Reply: No.

Interpretation 1-16:

Subject: Clarification of Long Radius Elbow
Date Issued: January 25, 1991
File Number: B16-90-027

Question: Does ASME/ANSI B16.9-1986, for 90° long radius elbows, require the openings to be joined by circular arcs on the external surfaces?

Reply: Yes, but the circular arcs may be terminated in tangents. See ASME/ANSI B16.9-1986, Section 7, Surface Contours.

Interpretation 1-17:

Subject: Paragraph 9.2.2, Other Components
Date Issued: February 19, 1991
File Number: B16-90-031

Question: Is the actual wall thickness or the pipe material used in the Design Proof Test Assembly described in ASME/ANSI B16.9-1986 in para. 9.2.2 limited to the nominal wall thickness or compatible pipe material that the fitting marking identifies?

Reply: No.

Interpretation 1-18:

Subject: Proof Testing of Fittings
Date Issued: February 19, 1991
File Number: B16-90-011

Question: Can successful proof pressure test data of an ASME/ANSI B16.9-1986 fitting such as a tee be applied to qualify a non-similar B16.9 fitting such as an elbow?

Reply: No. Test Data may only be applied to qualify fittings similar to the test fittings as outlined in Section 9.4, ASME/ANSI B16.9-1986.

Interpretation 1-19:

Subject: Wall Thickness Limitation for Fittings
Date Issued: September 19, 1991
File Number: B16-91-012

Question: Does ASME/ANSI B16.9-1986 have any restrictions on the maximum wall thickness used for B16.9 fitting construction?

Reply: No, provided the ends are prepared to match the customer's pipe within the tolerances specified in Table 1.

Interpretation 1-20:

Subject: Table 9, Straight Cone Taper Reducers
Date Issued: April 2, 1992
File Number: B16-91-013

Question: Are straight cone taper reducers included in the scope of ASME/ANSI B16.9-1986?

Reply: Yes, however the welding end preparations described in ASME/ANSI B16.9 Section 8 shall be met. The referencing Code may have additional requirements.

Interpretation 1-21:

Subject: Table 1, Tolerances
Date Issued: July 31, 1992
File Number: B16-92-006

Question: Do the inside, outside diameters, and minimum wall thickness tolerances of B16.9-1978, Table 1 apply throughout the fitting?

Reply: Table 1 tolerances for the I.D. and O.D. dimensions apply at the ends of the fitting. The wall thickness tolerances applied throughout the fitting.

Interpretation 1-22:

Subject: Test Procedures
Date Issued: August 19, 1992
File Number: B16-92-014

Question: When calculating the adjusted proof test pressure $P_{(adj.)}$ per ASME/ANSI B16.9-1986, para. 9.3, for a filler metal added welded test fitting, can a welded tensile test specimen, representative of the test fitting, be used in determining the actual tensile strength of the test fitting material $S_{(act)}$?

Reply: Yes, provided the tensile specimen and tensile strength meet the applicable material requirements of para. 5.0.

Interpretation B16-90-012

Subject: Welding Outlet Fittings
Date Issued: October 1, 1990
File: B16-90-12

Question: Does B16.9 cover welding outlet fittings?

Reply: No.

Interpretation B16-92-015

Subject: B16.9-1986, Segmented Elbows
Date Issued: December 1, 1992
File: B16-92-015

Question (1): Does B16.9-1986 apply to elbows modified by someone other than the manufacturer?

Reply (1): No.

Question (2): Can B16.9-1986 elbows be modified by the manufacturer?

Reply (2): Yes, by agreement with the purchaser (see paragraph 1.3).

Interpretation B16-92-031

Subject: B16.9-1986, Dimension of Caps
Date Issued: May 1, 1993
File: B16-92-031

Question: Is a steel rule having a 1/64-inch accuracy acceptable for the linear measurement of B16.9-1986 fitting dimensions found in Tables 2 through 9?

