Детали трубопроводов бесшовные приварные  
из углеродистой и низколегированной стали

**М е ж г о с у д а р с т в е н н ы й с т а н д а р т**

ОТВОДЫ КРУТОИЗОГНУТЫЕ  
ТИПА 3D (R » 1,5 DN)

Конструкция

Издание официальное

**МЕЖГОСУДАРСТВЕННЫЙ совет  
ПО СТАНДАРТИЗАЦИИ, МЕТРОЛОГИИ И СЕРТИФИКАЦИИ**

Минск

Предисловие

1. РАЗРАБОТАН ОАО «Корпорация МОНТАЖСПЕЦСТРОЙ»

ВНЕСЕН Государственным комитетом Российской Федерации по стандартизации и метрологии.

1. ПРИНЯТ Межгосударственным советом по стандартизации, метрологии и сертификации (протокол № 20 от 1 ноября 2001 г.)

За принятие проголосовали:

|  |  |
| --- | --- |
| Наименование государства | Наименование национального органа по стандартизации |
| Азербайджанская Республика | Азгосстандарт |
| Республика Армения | Армгосстандарт |
| Республика Беларусь | Госстандарт Республики Беларусь |
| Грузия | Грузстандарт |
| Республика Казахстан | Госстандарт Республики Казахстан |
| Кыргызская республика | Кыргызстандарт |
| Республика Молдова | Молдовастандарт |
| Российская федерация | Госстандарт России |
| Туркменистан | Главгосслужба «Туркменстандартлары» |
| Республика Узбекистан | Узгосстандарт |
| Украина | Г осстандарт Украины |

1. Стандарт соответствует ИСО 3419-81 «Фитинги и легированной и нелегированной стали приварные встык» в части конструкции отводов.
2. Постановление Государственного комитета Российской федерации по стандартизации и метрологии от 27 мая 2002 г. № 205-ст межгосударственный стандарт ГОСТ 17375-2001 (ИСО 3419-81) введен в действие непосредственно в качестве государственного стандарта Российской Федерации с 1 января 2003 г.
3. ВЗАМЕН ГОСТ 17375-83

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М е ж г о с у д а р с т в е н н ы й с т а н д а р т

Детали трубопроводов бесшовные приварные из углеродистой  
и низколегированной стали

ОТВОДЫ КРУТОИЗОГНУТЫЕ ТИПА 3D (R » 1,5 DN)

Конструкция

Carbom and low-alloy steel butt-welding fitting/ Sharply curved bends type 3D (R » 1,5 DN)/ Design Дата введения 2003-01-01

1. Область применения

Настоящий стандарт распространяется на бесшовные приварные отводы из углеродистой и низколегированной стали типа R » 1,5 DN и 0 = 90° и 0 = 180°, изготавливаемые из труб методами штамповки или протяжки по рогообразному сердечнику.

Область применения отводов-в соответствии с разделом 1 ГОСТ 17380.

Требования пункта 4.1. и раздела 5 являются обязательными, остальные требования - рекомендуемыми.

1. Нормативные ссылки

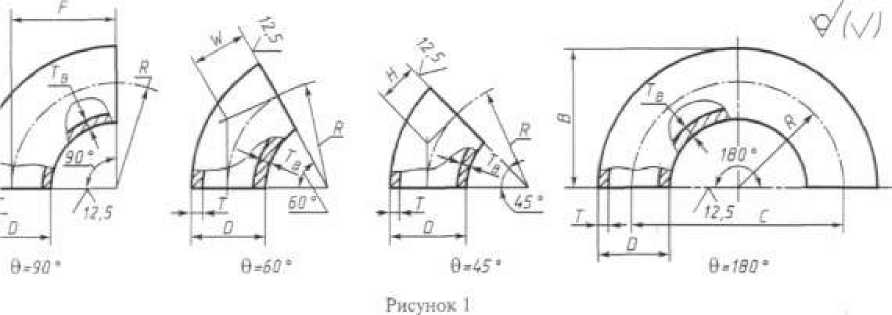
В настоящем стандарте использована ссылка на ГОСТ 17380-2001. Детали трубопроводов бесшовные приварные из углеродистой и низколегированной стали. Общие технические условия.

