

## INTERPRETATIONS TO ASME B16.25

(These Interpretations are not part of ASME B16.25-1992 and are included for information only.)

### INTRODUCTION

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### PROCEDURE FOR REQUESTING INTERPRETATIONS

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Secretary, B16 Main Committee  
The American Society of Mechanical Engineers  
United Engineering Center  
345 East 47th Street  
New York, NY 10017

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**INTERPRETATIONS NO. 1**

Replies to Technical Inquiries Issued from January 1, 1987, through November 30, 1992

**Interpretation: 1-1**

Subject: Finish of Buttwelding Ends

Date Issued: April 19, 1991

File: B16-91-005

Question (1): Do all buttwelding ends conforming to ASME/ANSI B16.25-1986 require a total or partially machined finish to achieve final dimensions?

Reply (1): No.

Question (2): Is an as-cast finish of buttwelding ends conforming to Figure 2(a), ASME/ANSI B16.25-1986, including dimensions and tolerances, acceptable?

Reply (2): Yes.

## AMERICAN NATIONAL STANDARDS FOR PIPING, PIPE FLANGES, FITTINGS, AND VALVES

Scheme for the Identification of Piping Systems .....	A13.1-1981(R1985)
Pipe Threads, General Purpose (Inch) .....	B1.20.1-1983(R1992)
Dryseal Pipe Threads (Inch) .....	B1.20.3-1976(R1991)
Cast Iron Pipe Flanges and Flanged Fittings .....	B16.1-1989
Malleable Iron Threaded Fittings, Class 150 and 300 .....	B16.3-1985
Cast Iron Threaded Fittings, Classes 125 and 250 .....	B16.4-1985
Pipe Flanges and Flanged Fittings .....	B16.5-1988
Factory-Made Wrought Steel Buttwelding Fittings .....	B16.9-1986
Face-to-Face and End-to-End Dimensions of Valves .....	B16.10-1986
Forged Fittings, Socket-Welding and Threaded .....	B16.11-1991
Cast Iron Threaded Drainage Fittings .....	B16.12-1991
Ferrous Pipe Plugs, Bushings, and Locknuts with Pipe Threads .....	B16.14-1991
Cast Bronze Threaded Fittings, Class 125 and 250 .....	B16.15-1985
Cast Copper Alloy Solder Joint Pressure Fittings .....	B16.18-1984
Ring-Joint Gaskets and Grooves for Steel Pipe Flanges .....	B16.20-1973
Nonmetallic Flat Gaskets for Pipe Flanges .....	B16.21-1992
Wrought Copper and Copper Alloy Solder Joint Pressure Fittings .....	B16.22-1989
Cast Copper Alloy Solder Joint Drainage Fittings — DWV .....	B16.23-1992
Cast Copper Alloy Pipe Flanges and Flanged Fittings, Class 150, 300, 400, 600, 900, 1500, and 2500 .....	B16.24-1991
Buttwelding Ends .....	B16.25-1992
Cast Copper Alloy Fittings for Flared Copper Tubes .....	B16.26-1988
Wrought Steel Buttwelding Short Radius Elbows and Returns .....	B16.28-1986
Wrought Copper and Wrought Copper Alloy Solder Joint Drainage Fittings — DWV .....	B16.29-1986
Cast Copper Alloy Solder Joint Fittings for Solvent Drainage Systems .....	B16.32-1992
Manually Operated Metallic Gas Valves for Use in Gas Piping Systems Up to 125 psig (Sizes ½ Through 2) .....	B16.33-1990
Valves — Flanged, Threaded, and Welding End .....	B16.34-1988
Orifice Flanges .....	B16.36-1988
Large Metallic Valves for Gas Distribution (Manually Operated, NPS 2½ to 12, 125 psig Maximum) ..	B16.38-1985
Malleable Iron Threaded Pipe Unions, Classes 150, 250, and 300 .....	B16.39-1986
Manually Operated Thermoplastic Gas Shutoffs and Valves in Gas Distribution Systems .....	B16.40-1985
Functional Qualification Requirements for Power Operated Active Valve Assemblies for Nuclear Power Plants .....	B16.41-1983(R1989)
Ductile Iron Pipe Flanges and Flanged Fittings, Class 150 and 300 .....	B16.42-1987
Wrought Copper and Copper Alloy Solder Joint Fittings for Solvent® Drainage Systems .....	B16.43-1982
Cast Iron Fittings for Solvent® Drainage Systems .....	B16.45-1987
Large Diameter Steel Flanges (NPS 26 Through NPS 60) .....	B16.47-1990
Power Piping .....	B31.1-1989
Fuel Gas Piping .....	B31.2-1968
Chemical Plant and Petroleum Refinery Piping .....	B31.3-1990
Liquid Transportation Systems for Hydrocarbons, Liquid Petroleum Gas, Anhydrous Ammonia, and Alcohols .....	B31.4-1989
Refrigeration Piping .....	B31.5-1987
Gas Transmission and Distribution Piping Systems .....	B31.8-1989
Building Services Piping .....	B31.9-1988
Slurry Transportation Piping Systems .....	B31.11-1989
ASME Guide for Gas Transmission and Distribution Piping Systems — 1986 (not an ANSI Standard) .....	
Manual for Determining the Remaining Strength of Corroded Pipelines (not an ANSI Standard) .....	B31G-1991
Welded and Seamless Wrought Steel Pipe .....	B36.10M-1985
Stainless Steel Pipe .....	B36.19M-1985
Self-Operated and Power-Operated Safety-Related Valves Functional Specification Standard ..	N278.1-1975(R1984)

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# ASME B16.25 INTERPRETATIONS

## Replies to Technical Inquiries November 31, 1992, through December 31, 1996

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**Interpretation: 2-1**

Subject: Internal Transition of Buttwelded Pipe

Date Issued: September 27, 1993

File: B16-93-012

Question: Are the requirements for the internal transition of a 4 in. Schedule 40 pipe when buttwelded to 4 in. Schedule 10 pipe using a gas tungsten arc welding (GTAW) root pass procedure covered by ASME B16.25-1992?

Reply: No. See Section 2.

**Interpretation: 2-2**

Subject: Counterbore End Preparations

Date Issued: August 24, 1995

File: B16-95-002

Question: When providing counterbore end preparations in accordance with ASME B16.25-1992, Fig. 2, 3, 5, or 6, is it necessary to have a tapered transition in the inside diameter within the  $2t_{\min}$  transition region as long as the provided slope or alternate radius does not break the solid 1:3 maximum slope line?

Reply: No. Figure 1 allows any slope to be used in the  $2t_{\min}$  transition region.