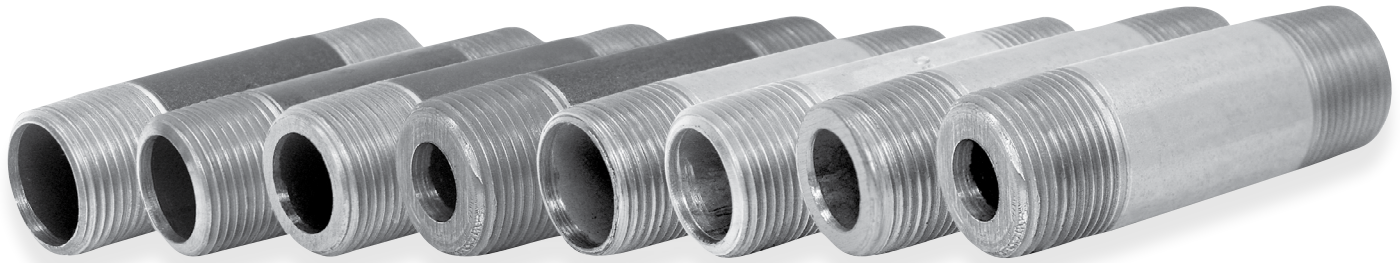


## Seamless Pipe Nipples – Black & Galvanized Standard Schedule 40, XH Schedule 80, Schedule 160, XXH



**Fig. 320:**  
Standard  
Black Sch. 40

**Fig. 325:**  
Extra Heavy  
Black Sch. 80

**Fig. 326:**  
160 Black  
Sch. 160

**Fig. 327:**  
XXH Black

**Fig. 330:**  
Standard Galv.  
Sch. 40

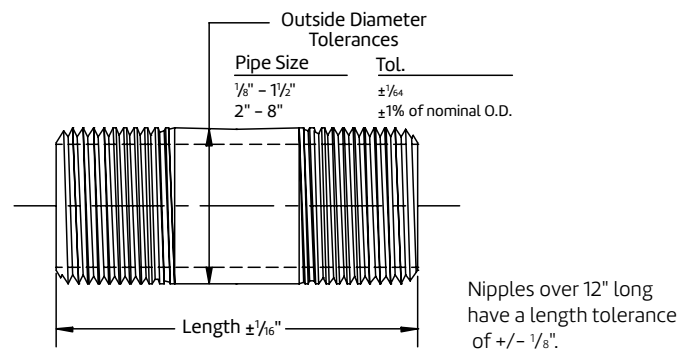
**Fig. 335:**  
Extra Heavy  
Galv. Sch. 80

**Fig. 333:**  
160 Galv.  
Sch. 160

**Fig. 329:**  
XXH  
Galvanized

### Specifications

- Dimensions:** ASTM A733 (See table below for standard sizes)  
**Threads:** NPT per ASME B1.20.1  
**Material:** ASTM A106 Grade B Seamless Pipe  
 ASTM A333 Grade 6 Seamless Pipe (For Canada only)  
**Finish:** ASTM A106 Nipples Black or Hot Dip Galvanized  
 ASTM A333 Nipples Phosphate Coated or Zinc Electroplated



Pipe Size	Pipe O.D.	Length Close	Pipe Nipple Lengths															
in	in	in																
1⁄8	0.405	¾	1½	2	2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
1⁄4	0.540	⅞	1½	2	2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
⅜	0.675	1	1½	2	2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
½	0.840	1⅛	1½	2	2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
¾	1.050	1⅜	1½	2	2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
1	1.315	1½		2	2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
1¼	1.660	1⅝		2	2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
1½	1.900	1¾		2	2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
2	2.375	2			2½	3	3½	4	4½	5	5½	6	7	8	9	10	11	12
2½	2.875	2½				3	3½	4	4½	5	5½	6	7	8	9	10	11	12
3	3.500	2⅝				3	3½	4	4½	5	5½	6	7	8	9	10	11	12
4	4.500	2⅞						4	4½	5	5½	6	7	8	9	10	11	12
5	5.563	3							4½	5	5½	6	7	8	9	10	11	12
6	6.625	3⅛							4½	5	5½	6	7	8	9	10	11	12

**Note:** Other lengths available upon request. 8" Pipe Size available as POA – contact your ASC Engineered Solutions™ Representative for details.

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



## Specifications

**Unless otherwise specified** welded nipples ASTM A 53 are furnished on orders for steel nipples in standard and extra strong sizes  $\frac{1}{8}$ " – 8" NPS (6 – 200 DN).

**Welded steel nipples (A 53 Type F or Type E)** are available in standard and extra strong sizes  $\frac{1}{8}$ " – 8" NPS (6 – 200 DN), right hand threads, black or galvanized.

**Seamless nipples** manufactured for the U.S. and International markets are **not** phosphate coated. Seamless nipples manufactured for Canada **are** phosphate coated.