1. Определения, обозначения и сокращения

Термины, их определения, обозначения и сокращения по ГОСТ 17380.

1. Конструкция и размеры

4.1. Конструкция и размеры отводов должны соответствовать указанным на рисунке 1 в таблицах 1 и 2.



Издание официальное

Таблица 1 - Отводы исполнения 1

|  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| DN | D | T | F = R | H | C | B | Масса, кг, Отвода с 6 | |  |
| 45° | 90° | 180° |
|  |  | 2,0 |  |  |  |  | 0,02 | 0,04 | 0,08 |
| 15 | 21,3 | 3,2 | 28 | 14 | 56 | 38 | 0,03 | 0,06 | 0,12 |
|  |  | 4,0 |  |  |  |  | 0,04 | 0,07 | 0,14 |
|  |  | 2,0 |  |  |  |  | 0,03 | 0,06 | 0,11 |
| 20 | 26,9 | 3,2 | 29 | 14 | 58 | 43 | 0,04 | 0,08 | 0,17 |
|  |  | 4,0 |  |  |  |  | 0,06 | 0,10 | 0,20 |
|  |  | 2,3 |  |  |  |  | 0,05 | 0,11 | 0,21 |
| 25 | 33,7 | 3,2 | 38 | 18 | 76 | 56 | 0,08 | 0,16 | 0,23 |
|  |  | 4,5 |  |  |  |  | 0,09 | 0,19 | 0,38 |
|  |  | 2,6 |  |  |  |  | 0,10 | 0,19 | 0,39 |
| 32 | 42,4 | 3,6 | 48 | 23 | 96 | 69 | 0,13 | 0,26 | 0,52 |
|  |  | 5,0 |  |  |  |  | 0,17 | 035 | 0,60 |
|  |  | 2,6 |  |  |  |  | 0,13 | 0,26 | 0,53 |
| 40 | 48,3 | 3,6 | 57 | 29 | 114 | 82 | 0,18 | 0,36 | 0,72 |
|  |  | 5,0 |  |  |  |  | 0,24 | 0,47 | 0,95 |
|  |  | 2,9 |  |  |  |  | 0,25 | 0,50 | 0,99 |
| 50 | 60,3 | 4,0 | 76 | 35 | 152 | 106 | 0,33 | 0,67 | 1,30 |
|  |  | 5,6 |  |  |  |  | 0,50 | 0,89 | 1,80 |
|  |  | 2,9 |  |  |  |  | 0,40 | 0,79 | 1,60 |
| 65 | 76,1 | 5,0 | 95 | 44 | 190 | 133 | 0,72 | 1,50 | 2,90 |
|  |  | 7,1 |  |  |  |  | 0,90 | 1,80 | 3,60 |
|  |  | 3,2 |  |  |  |  | 0,60 | 1,20 | 2,40 |
| 80 | 88,9 | 5,6 | 114 | 51 | 228 | 159 | 1,00 | 2,10 | 4,10 |
|  |  | 8,0 |  |  |  |  | 1,40 | 2,80 | 5,70 |
|  |  | 3,6 |  |  |  |  | 1,20 | 2,40 | 4,70 |
| 100 | 114,3 | 6,3 | 152 | 64 | 304 | 210 | 2,00 | 4,00 | 8,00 |
|  |  | 8,8 |  |  |  |  | 2,80 | 5,40 | 11,00 |
|  |  | 4,0 |  |  |  |  | 2,00 | 4,00 | 8,00 |
| 125 | 139,7 | 6,3 | 190 | 79 | 380 | 260 | 3,10 | 6,20 | 12,00 |
|  |  | 10,0 |  |  |  |  | 4,80 | 9,60 | 19,00 |
|  |  | 4,5 |  |  |  |  | 3,20 | 6,50 | 13,00 |
| 150 | 168,3 | 7,1 | 229 | 95 | 457 | 313 | 5,10 | 10,00 | 20,00 |
|  |  | 11,0 |  |  |  |  | 7,70 | 15,00 | 31,00 |
|  |  | 6,3 |  |  |  |  | 8,00 | 16,00 | 32,00 |
| 200 | 219,1 | 8,0 | 305 | 127 | 610 | 414 | 9,90 | 20,00 | 40,00 |
|  |  | 12,5 |  |  |  |  | 14,00 | 31,00 | 61,00 |
|  |  | 6,3 |  |  |  |  | 12,00 | 25,00 | 50,00 |
| 250 | 273,0 | 10,0 | 381 | 159 | 762 | 518 | 19,00 | 39,00 | 78,00 |
|  |  | 7,1 |  |  |  |  | 20,00 | 40,00 | 80,00 |
| 300 | 323,9 | 10,0 | 457 | 190 | 914 | 619 | 28,00 | 56,00 | 111,00 |

