

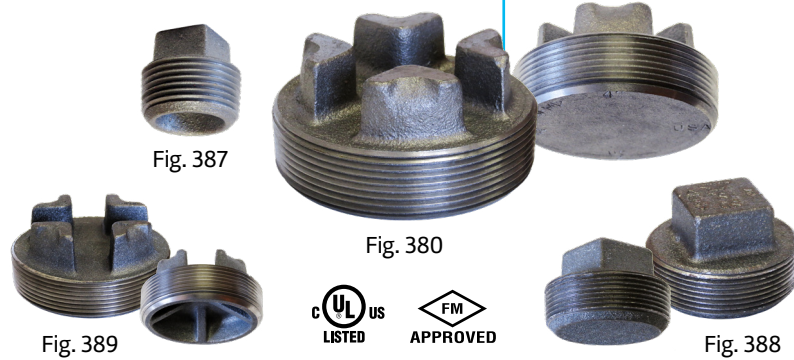
Plugs (Class 125 Standard)

Fig. 380 Square Head Plugs, Solid

Fig. 387 Square head Plugs, Cored

Fig. 388 Bar Plugs, Solid

Fig. 389 Bar Plugs, Cored



Anvil standard and extra heavy cast iron threaded fittings are manufactured in accordance with ASME-B16.4 (except plugs and bushings, ASME B16.14). Dimensions also conform to Federal Specifications, WW-P-501 (except plugs and bushings WW-P-471).

Cast iron threaded fittings are available in both black and galvanized.

For Listings/Approval Details and Limitations, visit our website at www.asc-es.com or contact an ASC Engineered Solutions™ Representative.

See following page for standards and specifications.

Cast Iron Threaded Fittings Pressure - Temperature Ratings

Temperature	Pressure		Temperature	Pressure	
	Class 125	Class 250		Class 125	Class 250
°F/°C	PSI/bar	PSI/bar	°F/°C	PSI/bar	PSI/bar
-20°–150° -28.9°–65.6°	175 12.1	400 27.6	300° 148.9°	140 9.7	310 21.4
200° 93.3°	165 11.4	370 25.5	350° 176.7°	125 8.6	300 20.7
250° 121.1°	150 10.3	340 23.4	400° 204.4°	– –	250 17.2

Note:

Anvil standard and extra heavy cast iron threaded fittings are manufactured in accordance with ASME B16.4. Plugs and bushings are manufactured in accordance with ASME B16.14.

Figure 367 Concentric Reducers do not meet the overall length requirement of ASME B16.4. All other dimensions are in compliance.



PROJECT INFORMATION	APPROVAL STAMP
Project:	Approved
Address:	Approved as noted
Contractor:	Not approved
Engineer:	Remarks:
Submittal Date:	
Notes 1:	
Notes 2:	

Square Head Plugs, Bar Plugs (Class 125 Standard) Fig. 387, 388, 389, 380



Standards and Specifications

Cast Iron Threaded Fittings

	Dimensions	Material	Galvanizing*	Thread	Pressure Rating
Class 125	ASME B16.4	ASTM A126 (A)	ASTM A153	ASME B1.20.1	ASME B16.4
Class 250	ASME B16.4	ASTM A126 (A)	ASTM A153	ASME B1.20.1	ASME B16.4

Cast Iron Plugs and Bushings

	Dimensions	Material	Galvanizing*	Thread	Pressure Rating
	ASME B16.14	ASTM A126 (A)	ASTM A153	ASME B1.20.1	ASME B16.14

Note:

* ASTM B633, Type I, SC 4, may be supplied as alternate zinc coating per applicable ASME B16 product standard.



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Fig. 380
Bar Plugs, Solid
(Class 125 Standard)



Size	Unit Weight		Size	Unit Weight	
	Black			Black	
NPS/DN	Lbs./kg		NPS/DN	Lbs./kg	
4 100	5.68 2.58		6 150	14.78 6.70	
5 125	9.60 4.35				

Fig. 387
Square Head Plugs, Cored
(Class 125 Standard)



Size	Unit Weight		Size	Unit Weight	
	Black	Galvanized		Black	Galvanized
NPS/DN	Lbs./kg	Lbs./kg	NPS/DN	Lbs./kg	Lbs./kg
¾* 20	0.13 0.06	0.13 0.06	2½ 65	1.32 0.60	1.32 0.60
1 25	0.25 0.11	0.25 0.11	3 80	1.87 0.85	1.87 0.85
1¼ 32	0.39 0.18	0.39 0.18	3½ 90	2.50 1.13	2.50 1.13
1½ 40	0.50 0.23	0.50 0.23	4 100	4.00 1.81	4.00 1.81
2 50	0.82 0.37	0.82 0.37			

Note:
*Zinc Plated

Note:

According to specifications, hex bushings and cored plugs should be used with 150# malleable iron and 125# cast iron. Solid plugs and face bushings are recommended for use with 250# and 300# fittings.

See first page for pressure-temperature ratings.



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Fig. 388
Square Head Plugs, Solid
(Class 125 Standard)



Size	Unit Weight		Size	Unit Weight	
	Black	Galvanized		Black	Galvanized
NPS/DN	Lbs./kg	Lbs./kg	NPS/DN	Lbs./kg	Lbs./kg
1/2	0.10	0.10	2	1.23	1.23
15	0.05	0.05	50	0.56	0.56
3/4	0.17	0.17	2 1/2	2.00	2.00
20	0.08	0.08	65	0.91	0.91
1	0.32	0.32	3	3.18	3.18
25	0.15	0.15	80	1.44	1.44
1 1/4	0.53	0.53	3 1/2	4.38	—
32	0.24	0.24	90	1.99	—
1 1/2	0.76	0.76			
40	0.34	0.34			

Fig. 389
Bar Plugs, Cored
(Class 125 Standard)



Size	Unit Weight		Size	Unit Weight	
	Black	Galvanized		Black	Galvanized
NPS/DN	Lbs./kg	Lbs./kg	NPS/DN	Lbs./kg	Lbs./kg
4	3.82	3.82	6	9.94	9.94
100	1.73	1.73	150	4.51	4.51
5	6.50	6.50	8	20.26	20.26
125	2.95	2.95	200	9.19	9.19

Note:

According to specifications, hex bushings and cored plugs should be used with 150# malleable iron and 125# cast iron. Solid plugs and face bushings are recommended for use with 250# and 300# fittings.

See first page for pressure-temperature ratings.



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Fig. 387, 388 Square Head Plugs (Class 125 Standard)
Fig. 389, 380 Bar Plugs (Class 125 Standard)

General Assembly of Threaded Fittings

1 Inspect both male and female components prior to assembly.

- Threads should be free from mechanical damage, dirt, chips and excess cutting oil.
- Clean or replace components as necessary.

2 Application of thread sealant

- Use a thread sealant that is fast drying, sets-up to a semi hard condition and is vibration resistant. Alternately, an anaerobic sealant may be utilized.
- Thoroughly mix the thread sealant prior to application.
- Apply a thick even coat to the male threads only. Best application is achieved with a brush stiff enough to force sealant down to the root of the threads.

3 Joint Makeup

- For sizes up to and including 2" pipe, wrench tight makeup is considered three full turns past handtight. Handtight engagement for ½" through 2" thread varies from 4½ turns to 5 turns.
- For 2½" through 4" sizes, wrench tight makeup is considered two full turns past handtight. Handtight engagement for 2½" through 4" thread varies from 5½ turns to 6¾ turns.



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