Reply: Yes.

Interpretation B16-93-002

Subject: B16.9-1986, Dimension of Caps
Date Issued: May 1, 1993
File: B16-93-002

Question: Are the diameter and length of skirt on caps illustrated in Table 8 of B16.9-1986 covered by B16.9-1986?

Reply: No. See Note (b), Table 8.

Interpretation B16-93-001R

Subject: B16.9-1986
Date Issued: June 1, 1993
File: B16-93-001R

Question: What is the allowable pressure rating for B16.9-1986 fittings?

Reply: Allowable pressure ratings for B16.9 fittings are calculated as for straight seamless pipe using the rules of the applicable section of the ASME Code for Pressure Piping. See paragraph 2.1.

Interpretation B16-93-010

Subject: B16.9-1986
Date Issued: September 1, 1993
File: B16-93-010

Question: Does B16.9-1993 cover requirements for extruded headers?

Reply: No.

Interpretation B16-93-009

Subject: B16.9-1993
Date Issued: October 1, 1993
File: B16-93-009

Question (1): According to B16.9-1993, are stub ends produced by welding plate to the end of pipe excluded?

Reply (1): Yes. See paragraph 1.4.

Question (2): According to B16.9-1993, are stub ends made by producing the entire lap with weld buildup to the end of pipe excluded?

Reply (2): Yes. See paragraph 1.4.

Interpretation B16-93-025

Subject: B16.9-1993
Date Issued: March 1, 1994
File: B16-93-025

Question (1): Does the off-angle tolerance “Q” specified in Table 1 of B16.9-1993 apply only to elbows and tees?

Reply (1): No. The tolerances apply to all fitting types except caps.

Question (2): Does the off-plane tolerance “P” specified in Table 1 apply only to 90 degree elbows?

Reply (2): No. They also apply to 45 degree elbows, reducing elbows, and tees.

Question (3): What are the off-angle and off-plane tolerances for 45 degree elbows?

Reply (3): They are the same as for the 90 degree elbows illustrated.

Question (4): What are the off-angle and off-plane tolerances for concentric and eccentric reducers?

Reply (4): Table 1 off-angle tolerances apply. Off-plane tolerances are not applicable.

Interpretation B16-93-026

Subject: B16.9-1986
Date Issued: March 1, 1994
File: B16-93-026

Question (1): According to B16.9-1986, does the successful design proof testing of one of the steels listed in paragraph 5 qualify the design of the fitting for all of the other steels listed in paragraph 5?

Reply (1): Yes. See paragraph 9.4.3.

Question (2): Can the design proof test results of a fitting made from a material not covered by paragraph 5 B16.9-1986 be extended to cover a fitting constructed under B16.9 requirements?

Reply (2): No.

Interpretation B16-94-002

Subject: B16.9-1993
Date Issued: July 1, 1994
File: B16-94-002

Question: Does the hydrostatic testing of starting pipe material (or lack of hydrostatic testing) relieve the manufacturer of responsibility to ensure that fittings made to B16.9-1993 meet the hydrostatic testing capabilities of Section X?

Reply: No.

Interpretation B16-95-009

Subject: B16.9-1986
Date Issued: December 1, 1995
File: B16-95-009

Question (1): Is the minimum lap thickness “T” for lap-joint stub ends per B16.9-1986, Table 7, equal to the nominal wall thickness?

Reply (1): Yes. See Note (1), Table 7.

Question (2): Does the lap thickness “T” for lap-joint stub ends per Table 7, B16.9-1986, have a maximum tolerance requirement?

Reply (2): Yes. See Table 1 for tolerance applicable to “T.”

Question (3): Does the tolerance “t” in Table 1, B16.9-1986, apply to the lap thickness “T”?

Reply (3): No.