Размеры в миллиметрах

|  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| DN | D | T | F = R | H | C | B | Масса, кг, Отвода с 9 | |  |
| 45° | VO  о  о | 180° |
| 350 | 355,6 | 8,0  11,0 | 533 | 222 | 1066 | 711 | 24.00  39.00 | 57.00  78.00 | 114.00  156.00 |
| 400 | 406,4 | 8,8  12,5 | 610 | 254 | 1220 | 813 | 41.00  58.00 | 82,00  117,00 | 165.00  234.00 |
| 450 | 457,0 | 10,0 | 686 | 286 | 1372 | 914 | 59,00 | 119,00 | 237,00 |
| 500 | 508,0 | 11,0 | 762 | 318 | 1524 | 1016 | 81,00 | 126,00 | 323,00 |
| 600 | 610,0 | 12,5 | 914 | 381 | 1828 | 1219 | 133,00 | 266,00 | 531,00 |
| 700 | 711,0 | - | 1067 | 444 | 2134 | 1422 | - | - | - |
| 800 | 813,0 | - | 1219 | 507 | 2238 | - | - | - | - |
| 900 | 914,0 | - | 1372 | 570 | 2744 | - | - | - | - |
| 1000 | 1016,0 | - | 1524 | 634 | 3048 | - | - | - | - |

П р и м е ч а н и я

1. Масса приведена для справок.
2. Отводы с 9 = 60° исполнения 1 не предусматриваются.

Таблица 2 - Отводы исполнения 2

Размеры в миллиметрах

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| DN | D | T | F = R | W | H | C | B | Масса отвода с 9 = 90°, кг |
|  |  | 2,0 |  |  |  |  |  | 0,1 |
| 25 | 32 | 2,5 | 38 | 22 | 18 | 76 | 56 | 0,2 |
|  |  | 3,0 |  |  |  |  |  | 0,2 |
|  |  | 3,5 |  |  |  |  |  | 0,2 |
|  |  | 2,0 |  |  |  |  |  | 0,2 |
|  |  | 2,5 |  |  |  |  |  | 0,2 |
| 32 | 38 | 3,0 | 48 | 28 | 23 | 96 | 69 | 0,2 |
|  |  | 3,5 |  |  |  |  |  | 0,3 |
|  |  | 4,0 |  |  |  |  |  | 0,3 |
|  |  | 2,5 |  |  |  |  |  | 0,3 |
|  |  | 3,0 |  |  |  |  |  | 0,3 |
| 40 | 45 | 3,5 | 60 | 35 | 25 | 120 | 83 | 0,4 |
|  |  | 4,0 |  |  |  |  |  | 0,4 |
|  |  | 5,0 |  |  |  |  |  | 0,5 |
|  |  | 2,5 |  |  |  |  |  | 0,4 |
|  |  | 3,0 |  |  |  |  |  | 0,5 |
|  |  | 3,5 |  |  |  |  |  | 0,6 |
| 50 | 57 | 4,0 | 75 | 43 | 80 | 150 | 104 | 0,7 |
|  |  | 4,5 |  |  |  |  |  | 0,7 |
|  |  | 5,0 |  |  |  |  |  | 0,8 |
|  |  | 5,5 |  |  |  |  |  | 0,9 |
|  |  | 6,0 |  |  |  |  |  | 1,0 |

