

ASME B16.15-2013
(Revision of ASME B16.15-2011)

Cast Copper Alloy Threaded Fittings

Classes 125 and 250

AN AMERICAN NATIONAL STANDARD



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Mechanical Engineers**

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FOREWORD

As early as the spring of 1921, the consolidation and further development of threaded and flanged fittings standards in force in this country seemed desirable. To meet this need, the American Standards Association (ASA) [now the American National Standards Institute (ANSI)] authorized the organization of a Sectional Committee on the Standardization of Pipe Flanges and Flanged Fittings (B16), with the Heating, Piping, and Air Conditioning Contractors' National Association (now known as the Mechanical Contractors Association of America), the Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), and The American Society of Mechanical Engineers acting as joint sponsors.

In June 1927, the Manufacturers Standardization Society of the Valve and Fittings Industry appointed a committee on Nonferrous Screw Fittings for the purpose of developing standards for products commonly designated as threaded pipe fittings of brass, bronze, or other nonferrous materials. At the time, brass threaded fittings were furnished from a number of different patterns with wide variations in dimensions and weights.

MSS SP-10 for 125-lb Bronze Screwed Fittings and MSS SP-11 for 250-lb Bronze Screwed Fittings were developed and adopted by the MSS in September 1930. The lighter fittings were patterned after malleable iron threaded fittings, then standardized in ASA B16c, while the heavier products were patterned after the cast iron threaded fittings covered by ASA B16d. Thus, a practice was standardized that had been found satisfactory in the valve and fittings industry over many years.

Following the publication of revised editions in 1941 and 1943, SP-10 was submitted to Subcommittee No. 2 of ASA Sectional Committee B16 for adoption as an American Standard. Final approval of that edition was granted on January 23, 1947 with the designation ASA B16.15. A reaffirmation of the Standard was granted in 1952, and a complete revision for updating the Standard was approved by ASA on March 25, 1958.

After revision in 1944, SP-11 was submitted to Subcommittee No. 2 in August 1947, and ASA granted the approval of B16.17 on April 6, 1949.

In 1961, Subcommittee No. 2 reviewed the two Standards and noted that the historical reason for their separate existence no longer applied. Accordingly, the two were combined into ASA B16.15 with final ASA approval granted on February 6, 1964.

In 1969, the document was reviewed by Subcommittee No. 2, and minor changes were proposed. Final ANSI approval was granted on April 14, 1971.

In 1977, the MSS submitted a proposed revision to Subcommittee B (formerly No. 2) for B16 review and approval. Changes included the addition of metric (SI) units and editorial updating. ANSI granted final approval on December 4, 1978.

In 1982, American National Standards Committee B16 was reorganized as the ASME B16 Committee, operating under procedures accredited by ANSI. The revision, following regular 5-yr review by Subcommittee B, involved rationalization of metric equivalent dimensions and updating of reference standards. Following approval within ASME, ANSI approval was granted on July 30, 1985 with the new designation ANSI/ASME B16.15-1985.

In 1994, and again in 2004, the document was reaffirmed.

In 2005, Subcommittee B of the ASME B16 Committee changed the title to Cast Copper Alloy Threaded Fittings, a section on leakage capacity was added, and nominal size (DN) according to ISO 6078 was addressed as SI values were positioned in the main text, while U.S. Customary values were positioned in Mandatory Appendix I. The reference for gaging internal fitting threads was made clearer by using the wording from ASME B1.20.1, Pipe Threads, General Purpose (Inch). Many clarifying and editorial revisions were made in order to improve the text. After approval by ASME, ANSI approval was granted on August 25, 2006 with the designation of ASME B16.15-2006.

In 2011, references to ASME standards were revised to no longer list specific edition years; the latest edition of ASME publications applies unless stated otherwise. Materials manufactured to other editions of the referenced ASTM standards have been permitted to be used to manufacture



fittings meeting the requirements of this Standard as long as the fitting manufacturer verifies the material meets the requirements of the referenced edition. Following approval by the Standards Committee and the ASME Board on PTCS, the revision to the 2006 edition was approved as an American National Standard by ANSI on August 9, 2011 with the designation ASME B16.15-2011.

In this 2013 edition, section 7 was revised and now requires threads and gaging practices to be as per and identical with ASME B1.20.1 and other B16 Standards. Following approval by the ASME B16 Standards Committee, approval as an American National Standard was given by ANSI on July 29, 2013 with the new designation ASME B16.15-2013.