Interpretation B16-95-010

Subject: B16.9-1993
Date Issued: March 1, 1996
File: B16-95-010

Question: Is the tolerance for the inside diameter at the end of a 10-in. B16.9-93 fitting equal to ± 0.12 in., if not otherwise specified by the purchaser?

Reply: Yes. See Table (1), including notes.

Interpretation B16-96-002

Subject: B16.9-1993
Date Issued: May 1, 1996
File: B16-96-002

Question: Are straight-cone per reducers included in the scope of B16.9-1993?

Reply: Yes, however, the welding-end preparations described in B16.9, Section 8 shall be met. The referencing Code may have additional requirements.

Interpretation B16-96-003

Subject: B16.9-1993
Date Issued: October 1, 1996
File: B16-96-003

Question: Can localized wall thickness of formed fittings established by mathematical analysis require a wall thickness that exceeds the minimum wall thickness of the pipe with which the fitting is intended to be used?

Reply: Yes. See B16.9-1993, paragraph 2.2.

Interpretation B16-97-005

Subject: B16.9-1993
Date Issued: June 1, 1997
File: B16-97-005

Question: Can acceptable-proof pressure-test data for an B16.9-1993 “tee” be extended to cover the acceptance of an equivalent size and pressure rated B16.9 “cross”?

Reply: No. A “tee” is not a representative fitting for a “cross.” See paragraph 9.4.

Interpretation B16-97-006

Subject: B16.9-1993
Date Issued: June 1, 1997
File: B16-97-006

Question: Does B16.9-1993, Table 2, B dimensions for 45-degree long-radius elbows ensure that two placed in series would match the dimensions of a 90-degree long-radius elbow?

Reply: No.

Interpretation B16-97-008

Subject: B16.9-1993
Date Issued: August 1, 1997
File: B16-97-008

Question: Do center-to-end dimensions, B, of Table 2, B16.9-1993, for 45-degree elbows require the same bend radius to be used as for the 90-degree long-radius elbows?

Reply: No.

Interpretation B16-97-016:

Subject: B16.9-1993
Date Issued: February 1, 1998
File: B16-97-016

Question (1): Does B16.9-1993 have a tolerance for concentricity between the two ends of concentric reducers?

Reply (1): No.

Question (2): Does B16.9-1993 have an angularity tolerance for concerning the off angle between the two ends of concentric reducers?

Reply (2): Yes. See Table 1.

Interpretation 2-1:

Subject: B16.9-1993
Date Issued: December 6, 1999
File Number: B16-99-015

Question (1): Can Bar Stock meeting ASTM A234 and ASTM A403 be used for the manufacture of ASME B16.9-1993 fittings?

Reply (1): Yes, providing the Bar Stock material qualifies as a forging under the material specifications and the shape rules and fitting size limits of the material specifications are followed. (See Para. 5).

Question (2): Does ASME B16.9-1993 specify the required material marking for ASTM A234 and ASTM A403 fittings manufactured under the partial compliance rules?

Reply (2): No, Marking shall be as agreed on between the manufacturer and purchaser, but the material marking symbol prefix “WP” shall not be used and the marking shall include the “S9” partial compliance marking. (See Para. 4.4).

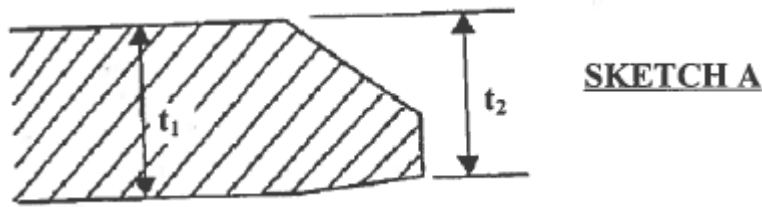
Interpretation 2-2:

Subject: B16.9 and B16.28

Date Issued: January 11, 2000

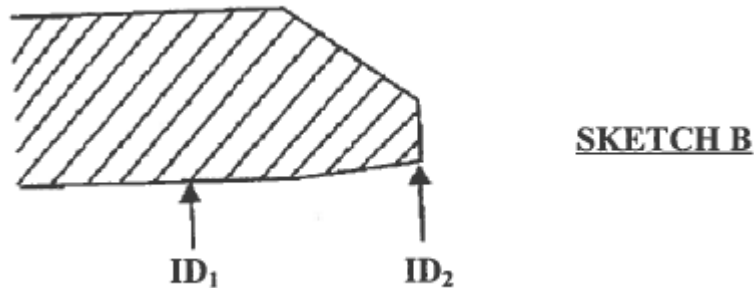
File Number: B16-99-016

Question (1): With reference to Sketch A, what constitutes the fitting minimum wall thickness, t_1 and t_2 , under B16.9-1993 and B16.28-1994 construction rules?



Reply (1): t_2 represents minimum wall.

Question (2): With reference to Sketch B, what constitutes the fitting inside diameter at the weld bevel, ID_1 , or ID_2 , under B16.9-1993 and B16.28-1994 construction rules?



Reply (2): ID_2 represents fitting weld bevel.

Interpretation 2-3:

Subject: Interpretation on B16.9-1993

Date Issued: January 31, 2000

File Number: B16-99-017

Question: Under ASME B16.9-1993 rules, can design proof test data for an 18", 90 degree elbow made from welded construction material be extended to cover the design of a similarly proportioned 10"m 90 degree elbow made of seamless material?

Reply: Yes, see Para. 9.2.1 and Para. 9.4.

Interpretation 2-4:

Subject: Interpretation on B16.9-1993
Date Issued: January 31, 2000
File Number: B16-99-018

Question: Does ASME B16.9-1993 have a tolerance on minimum wall thickness applicable to localized critical areas of a fitting as determined in the proof test of Section 9?

Reply: No, except the thickness cannot be less than 87.5% of nominal thickness. See Table 1.

Interpretation 2-5:

Subject: Interpretation on B16.9-1993
Date Issued: March 7, 2000
File Number: B16-00-002

Question (1): Is it mandatory for the manufacturers of ASME B16.9-1993 fittings to prove the fitting design by mathematical analysis or by proof testing?

Reply (1): Yes, see Para. 2.2.

Question (2): Is achieving of the minimum wall thickness throughout a B16.9-1993 formed fitting sufficient to meet fitting design requirements by the mathematical analysis process?

Reply (2): Yes, see Para. 2.2.

Interpretation 2-6:

Subject: Request for Clarification of B16.9-1993; para. 9.4.3
Date Issued: August 22, 2000
File Number: B16-00-008

Question (1): Does ASME B16.9-1993 permit applying the successful proof test data of a steel fitting be extended to cover a geometrically identical fitting made from a different grade of steel?

Reply (1): Yes, see Para. 9.4.3.

Question (2): Does ASME B16.9-1993 permit applying the successful proof pressure test data of an ASME B16.9-1993 steel fitting to be extended to cover a geometrically identical fitting made of a nonferrous material?

Reply (2): No.

Interpretation 2-7:

Subject: Request for Clarification of B16.9-1993; Table 1
Date Issued: August 28, 2000
File Number: B16-99-010

Question: Does Table 1, ASME B16.9-1993 for Off Angle and Off Plane Angularity Tolerance apply to Reducers, Crosses, and Reducing Elbows?

Reply: Yes, if applicable. See Section 11.

Interpretation 2-8:

Subject: Request for Clarification of B16.9-1993; Figure 2
Date Issued: January 3, 2001
File Number: B16-00-013

Question: If the transition angles given in Figure 2, ASME B16.9, are maximums, can other combinations, including zero degree angles, be used for the $2t$ transition region?

Reply: Yes, providing maximum angles and minimum radii are not violated. See Note (5) Fig. 2.