Продолжение таблицы 2

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| DN | D | T | F = R | W | H | C | B | Масса отвода с 0 = 90°, кг |
|  |  | 3,0 |  |  |  |  |  | 0,8 |
|  |  | 3,5 |  |  |  |  |  | 1,0 |
|  |  | 4,0 |  |  |  |  |  | 1,1 |
|  |  | 4,5 |  |  |  |  |  | 1,3 |
| 65 | 76 | 5,0 | 100 | 57 | 41 | 200 | 138 | 1,4 |
|  |  | 5,5 |  |  |  |  |  | 1,6 |
|  |  | 6,0 |  |  |  |  |  | 1,7 |
|  |  | 7,0 |  |  |  |  |  | 2,0 |
|  |  | 8,0 |  |  |  |  |  | 2,2 |
|  |  | 3,0 |  |  |  |  |  | 1,2 |
|  |  | 3,5 |  |  |  |  |  | 1,4 |
|  |  | 4,0 |  |  |  |  |  | 1,5 |
|  |  | 4,5 |  |  |  |  |  | 1,7 |
| 80 | 89 | 5,0 | 120 | 69 | 50 | 240 | 165 | 1,9 |
|  |  | 5,5 |  |  |  |  |  | 2,1 |
|  |  | 6,0 |  |  |  |  |  | 2,3 |
|  |  | 7,0 |  |  |  |  |  | 2,7 |
|  |  | 8,0 |  |  |  |  |  | 3,0 |
|  |  | 3,5 |  |  |  |  |  | 2,1 |
|  |  | 4,0 |  |  |  |  |  | 2,4 |
|  |  | 4,5 |  |  |  |  |  | 2,6 |
|  |  | 5,0 |  |  |  |  |  | 2,9 |
|  | 102 | 6,0 |  |  |  |  | 201 | 3,4 |
|  |  | 7,0 |  |  |  |  |  | 3,9 |
|  |  | 8,0 |  |  |  |  |  | 4,5 |
|  |  | 9,0 |  |  |  |  |  | 5,0 |
|  |  | 10,0 |  |  |  |  |  | 5,5 |
|  |  | 3,5 |  |  |  |  |  | 2,2 |
|  |  | 4,0 |  |  |  |  |  | 2,5 |
|  |  | 4,5 |  |  |  |  |  | 2,8 |
|  |  | 5,0 |  |  |  |  |  | 3,1 |
|  | 108 | 6,0 |  |  |  |  | 204 | 3,6 |
| 100 |  | 7,0 | 150 | 87 | 62 | 300 |  | 4,1 |
|  |  | 8,0 |  |  |  |  |  | 4,7 |
|  |  | 9,0 |  |  |  |  |  | 5,3 |
|  |  | 10,0 |  |  |  |  |  | 5,8 |
|  |  | 3,5 |  |  |  |  |  | 2,2 |
|  |  | 4,0 |  |  |  |  |  | 2,6 |
|  |  | 4,5 |  |  |  |  |  | 2,9 |
|  |  | 5,0 |  |  |  |  |  | 3,3 |
|  | 114 | 6,0 |  |  |  |  | 207 | 3,8 |
|  |  | 7,0 |  |  |  |  |  | 4,4 |
|  |  | 8,0 |  |  |  |  |  | 5,0 |
|  |  | 9,0 |  |  |  |  |  | 5,7 |
|  |  | 10,0 |  |  |  |  |  | 6,1 |
|  |  | 3,5 |  |  |  |  |  | 3,3 |
|  |  | 4,0 |  |  |  |  |  | 3,8 |
| 125 | 133 | 4,5 | 190 | 110 | 79 | 380 | 257 | 4,3 |
|  |  | 5,0 |  |  |  |  |  | 4,8 |
|  |  | 6,0 |  |  |  |  |  | 5,7 |
|  |  | 7,0 |  |  |  |  |  | 6,5 |

