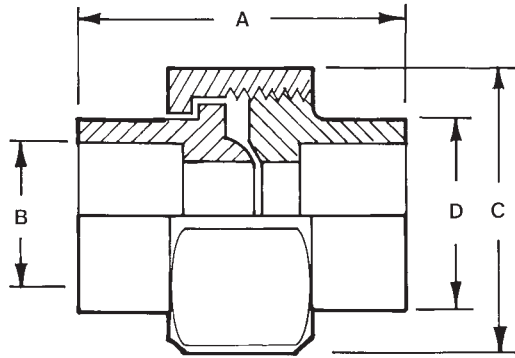


# Socket-Welding Unions



- Unions and fittings shall be made from forgings or bar stock by machining or forging or by a combination of these operations.
- Unless otherwise specified, random samples shall be selected with lot acceptance based on sampling requirements of MIL-STD-105-D.
- Each of the samples shall be subjected to visual and dimensional inspection to determine compliance with the requirements of this drawing.
- Each fitting or component shall be capable of withstanding a hydro test pressure of  $1\frac{1}{2}$  times the rated working pressure with no leakage or deformation.
- The dimensions for manufacturing shall meet or exceed the minimum requirements of NAVSEA Dwg. 810-1385884-Rev. J., or MSS SP-83 (Ground joint unions).
- All components can be produced from the following material; Union Nuts\* and Fittings: UNS C70600 (90-10) , UNS C71500 (70-30), and Ni-Cu (Monel™).
- Unless otherwise specified the material used shall be; Union Nuts: Class 3000 PSI Bronze (Brass) 6000 PSI Ni-Cu (Monel™) Fittings: Class 3000 & 6000 PSI 70-30 Cu-Ni.
- Socket-Weld ends can be adapted for silver brazing rings (MIL F-1183).

## Class 3000

Nominal Pipe Size	A	B	C	D	E
$\frac{1}{8}$	$1\frac{5}{8}$	$\frac{7}{8}$	$1\frac{3}{8}$	$\frac{5}{8}$	.420
$\frac{1}{4}$	$1\frac{5}{8}$	$\frac{7}{8}$	$1\frac{3}{8}$	$\frac{3}{8}$	.550
$\frac{3}{8}$	$1\frac{13}{16}$	$1\frac{1}{4}$	$1\frac{5}{8}$	$\frac{7}{16}$	.690
$\frac{1}{2}$	$1\frac{15}{16}$	$1\frac{1}{32}$	$1\frac{27}{32}$	$\frac{1}{2}$	.885
$\frac{3}{4}$	$2\frac{1}{4}$	$1\frac{15}{32}$	$2\frac{3}{16}$	$\frac{9}{16}$	1.065
1	$2\frac{1}{2}$	$1\frac{51}{64}$	$2\frac{1}{2}$	$\frac{41}{64}$	1.330
$1\frac{1}{4}$	$2\frac{13}{16}$	$2\frac{11}{64}$	$3\frac{1}{16}$	$\frac{11}{16}$	1.675
$1\frac{1}{2}$	3	$2\frac{15}{32}$	$3\frac{13}{32}$	$\frac{3}{4}$	1.915
2	$3\frac{3}{8}$	$3\frac{1}{32}$	$4\frac{3}{32}$	$\frac{7}{8}$	2.406

Dimensions are in inches.

\*Union nuts can be produced from Bronze (Brass).