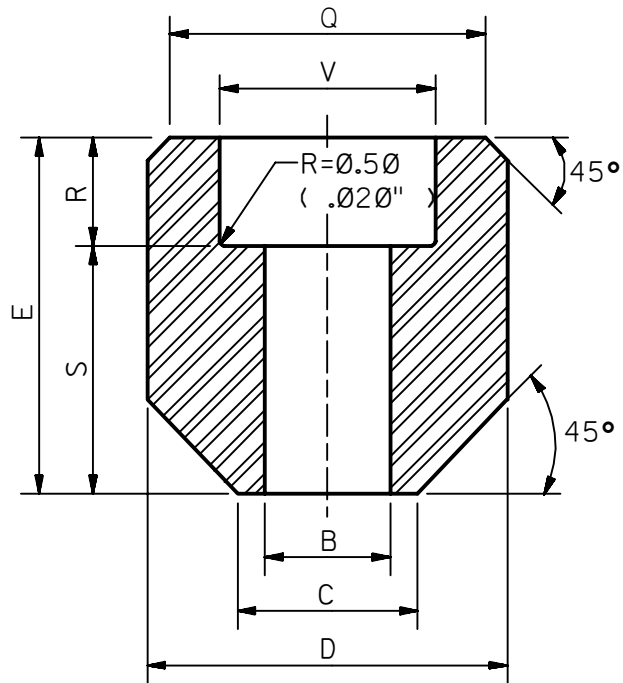


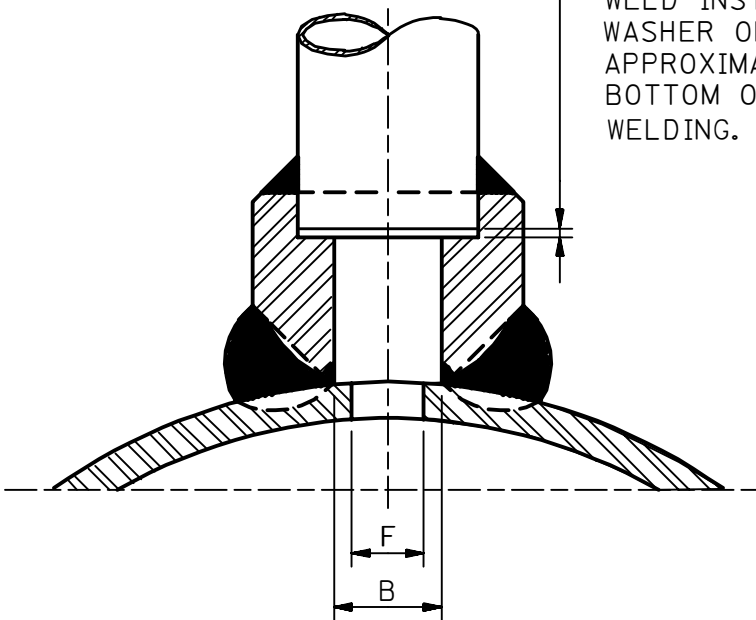
04	001	AD-036643	L	066
REV. NO.	SHEET NO.	DRAWING NUMBER	INDEX	PLANT NO.



TOLERANCES		
NOM. SIZE	OUT OF ROUND (mm) (inch)	
1/4 " , 1/2 "	0.038	0.023
1 1/2 " & 2"	0.89	0.035

THE SOCKET AND FITTING BORES ARE TO BE CONCENTRIC WITHIN 0.76 (0.030") FOR ALL SIZES.

EACH WELDING BOSS SHALL BE IDENTIFIED BY STAMPING PER ANSI B 16.11.



FOR INSTRUMENT FLOW AND PRESSURE CONNECTIONS:

1. WELD 3/4 " BOSS TO PIPE OR VESSEL.
2. DRILL F=13 (1/2 ") WITH JIG OR PILOT DRILL.
3. DEBURR INSIDE EDGE WITH HOOK SCRAPER.