**Размеры в миллиметрах**

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| DN | D | T | F = R | W | H | C | B | Масса отвода с 0 = 90°, кг |
|  |  | 8,0 |  |  |  |  |  | 7,4 |
|  |  | 9,0 |  |  |  |  |  | 8,2 |
| 125 | 133 | 10,0 | 190 | 110 | 79 | 380 | 257 | 9,1 |
|  |  | 11,0 |  |  |  |  |  | 10,0 |
|  |  | 12,0 |  |  |  |  |  | 11,0 |
|  |  | 4,0 |  |  |  |  |  | 5,4 |
|  |  | 4,5 |  |  |  |  |  | 6,1 |
|  |  | 5,0 |  |  |  |  |  | 6,7 |
|  |  | 6,0 |  |  |  |  |  | 8,1 |
|  |  | 7,0 |  |  |  |  |  | 9,4 |
|  |  | 8,0 |  |  |  |  |  | 11,0 |
|  | 159 | 9,0 |  |  |  |  |  | 12,0 |
|  |  | 10,0 |  |  |  |  |  | 13,0 |
|  |  | 11,0 |  |  |  |  |  | 14,0 |
|  |  | 12,0 |  |  |  |  |  | 16,0 |
|  |  | 13,0 |  |  |  |  |  | 17,0 |
|  |  | 14,0 |  |  |  |  |  | 18,0 |
| 150 |  | 4,0 | 225 | 130 | 93 | 450 | 305 | 5,6 |
|  |  | 4,50 |  |  |  |  |  | 6,4 |
|  |  | 5,0 |  |  |  |  |  | 7,1 |
|  |  | 6,0 |  |  |  |  |  | 8,5 |
|  |  | 7,0 |  |  |  |  |  | 9,8 |
|  |  | 8,0 |  |  |  |  |  | 11,2 |
|  | 168 | 9,0 |  |  |  |  |  | 12,5 |
|  |  | 10,0 |  |  |  |  |  | 14,0 |
|  |  | 11,0 |  |  |  |  |  | 15,0 |
|  |  | 12,0 |  |  |  |  |  | 16,0 |
|  |  | 13,0 |  |  |  |  |  | 17,5 |
|  |  | 14,0 |  |  |  |  |  | 19,0 |
|  |  | 5,0 |  |  |  |  |  | 13,0 |
|  |  | 6,0 |  |  |  |  |  | 15,0 |
|  |  | 7,0 |  |  |  |  |  | 17,0 |
|  |  | 8,0 |  |  |  |  |  | 20,0 |
|  |  | 9,0 |  |  |  |  |  | 22,0 |
|  |  | 10,0 |  |  |  |  |  | 25,0 |
| 200 | 219 | 11,0 | 300 | 173 | 124 | 600 | 410 | 27,0 |
|  |  | 12,0 |  |  |  |  |  | 29,0 |
|  |  | 13,0 |  |  |  |  |  | 32,0 |
|  |  | 14,0 |  |  |  |  |  | 34,0 |
|  |  | 15,0 |  |  |  |  |  | 37,0 |
|  |  | 16,0 |  |  |  |  |  | 39,0 |
|  |  | 17,0 |  |  |  |  |  | 42,0 |
|  |  | 18,0 |  |  |  |  |  | 44,0 |
|  |  | 6,0 |  |  |  |  |  | 23,0 |
|  |  | 7,0 |  |  |  |  |  | 27,0 |
|  |  | 8,0 |  |  |  |  |  | 31,0 |
| 250 | 273 | 9,0 | 375 | 217 | 155 | 750 | 512 | 35,0 |
|  |  | 10,0 |  |  |  |  |  | 39,0 |
|  |  | 11,0 |  |  |  |  |  | 43,0 |
|  |  | 12,0 |  |  |  |  |  | 46,0 |
|  |  | 13,0 |  |  |  |  |  | 50,0 |
|  |  | 14,0 |  |  |  |  |  | 54,0 |