All requests for interpretations or suggestions for revisions should be sent to the Secretary, B16 Committee, The American Society of Mechanical Engineers, Two Park Avenue, New York, NY 10016-5990.



ASME B16 COMMITTEE

Standardization of Valves, Flanges, Fittings, and Gaskets

(The following is the roster of the Committee at the time of approval of this Standard.)

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CORRESPONDENCE WITH THE B16 COMMITTEE

General. ASME Standards are developed and maintained with the intent to represent the consensus of concerned interests. As such, users of this Standard may interact with the Committee by requesting interpretations, proposing revisions, and attending Committee meetings. Correspondence should be addressed to:

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

As an alternative, inquiries may be submitted via email to: 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.

Proposing a Case. Cases may be issued for the purpose of providing alternative rules when justified, to permit early implementation of an approved revision when the need is urgent, or to provide rules not covered by existing provisions. Cases are effective immediately upon ASME approval and shall be posted on the ASME Committee Web page.

Requests for Cases shall provide a Statement of Need and Background Information. The request should identify the Standard, the paragraph, figure or table number(s), and be written as a Question and Reply in the same format as existing Cases. Requests for Cases should also indicate the applicable edition(s) of the Standard to which the proposed Case applies.

Interpretations. Upon request, the B16 Committee will render an interpretation of any requirement of the Standard. Interpretations can only be rendered in response to a written request sent to the Secretary of the B16 Standards Committee.

The request for interpretation should be clear and unambiguous. It is further recommended that the inquirer submit his/her request in the following format:

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 design 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.

ASME procedures provide for reconsideration of any interpretation when or if additional information that might affect an interpretation is available. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME Committee or Subcommittee. ASME does not "approve," "certify," "rate," or "endorse" any item, construction, proprietary device, or activity.

Attending Committee Meetings. The B16 Standards Committee regularly holds meetings, which are open to the public. Persons wishing to attend any meeting should contact the Secretary of the B16 Standards Committee.



ASME B16.15-2013

SUMMARY OF CHANGES

Following approval by the ASME B16 Committee and ASME, and after public review, ASME B16.15-2013 was approved by the American National Standards Institute on July 29, 2013.

ASME B16.15-2013 includes the following changes identified by a margin note, **(13)**.

<i>Page</i>	<i>Location</i>	<i>Change</i>
2	Section 7	Revised in its entirety
12	Table 9	Note (1) revised
25	Table I-9	Note (1) revised
29	Mandatory Appendix II	ASME B18.2.2 replaced by ASME B18.2.1



CAST COPPER ALLOY THREADED FITTINGS

Classes 125 and 250

1 SCOPE

This Standard covers cast Classes 125 and 250 copper alloy threaded pipe fittings with provisions for substituting wrought copper alloys for plugs, bushings, caps, and couplings in small sizes. This Standard includes the following:

- (a) pressure–temperature ratings
 - (b) size and method of designating openings of reducing pipe fittings
 - (c) marking requirements
 - (d) minimum requirements for casting quality and materials
 - (e) dimensions and tolerances in SI (metric) and U.S. Customary units
 - (f) threading requirements
 - (g) pressure test requirements
- Mandatory Appendix I provides table values in U.S. Customary units.

2 GENERAL

2.1 Relevant Units

This Standard states values in both SI (Metric) and U.S. Customary units. 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 that appear in Mandatory Appendix I. 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. Combining values from the two systems constitutes nonconformance with the Standard.

2.2 References

Standards and specifications containing provisions to the extent referenced herein constitute requirements of this Standard. These referenced documents are listed in Mandatory Appendix II.

2.3 Quality Systems

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

2.4 Denotation

2.4.1 Pressure Rating Designation. Class followed by a dimensionless number is the designation for pressure–temperature ratings, e.g., Class 125 and Class 250.

2.4.2 Size. NPS followed by a dimensionless number is the designation for nominal fittings size, e.g., NPS 2.

2.5 Time of Purchase, Manufacture, or Installation

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

2.6 User Accountability

This Standard cites responsibilities that are to be assumed by the fitting user in the areas of the temperature at which the pressure rating is taken.

2.7 Service Conditions

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

3 PRESSURE–TEMPERATURE RATINGS

3.1 General

Pressure–temperature ratings for these pipe fittings are shown in Tables 1 and I-1. All pressures are gage.

3.2 Rating

Pressure–temperature ratings are independent of the contained fluid and are the maximum allowable pressures at the tabulated temperatures. Intermediate ratings may be obtained by linear interpolation between the temperatures shown.

The temperature shown for the corresponding pressure rating shall be the material temperature of the