FOR OTHER CONNECTIONS:

1. WELD BOSS TO PIPE OR VESSEL.
2. DRILL SIZE F=B-0.80 (1/32")

DIMENSIONS

NOM. SIZE	CLASS 3000				CLASS 6000				R (REF.)		S		E		C (DIA.)		D (DIA.)		V (DIA.)	
	Q (DIA.)		B (DIA.)		Q (DIA.)		B (DIA.)		R (REF.)		S		E		C (DIA.)		D (DIA.)		V (DIA.)	
	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)
1/4	21 +0.80 -0	53/64 + 1/32 - 0	9 +0.80 -0	11/32 + 1/32 - 0	23 +0.80 -0	57/64 + 1/32 - 0	6 +0.80 -0	15/64 + 1/32 - 0	10	3/8	32 ±1.6	1-1/4 ±1/16	42 ±1.6	1-5/8 ±1/16	15 ±0.4	37/64 ±1/64	32 ±0.4	1-1/4 ±1/64	14.1 14.3	.555 .565
1/2	30 +0.80 -0	1-3/16 + 1/32 - 0	15 +0.80 -0	39/64 + 1/32 - 0	33 +0.80 -0	1-9/32 + 1/32 - 0	12 +0.80 -0	29/64 + 1/32 - 0	12	1/2	38 ±1.6	1-1/2 ±1/16	50 ±1.6	2 ±1/16	21 ±0.4	27/32 ±1/64	38 ±0.4	1-1/2 ±1/64	21.7 22	.855 .865
3/4	36 +0.80 -0	1-27/64 + 1/32 - 0	21 +0.80 -0	13/16 + 1/32 - 0	40 +0.80 -0	1-9/16 + 1/32 - 0	15 +0.80 -0	19/32 + 1/32 - 0	14	9/16	36 ±1.6	1-7/16 ±1/16	50 ±1.6	2 ±1/16	27 ±0.4	1-1/16 ±1/64	44 ±0.4	1-3/4 ±1/64	27 27.3	1.065 1.075
1"	44 +0.80 -0	1-47/64 + 1/32 - 0	26 +0.80 -0	1-1/32 + 1/32 - 0	48 +0.80 -0	1-57/64 + 1/32 - 0	20 +0.80 -0	51/64 + 1/32 - 0	16	5/8	34 ±1.6	1-3/8 ±1/16	50 ±1.6	2 ±1/16	33 ±0.4	1-9/32 ±1/64	51 ±0.4	2 ±1/64	33.8 34	1.330 1.340
1 1/2	60 +0.80 -0	2-3/8 + 1/32 - 0	40 +0.80 -0	1-19/32 + 1/32 - 0	65 +0.80 -0	2-35/64 + 1/32 - 0	34 +0.80 -0	1-21/64 + 1/32 - 0	18	3/4	32 ±1.6	1-1/4 ±1/16	50 ±1.6	2 ±1/16	47 ±0.4	1-27/32 ±1/64	70 ±0.4	2-3/4 ±1/64	48.6 48.9	1.915 1.925
2"	73 +0.80 -0	2-57/64 + 1/32 - 0	52 +0.80 -0	2-3/64 + 1/32 - 0	80 +0.80 -0	3-11/64 + 1/32 - 0	42 +0.80 -0	1-43/64 + 1/32 - 0	22	7/8	28 ±1.6	1-1/8 ±1/16	50 ±1.6	2 ±1/16	59 ±0.4	2-5/16 ±1/64	83 ±0.4	3-1/4 ±1/64	61.1 61.4	2.406 2.416

NOTES:

1. FOR PIPE THREAD CONNECTIONS REFER TO DWG. AE-036175.

REVISION NOTE:-

1. REDRAWN, CONSOLIDATED SH. 1 & 2 INTO SH. 1. CHANGED DWG. SIZE FROM "E" TO "D" AND ADDED TYP. INSTALL. NOTE

DRAWING RESPONSIBILITY:

PIPING STANDARDS COMMITTEE

04	OCT98	EDSD WED		CHANGED DWG. FROM TYPICAL INSTALL'N TO MANDATORY STANDARD DWG.			
03	JUN88	RLO		SEE REVISION NOTE 1.	ORIG. SIGNED	ORIG. SIGNED	ORIG. SIGNED
REV. NO.	DATE	BY	JO/EWO	DESCRIPTION	CHKD.	CERT.	APPD.

SAUDI ARABIAN OIL COMPANY

DRAWN BY S. GHAMIDI CHECKED BY _____ SCALE NONE
DATE STARTED _____ DATE COMPLETED _____
OPRG. DEPT. _____ ENG. DEPT. _____
APPD. FOR CONSTR. _____

THIS DRAWING IS NOT TO BE USED FOR CONSTRUCTION OR FOR ORDERING MATERIAL UNTIL CERTIFIED AND DATED
CERTIFIED BY _____ DATE _____

DETAIL OF HEAVY WELDING BOSS SOCKET WELD CONNECTIONS

STD. DWG.

PLANT NO.	INDEX	DRAWING NUMBER	SHEET NO.	REV. NO.
990	L	AD-036643	001	04