

BONNEY FORGE – WFI

**RECOMMENDED FLEXOLET, PIPET, AND WELDOLET
WELD PROFILES**

PF 03-5

**INDEX/NOTES OF RECOMMENDED FLEXOLET, PIPET, AND
WELDOLET WELD PROFILES
(PF 03-5)**

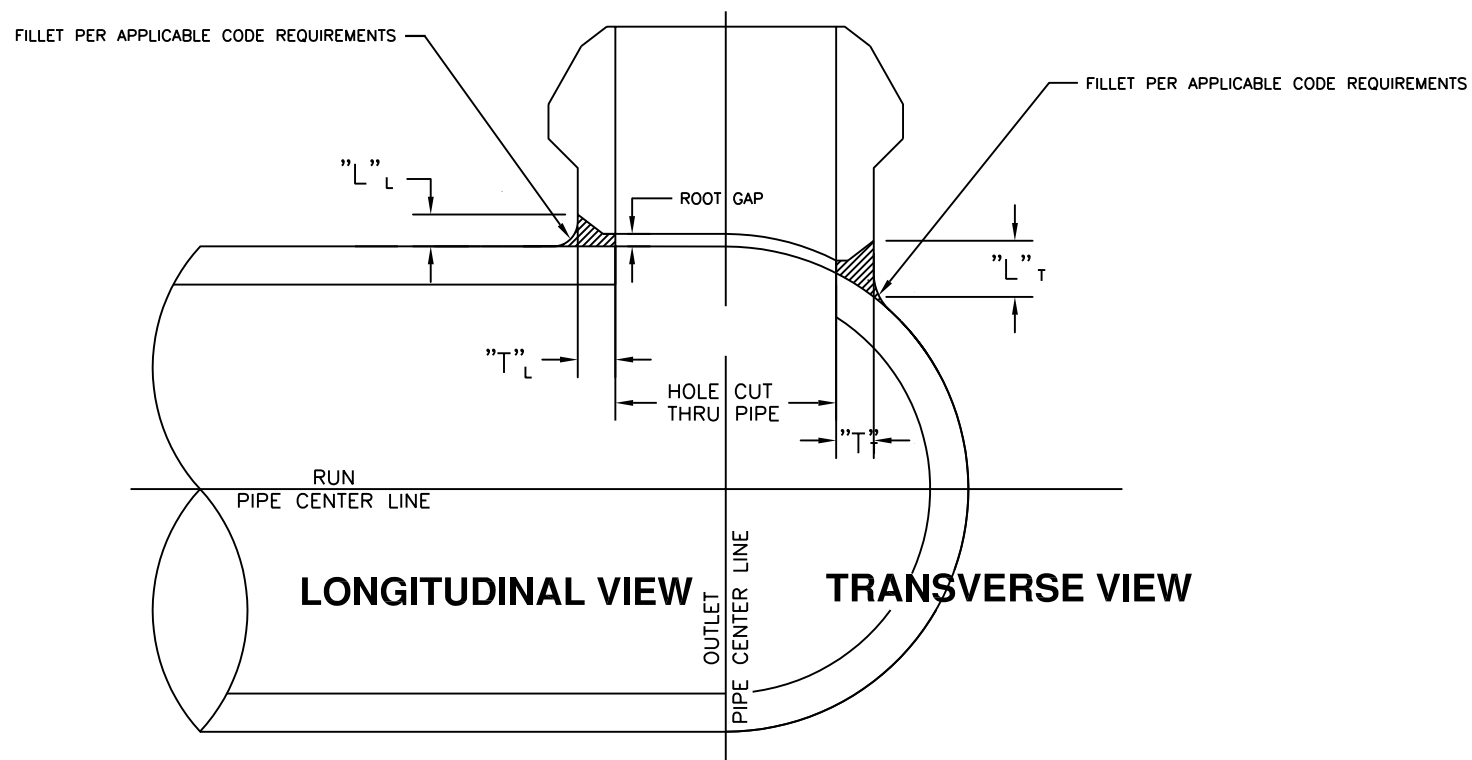
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NOTES:

1. The recommended Root Gap dimension shown is included as part of the weld profile.
2. The enclosed charts are intended to be used as a reference guide only.
3. Reference to Carbon Steel implies the specific material grades of SA/A 105 and SA/A 350 LF2 CL.1.

