Class 125 (Standard)

FIGURE 387 Square Head Plugs, Cored

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

* Zinc Plated

FIGURE 388 Square Head Plugs, Solid

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

FIGURE 389 Bar Plugs, Cored

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

FIGURE 380 Bar Plugs, Solid

Size		Unit Weight	
		Black	
NPS	*DN*	lbs	*kg*
4	*100*	5.68	*2.58*
5	*125*	9.60	*4.35*
6	*150*	14.78	*6.70*

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.

Note: See following page for pressure-temperature ratings.

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

CAST IRON THREADED FITTINGS

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.

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

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FM APPROVED

For Listings/Approval Details and Limitations, visit our website at www.anvilintl.com or contact an Anvil Sales Representative.

Cast Iron Threaded Fittings
Pressure - Temperature Ratings

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

Standards and Specifications

	Dimensions	Material	Galvanizing*	Thread	Pressure Rating
CAST IRON THREADED FITTINGS					
Class 125	ASME B16.4	ASTM A-126 (A)	ASTM A-153	ASME B1.20.1	ASME B16.4
Class 250	ASME B16.4	ASTM A-126 (A)	ASTM A-153	ASME B1.20.1	ASME B16.4
CAST IRON PLUGS AND BUSHINGS					
	ASME B16.14	ASTM A- 126 (A)	ASTM A-153	ASME B1.20.1	ASME B16.14

* ASTM B 633. Type I, SC 4, may be supplied as alternate zinc coating per applicable ASME B16 product 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 1/2" through 2" thread varies from 4 1/2 turns to 5 turns.
   - For 2 1/2" through 4" sizes, wrench tight makeup is considered two full turns past handtight. Handtight engagement for 2 1/2" through 4" thread varies from 5 1/2 turns to 6 3/4 turns.