Продолжение таблицы 2

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| DN | D | T | F = R | W | H | C | B | Масса отвода с 0 = 90°, кг |
|  |  | 15,0 |  |  |  |  |  | 58,0 |
|  |  | 16,0 |  |  |  |  |  | 61,0 |
| 250 | 273 | 17,0 | 375 | 217 | 155 | 750 | 512 | 66,0 |
|  |  | 18,0 |  |  |  |  |  | 70,0 |
|  |  | 20,0 |  |  |  |  |  | 78,0 |
|  |  | 22,0 |  |  |  |  |  | 85,0 |
|  |  | 7,0 |  |  |  |  |  | 39,0 |
|  |  | 8,0 |  |  |  |  |  | 45,0 |
|  |  | 9,0 |  |  |  |  |  | 50,0 |
|  |  | 10,0 |  |  |  |  |  | 56,0 |
|  |  | 11,0 |  |  |  |  |  | 61,0 |
|  |  | 12,0 |  |  |  |  |  | 66,0 |
|  |  | 13,0 |  |  |  |  |  | 72,0 |
| 300 | 325 | 14,0 | 450 | 260 | 186 | 900 | 613 | 77,0 |
|  |  | 15,0 |  |  |  |  |  | 82,0 |
|  |  | 16,0 |  |  |  |  |  | 87,0 |
|  |  | 17,0 |  |  |  |  |  | 92,0 |
|  |  | 18,0 |  |  |  |  |  | 96,0 |
|  |  | 20,0 |  |  |  |  |  | 107,0 |
|  |  | 22,0 |  |  |  |  |  | 118,0 |
|  |  | 24,0 |  |  |  |  |  | 130,0 |
|  |  | 26,0 |  |  |  |  |  | 141,0 |
|  |  | 28,0 |  |  |  |  |  | 150,0 |
|  |  | 9,0 |  |  |  |  |  | 68,0 |
|  |  | 10,0 |  |  |  |  |  | 75,0 |
|  |  | 11,0 |  |  |  |  |  | 83,0 |
|  |  | 12,0 |  |  |  |  |  | 90,0 |
|  |  | 13,0 |  |  |  |  |  | 97,0 |
|  |  | 14,0 |  |  |  |  |  | 104,0 |
|  |  | 15,0 |  |  |  |  |  | 112,0 |
| 350 | 377 | 16,0 | 525 | 303 | 217 | 1050 | 714 | 119,0 |
|  |  | 18,0 |  |  |  |  |  | 133,0 |
|  |  | 20,0 |  |  |  |  |  | 147,0 |
|  |  | 22,0 |  |  |  |  |  | 161,0 |
|  |  | 24,0 |  |  |  |  |  | 175,0 |
|  |  | 26,0 |  |  |  |  |  | 188,0 |
|  |  | 28,0 |  |  |  |  |  | 201,0 |
|  |  | 30,0 |  |  |  |  |  | 214,0 |
|  |  | 32,0 |  |  |  |  |  | 228,0 |
|  |  | 8,0 |  |  |  |  |  | 78,0 |
|  |  | 9,0 |  |  |  |  |  | 87,0 |
|  |  | 10,0 |  |  |  |  |  | 97,0 |
|  |  | 11,0 |  |  |  |  |  | 107,0 |
|  |  | 12,0 |  |  |  |  |  | 117,0 |
|  |  | 13,0 |  |  |  |  |  | 126,0 |
| 400 | 426 | 14,0 | 600 | 346 | 248 | 1200 | 813 | 135,0 |
|  |  | 15,0 |  |  |  |  |  | 145,0 |
|  |  | 16,0 |  |  |  |  |  | 154,0 |
|  |  | 17,0 |  |  |  |  |  | 164,0 |
|  |  | 18,0 |  |  |  |  |  | 137,0 |
|  |  | 20,0 |  |  |  |  |  | 192,0 |
|  |  | 22,0 |  |  |  |  |  | 210,0 |
|  |  | 24,0 |  |  |  |  |  | 230,0 |