**Seamless steel pressure tube nipples (ASTM A 106 Grade B)** are available in standard and extra strong sizes  $\frac{1}{8}$ " – 8" NPS (6 – 200 DN) with right hand threads, black only.

**Right and left steel nipples** are available in standard and extra heavy weight sizes  $\frac{1}{8}$ " – 4" NPS (8 – 50 DN), in 4" (102mm) and 6" (152mm) lengths.

**Nipples** are available from stock in  $\frac{1}{8}$ " – 8" NPS (6 – 200 DN) diameter, close to 12 NPS (300 DN) in length. Sizes 13" – 24" NPS (325 – 600 DN). (Prices on application.)

Steel pipe nipples meet ASTM A733.

$\frac{1}{8}$ " Schedule 40 and 80 galvanized nipples are all electroplated.

## Identification

Where possible, each seamless pipe nipple is identified with the following:

- A trade mark
- Seamless designation "SMLS"
- Pipe schedule 40, 80, 160, XXS
- Material designation
- Heat number for traceability

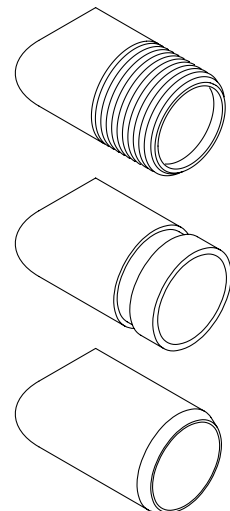
## Standards and Specifications

	Dimensions	Material	Thread	Federal/Other
<b>Pipe Nipples</b>				
Steel Pipe - Welded	ASTM A733	ASTM A53 Type F or Type E	ASME B1.20.1	WWN 351
Steel Pipe - Seamless (High Temp.)	ASTM A733	ASTM A106 Gr. B	ASME B1.20.1	WWN 351
Brass	ASTM B687	ASTM B43	ASME B1.20.1	WWN 351

## Special Design Pipe Nipples

Beck Pipe Nipples are available with a variety of options for customization. To order, begin by selecting the figure number, material, finish, and end treatments from the table below. Then, select the nominal pipe size and specify the length rounded to the nearest 1/16". Contact your ASC Engineered Solutions™ Representative for additional options.

Fig. No.	Description	Material	Finish	End #1	End #2	NPS	Length
320SD	Sch. 40 Seamless Nipple Special Design	A ASTM A106 GR B	A Plain with Zinc Phosphate Coating	A NPT	A NPT	1/8	Up to 24" Maximum Specify to the nearest 1/16"
		B ASTM A333	B Plain with Sandblasted Surface	B PLN	B PLN	1/4	
330SD	Sch. 40 Seamless Nipple - Galvanized Special Design	A ASTM A106 GR B	A Hot Dip Galvanized per ASTM A153	C PSQ	C PSQ	3/8	
		B ASTM A333	B Zinc Electroplated per ASTM B633	D PDB	D PDB	1/2	
		- -	C Zinc Electroplated with Yellow Chromate	E ROE	E ROE	3/4	
325SD	XH/Sch. 80 Seamless Nipple Special Design	A ASTM A106 GR B	A Plain with Zinc Phosphate Coating	F BEV	F BEV	1	
		B ASTM A333	B Plain with Sandblasted Surface	G NPL	G NPL	1 1/4	
335SD	XH/Sch. 80 Seamless Nipple - Galvanized Special Design	A ASTM A106 GR B	A Hot Dip Galvanized per ASTM A153	H NPM	H NPM	1 1/2	
		B ASTM A333	B Zinc Electroplated per ASTM B633	I ISO	I ISO	2	
		- -	C Zinc Electroplated with Yellow Chromate	J GRV	J GRV	2 1/2	
326SD	Sch. 160 Seamless Nipple Special Design	A ASTM A106 GR B	A Plain with Zinc Phosphate Coating	K LHT	K LHT	3	
		B ASTM A333	B Plain with Sandblasted Surface			4	
333SD	Sch. 160 Seamless Nipple - Galvanized Special Design	A ASTM A106 GR B	A Hot Dip Galvanized per ASTM A153	NPT		5	
		B ASTM A333	B Zinc Electroplated per ASTM B633			6	
		- -	C Zinc Electroplated with Yellow Chromate				
327SD	XXH Seamless Nipple Special Design	A ASTM A106 GR B	A Plain with Zinc Phosphate Coating	PSQ			End Codes
		B ASTM A333	B Plain with Sandblasted Surface				
329SD	XXH Seamless Nipple - Galvanized Special Design	A ASTM A106 GR B	A Hot Dip Galvanized per ASTM A153	PDB			
		B ASTM A333	B Zinc Electroplated per ASTM B633				
		- -	C Zinc Electroplated with Yellow Chromate				
339SD	Sch. 40 Welded Nipple Special Design	A ASTM A53, Type F, CW	A Plain with Zinc Phosphate Coating	BEV			
		B ASTM A53, Type E, EW	B Plain with Sandblasted Surface				
343SD	Sch. 40 Welded Nipple - Galvanized Special Design	A ASTM A53, Type F, CW	A Hot Dip Galvanized per ASTM A153	NPL			
		B ASTM A53, Type E, EW	B Zinc Electroplated per ASTM B633				
		- -	C Zinc Electroplated with Yellow Chromate				
338SD	XH/Sch. 80 Welded Nipple Special Design	A ASTM A53, Type F, CW	A Plain with Zinc Phosphate Coating	ISO			
		B ASTM A53, Type E, EW	B Plain with Sandblasted Surface				
342SD	XH/Sch. 80 Welded Nipple - Galvanized Special Design	A ASTM A53, Type F, CW	A Hot Dip Galvanized per ASTM A153	GRV			
		B ASTM A53, Type E, EW	B Zinc Electroplated per ASTM B633				
		- -	C Zinc Electroplated with Yellow Chromate				
341SD	Tank Nipple - Sch. 40 Welded Special Design	A ASTM A53, Type E, EW	A Plain with Zinc Phosphate Coating	LHT			
			B Plain with Sandblasted Surface				
			C Zinc Electroplated per ASTM B633				
			D Zinc Electroplated with Yellow Chromate				
344SD	**Butt Nipple - Sch. 40 Welded Special Design	A ASTM A53, Type F, CW	A Plain with Zinc Phosphate Coating				
			B Plain with Sandblasted Surface				
			C Zinc Electroplated per ASTM B633				
			D Zinc Electroplated with Yellow Chromate				
345SD	Mining Nipple - Sch. 40 Welded Special Design	A ASTM A53, Type E, EW	A Plain with Zinc Phosphate Coating				
			B Plain with Sandblasted Surface				
			C Zinc Electroplated per ASTM B633				
			D Zinc Electroplated with Yellow Chromate				
362SD	Special Design Seamless Nipple Brass & Chromium Plated Brass	A ASTM B43 Brass	A Plain				
			B Chrome Plated				
363SD	Special Design Grooved Adapter Nipple - Aluminum & Brass	A ASTM B43 Brass	A Plain				
			B Chrome Plated				

