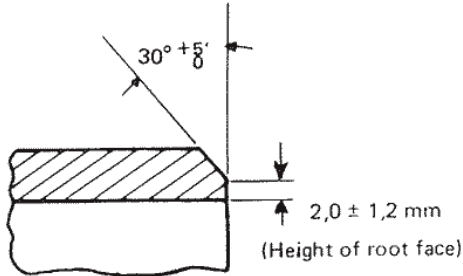


## JIS FITTINGS

### Japanese Industrial Standard JIS B2304 – 72



This standard specifies steel butt-welding pipe fittings which are generally used for ordinary piping in JIS G3452, for steam, water, oil, gas, etc., at relatively low pressures.

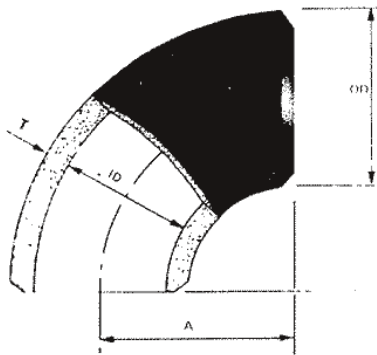
**MATERIALS:** The fittings to this standard are made from materials in accordance with JIS G3452.

**PRESSURE RATINGS:** The fittings are free from leakage at hydrostatic pressure up to a maximum of 2,5 MPa.

**WELDING END PREPARATIONS:** Bevel dimensions and tolerances conform to those shown in the diagram. Fittings with a basic thickness below 4 mm have plain unbevelled ends.

### 90° Elbows Long radius to JIS B2304 – 72

SGP — All sizes are welded.



Nominal pipe size mm	Outside Diameter OD mm	SGP		A	Mass (kg) (approx.) 90EL SGP
		Inside Diameter ID	Wall Thickness T		
15	21,7	16,1	2,8	38,1	0,078
20	27,2	21,6	2,8	38,1	0,100
25	34,0	27,6	3,2	38,1	0,146
32	42,7	35,7	3,5	47,6	0,252
40	48,6	41,6	3,5	57,2	0,350
50	60,5	52,9	3,8	76,2	0,634
65	76,3	67,9	4,2	95,3	1,12
80	89,1	80,7	4,2	114,3	1,58
90	101,6	93,2	4,2	133,4	2,11
100	114,3	105,3	4,5	152,4	2,91
125	139,8	130,8	4,5	190,5	4,49
150	165,2	155,2	5,0	228,6	7,09
200	216,3	204,7	5,8	304,8	14,4
250	267,4	—	—	381,0	—
250	267,4	254,2	6,6	381,0	25,4
300	318,5	—	—	457,2	—
300	318,5	304,7	6,9	457,2	38,1
350	355,6	—	—	533,4	—
350	355,6	339,8	7,9	533,4	56,7
400	406,4	—	—	609,6	—
400	406,4	390,6	7,9	609,6	74,3
450	457,2	—	—	685,8	—
450	457,2	441,4	7,9	685,8	94,2
500	508,0	—	—	762,0	—
500	508,0	492,2	7,9	762,0	117
600	609,6	—	—	914,4	—