Размеры в миллиметрах

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| DN | D | T | F = R | W | H | C | B | Масса отвода с 0 = 90°, кг |
|  |  | 26,0 |  |  |  |  |  | 249,0 |
|  |  | 28,0 |  |  |  |  |  | 268,0 |
| 400 | 426 | 30,0 | 600 | 346 | 1200 | 1200 | 813 | 286,0 |
|  |  | 32,0 |  |  |  |  |  | 309,0 |
|  |  | 34,0 |  |  |  |  |  | 324,0 |
|  |  | 9,0 |  |  |  |  |  | 138,0 |
|  |  | 10,0 |  |  |  |  |  | 153,0 |
|  |  | 11,0 |  |  |  |  |  | 168,0 |
|  |  | 12,0 |  |  |  |  |  | 183,0 |
|  |  | 13,0 |  |  |  |  |  | 198,0 |
|  |  | 14,0 |  |  |  |  |  | 212,0 |
|  |  | 15,0 |  |  |  |  |  | 227,0 |
|  |  | 16,0 |  |  |  |  |  | 242,0 |
|  |  | 17,0 |  |  |  |  |  | 256,0 |
| 500 | 530 | 18,0 | 750 | 433 | 1500 | 1500 | 1015 | 270,0 |
|  |  | 20,0 |  |  |  |  |  | 298,0 |
|  |  | 22,0 |  |  |  |  |  | 327,0 |
|  |  | 24,0 |  |  |  |  |  | 356,0 |
|  |  | 26,0 |  |  |  |  |  | 385,0 |
|  |  | 28,0 |  |  |  |  |  | 413,0 |
|  |  | 30,0 |  |  |  |  |  | 440,0 |
|  |  | 32,0 |  |  |  |  |  | 467,0 |
|  |  | 34,0 |  |  |  |  |  | 494,0 |
|  |  | 36,0 |  |  |  |  |  | 520,0 |
|  |  | 9,0 |  |  |  |  |  | 198,0 |
|  |  | 10,0 |  |  |  |  |  | 219,0 |
|  |  | 11,0 |  |  |  |  |  | 245,0 |
|  |  | 12,0 |  |  |  |  |  | 261,0 |
|  |  | 13,0 |  |  |  |  |  | 282,0 |
|  |  | 14,0 |  |  |  |  |  | 302,0 |
|  |  | 15,0 |  |  |  |  |  | 324,0 |
|  |  | 16,0 |  |  |  |  |  | 345,0 |
| 600 | 630 | 17,0 | 900 | 519 | 1800 | 1800 | 1215 | 366,0 |
|  |  | 18,0 |  |  |  |  |  | 387,0 |
|  |  | 20,0 |  |  |  |  |  | 429,0 |
|  |  | 22,0 |  |  |  |  |  | 471,0 |
|  |  | 24,0 |  |  |  |  |  | 513,0 |
|  |  | 26,0 |  |  |  |  |  | 554,0 |
|  |  | 28,0 |  |  |  |  |  | 595,0 |
|  |  | 30,0 |  |  |  |  |  | 636,0 |
|  |  | 32,0 |  |  |  |  |  | 678,0 |
|  |  | 9,0 |  |  |  |  |  | 248,0 |
|  |  | 10,0 |  |  |  |  |  | 275,0 |
|  |  | 11,0 |  |  |  |  |  | 302,0 |
|  |  | 12,0 |  |  |  |  |  | 329,0 |
|  |  | 13,0 |  |  |  |  |  | 356,0 |
| 700 | 720 | 14,0 | 1000 | 577 | 2000 | 2000 | 1360 | 383,0 |
|  |  | 15,0 |  |  |  |  |  | 410,0 |
|  |  | 16,0 |  |  |  |  |  | 436,0 |
|  |  | 17,0 |  |  |  |  |  | 462,0 |
|  |  | 18,0 |  |  |  |  |  | 489,0 |
|  |  | 20,0 |  |  |  |  |  | 452,0 |
|  |  | 22,0 |  |  |  |  |  | 595,0 |