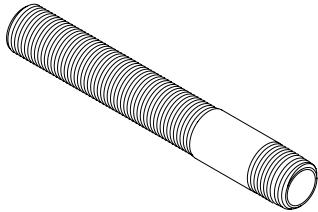


\*\* NPS and lengths available POA, upon request. Contact your ASC Engineered Solutions™ Representative for details.

## Special Design Pipe Nipples

### Tank Nipples

Fig. 341SD – Black & Galvanized

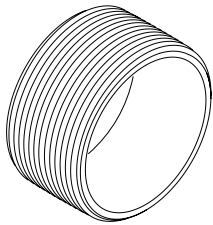


Description	Size	Length	Weight
Tank Nipples are recommended for use as tank legs, not intended for pressure service. Tank Nipples have standard NPT threads on one end and straight NPSM threads running for 4" on the other end. Tank Nipples are fabricated from ASTM A53 Schedule 40 welded pipe.	1/8	6	0.13
	1/4	6	0.20
	3/8	6	0.28
	1/2	6	0.40
	3/4	6	0.53
	1	6	0.76
	1 1/4	6	1.04
	1 1/2	6	1.28
	2	6	1.56

All Tank Nipples ship in quantities of 25. Not intended for pressure service.

### Butt Nipples

Fig. 344SD – Black & Galvanized



**Description**  
Butt Nipples are intended for joining couplings or female threaded components end to end without exposing male threads. Butt Nipples have standard NPT male threads on both ends. Threads may have fewer imperfect threads due to reduced nipple length. Butt Nipples are fabricated from ASTM A53 Schedule 40 welded pipe.

Size	Length	Weight	Quantity
2	1 1/4	0.28	25
2 1/2	2	0.87	10
3	2	1.28	10
4	2 1/4	1.11	5

### Right & Left Nipples

Black — Figure 339SD & Galvanized — Figure 343SD

Nom. Pipe Size	Length	Weight	Quantity
1/8	4" or 6"	0.09	-
1/4	4" or 6"	0.13	-
3/8	4" or 6"	0.18	25
1/2	4" or 6"	0.25	25
3/4	4" or 6"	0.35	25
1	4" or 6"	0.51	25
1 1/4	4" or 6"	0.68	25
1 1/2	4" or 6"	0.80	25
2	4" or 6"	1.09	25
2 1/2	4" or 6"	1.50	-
3	4" or 6"	2.00	-
3 1/2	4" or 6"	2.80	-
4	4" or 6"	3.24	-

## 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.