Interpretation 3-1:

Subject: ASME B16.9-2001, Para. 9.4
Date Issued: January 15, 2002
File Number: B16-01-007

Question (1): Does ASME B16.9-2001 permit the successful proof test data of a B16.9-2001 NPS 8-Schedule 20, 90 deg elbow ($t/D = 0.29$) to be extended to cover the proof test requirement for a B16.9-2001 NPS 20-Standard Schedule, 90 deg elbow ($t/D - 0.018$) under para. 9.4.2?

Reply (1): No, Paragraph 9.4.1 applies as well.

Question (2): Does ASME B16.9-1993 permit the successful proof pressure test data of a ASME B16.9 fitting such as a tee to be applied to qualify a fitting such as an elbow, cap, or reducer?

Reply (2): No. See para. 9.4. Extension of test data shall be from a representative fitting.

Interpretation 3-2:

Subject: ASME B16.9-2001; Para. 2.2 and 9
Date Issued: October 10, 2002
File Number: B16-02-006

Question: Does ASME B16.9-2001 have specific requirements for increasing the wall thickness above the minimum for fittings or particular areas on fittings to meet the pressure rating requirements?

Reply: No. See paras. 9 and 2.2.

Interpretation: 04-1

Subject: B16.9 (2001 Edition); Paragraph 9.4
Date Issued: February 2, 2004
File Number: 03-1255

Question: Does a successful burst test, per the requirements of B16.9-2001, of a long radius 90-degree elbow also qualify a short radius 90-degree elbow of the same size and wall thickness?

Reply: No. Short radius fittings are not similarly proportioned to long radius fittings.

Interpretation: 04-2

Subject: B16.9 (2001 Edition), Paragraph 9.4.3
Date Issued: December 29, 2004
File Number: 03-1517

Question: Is it the intent that the minimum proof test acceptable for the fitting, without rupture, is equal to the computed P when a design proof test to Section 9.0 of ASME B16.9-2001 is performed?

Reply: Yes.

Interpretation: 05-792

Subject: B16.9 (2001 Edition), Paragraph 9
Date Issued: June 9, 2005
File Number: 05-792

Question: Does ASME B16.9-2001 Edition permit the successful proof test of a 90 degree long radius elbow, NPS 30 x schedule extra strong (12.7 mm thick), to be extended to cover a NPS 60 x 25 mm thick 90 degree long radius elbow?

Reply: No. NPS 60 long radius elbows are outside the scope of B16.9-2001. See paragraph 1.1.

Interpretation: 08-1

Subject: B16.9-2003, Paragraph 9.4.1
Date Issued: March 6, 2008
File Number: 07-1822

Question (1): Does the successful proof test of an ASME B16.9-2003 concentric reducer qualify an eccentric reducer?

Reply (1): No. The “representative fitting” basis of 9.4 is not met.

Question (2): Does the successful proof test of an ASME B16.9-2003 reducer with least reduction (e.g. 6 x 5) qualify reducers one-half to twice the size of the tested reducer?

Reply (2): Yes, providing the thickness range ratio t/D of 9.4.2 is met for both the large and small end. See 9.4.1.

Interpretation: 08-2

Subject: B16.9-2003; Para 9.4 - Proof test data
Date Issued: July 10, 2008
File Number: 08-827

Question: Does ASME B16.9-2003 permit the successful proof pressure test of a B16.9 short radius elbow, meeting the requirements of paragraphs 9.4.1, 9.4.2 and 9.4.3, to be extended to cover the proof pressure test requirement for a B16.9 long radius elbow?

Reply: No.

Interpretation: 12-1

Subject: ASME B16.9-2007; Section 4.4 - Compliance & Section 5 - Materials
Date Issued: February 7, 2012
File Number: 11-1802

Question (1): Does ASME B16.9, Section 5, permit only materials manufactured in accordance with the requirements of the listed product standards ASTM A 234, A 403, A 420, A 815, B361, B363 and B366?