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| DN | D | T | F = R | W | H | C | B | Масса отвода с 0 = 90°, кг |
|  |  | 24,0 |  |  |  |  |  | 647,0 |
|  |  | 26,0 |  |  |  |  |  | 698,0 |
| 700 | 720 | 28,0 | 1000 | 577 | 404 | 2000 | 1360 | 750,0 |
|  |  | 30,0 |  |  |  |  |  | 801,0 |
|  |  | 32,0 |  |  |  |  |  | 852,0 |
|  |  | 9,0 |  |  |  |  |  | 339,0 |
|  |  | 10,0 |  |  |  |  |  | 376,0 |
|  |  | 11,0 |  |  |  |  |  | 413,0 |
|  |  | 12,0 |  |  |  |  |  | 450,0 |
|  |  | 13,0 |  |  |  |  |  | 487,0 |
|  |  | 14,0 |  |  |  |  |  | 524,0 |
|  |  | 15,0 |  |  |  |  |  | 561,0 |
|  |  | 16,0 |  |  |  |  |  | 598,0 |
| 800 | 820 | 17,0 | 1200 | 693 | 485 | 2400 | 1610 | 636,0 |
|  |  | 18.0 |  |  |  |  |  | 670.0 |
|  |  | 20,0 |  |  |  |  |  | 743,0 |
|  |  | 22,0 |  |  |  |  |  | 815,0 |
|  |  | 24,0 |  |  |  |  |  | 887,0 |
|  |  | 26,0 |  |  |  |  |  | 959,0 |
|  |  | 28.0 |  |  |  |  |  | 1030,0 |
|  |  | 30.0 |  |  |  |  |  | 1101,0 |
|  |  | 32,0 |  |  |  |  |  | 1171,0 |
| Примечания | |  | | | | | |  |
| 1 Масса приведена для справок. | | | | | | | |  |
| 2 Масса отводов с 0 = 60° и 0 = 45 | | | ° соответственно в 1 ,5 и 2 раза меньше, а отводов с 0 - 1 80° в 2 раза больше указанной. | | | | | |

При **меры условных обозначений:**

* отвода с 0 = 90°, исполнения 1, D = 139,7 мм, Т~ 4,0 мм из стали марки ТS4:

Отвод 90-1-139,7 • 4-Т54 ГОСТ 17375-2001

* отвода с 0= 45°, исполнения 2, D = 159 мм, Т = 4,0 мм, Тв = 6,0 мм из стали марки 20:

Отвод 45-159 - 4/6ГОСТ 17375-2001

* отвода с 0 = 90°, исполнения 2, D = 57 мм, Т= 5,0 мм из стали марки 09Г2С:

Отвод 90-57 5-09Г2СГОСТ 17375-2001

* то же, для трубопроводов, подконтрольных органам надзора:

Отвод П90-5 7 -5-09Г2С ГОСТ 173 75-2001

1. По согласованию между изготовителем и потребителем (заказчиком) допускается изготовление отводов исполнения 2 с другими размерами и углами 0.
2. Допускается изготовление отводов исполнения 2 с увеличенной толщиной стенки в неторцевых сечениях **Тв.**

5 Технические условия

Технические условия—по ГОСТ 17380.

УДК 621.643.4:006.354 МКС 23.040.40 Г18 ОКП 14 6800