Reply (1): Yes.

Question (2): Does ASME B16.9 permit fittings to be marked with "WP" if they fulfill all ASME B16.9 requirements except the Section 5, material, requirement?

Reply (2): No.

Interpretation: 13-1

Subject: B16.9-2011 – Paragraph 1.3
Date Issued: January 3, 2013
File Number: 13-79

Question: Is a wrought lateral fitting, fabricated without welding, meeting all related requirements of the standard considered compliant with the B16.9 Standard in accordance with paragraph 1.2 Special Fittings?

Reply: Yes.

Interpretation: 13-2

Subject: B16.9-2007 – Table 10

Date Issued: April 24, 2013

File Number: 12-392

Question: Does ASME B16.9-2007 table 10 permit the use of length, E in place of “Length, E1” when the cap wall thicknesses is greater than the limiting wall thickness for NPS 24 and smaller.

Reply: No.

Interpretation: 13-3

Subject: B16.9-2001, Para. 9.3

Date Issued: April 24, 2013

File Number: 12-1813

Question: Does a successful burst test, per the requirements of B16.9-2001, of a long radius 90° elbow also qualify a long radius 45° elbow of same size and wall thickness?

Reply: Yes and the rules of 9.4.1, 9.4.2, and 9.4.3 can be applied for further extension of test data

Interpretation: 13-4

Subject: B16.9-2010, Para. 9.4.1

Date Issued: April 24, 2013

File Number: 13-601

Question 1: Does ASME B16.9-2010 define “similarly proportioned fittings”?

Reply 1: No.

Question 2: In 9.4.1, may one test fitting be used to qualify reducing fittings from ½ to twice that of the tested fitting?

Reply 2: Yes.

Interpretation: 14-1

Subject: B16.9-2012, Tolerances

Date Issued: September 24, 2014

File Number: 14-1150

- Question 1: Does ASME B16.9 establish a minimum wall thickness?
- Reply 1: A minimum wall thickness of 87.5% applies unless the purchaser specifies a different wall thickness tolerance. See Table 13.
- Question 2: Does ASME B16.9 establish a maximum wall thickness?
- Reply 2: No, except at the ends. End preparation must conform to the requirements of para. 8.
- Question 3: In ASME B16.9 Table 12, what is meant by the expressions $t < 22(.88)$ and $t > 22(.88)$?
- Reply 3: The expressions describe the nominal wall thicknesses for which the plain and compound bevels are required.
- Question 4: In ASME B16.9, are the tolerances in Table 13 and the tolerances in Table I-12 different?
- Reply 4: Yes. The tolerances in Table 13 are to be used when fittings are manufactured using SI Units, and the tolerances in Table I-12 are to be used when fittings are manufactured using US Customary Units. See para. 1.4.
- Question 4: In ASME B16.9, are the angular tolerances in Table 13 in millimeters?
- Reply 5: Yes. See Note (a).

Interpretation: 15-243

Subject: B16.9-2012, Angularity Tolerance (Q)

Date Issued: April 28, 2015

File Number: 15-243

Question: Does the Q tolerance in ASME B16.9-2012 Table 13 and I-12 apply to all fittings?

Reply: Yes.

Interpretation: 15-425

Subject: B16.9-2012, Dimensions of Reducers

Date Issued: May 26, 2015

File Number: 15-425

Question: Do ASME B16.9-2012 paragraphs 1.2 and 4.4.2 permit manufacture of reducing fittings or reducers not included in Tables 2, I-2, 8, I-8, 11 or I-11?

Reply: Yes.

Interpretation: 14-1911

Subject: B16.9-2012, Table 12, Note 2

Date Issued: May 26, 2015

File Number: 14-1911

Question: Is it the intent that the requirements of ASME B16.9-2012 Table 12 Note 2 for austenitic alloy steel apply to nickel alloys?

Reply: Yes.