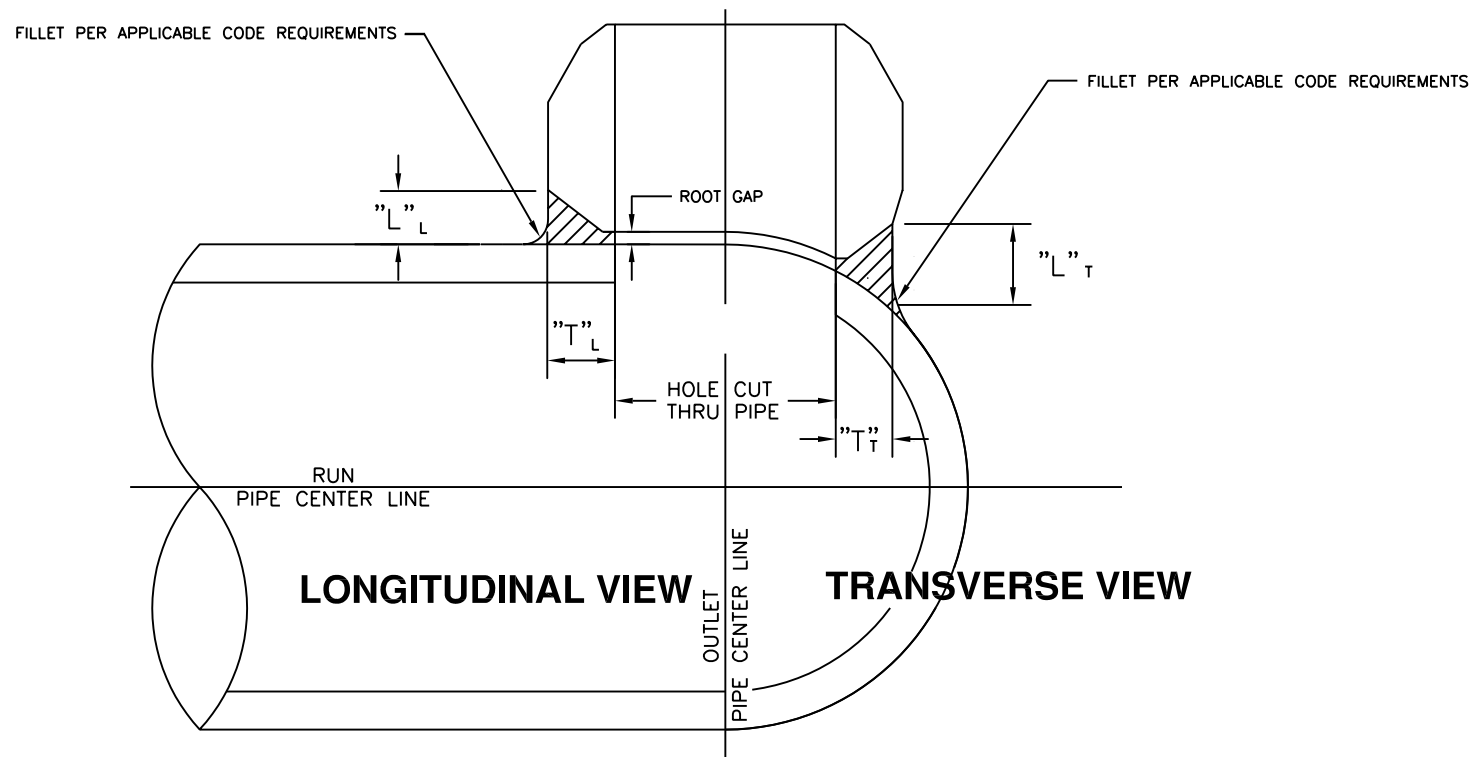
TYPICAL CL.300/S10 WELD SECTION PROFILE OF THE BONNEY FORGE FLEXOLET & WFI PIPET



OUTLET SIZE	SCHEDULE	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/4"	S10	0.121"	0.139"	0.121"	0.139"	.062
3/8"	S10	0.064"	0.065"	0.064"	0.065"	.062
1/2"	S10	0.141"	0.165"	0.141"	0.165"	.062
3/4"	S10	0.161"	0.192"	0.161"	0.192"	.062
1"	S10	0.182"	0.219"	0.182"	0.219"	.062
1 1/4"	S10	0.182"	0.219"	0.182"	0.219"	.062
1 1/2"	S10	0.175"	0.209"	0.175"	0.209"	.062
2"	S10	0.245"	0.301"	0.245"	0.301"	.062
2 1/2"	S10	0.191"	0.188"	0.191"	0.188"	.094
3"	S10	0.238"	0.250"	0.238"	0.250"	.094
3 1/2"	S10	0.238"	0.250"	0.238"	0.250"	.094
4"	S10	0.269"	0.250"	0.269"	0.250"	.125
5"	S10	0.252"	0.228"	0.252"	0.228"	.125
6"	S10	0.269"	0.250"	0.269"	0.250"	.125

OUTLET SIZE	CLASS & OUTLET	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/2"	300 - SW	0.140"	0.164"	0.140"	0.164"	.062
3/4"	300 - SW	0.161"	0.191"	0.161"	0.191"	.062
1"	300 - SW	0.182"	0.218"	0.182"	0.218"	.062
1 1/4"	300 - SW	0.182"	0.218"	0.182"	0.218"	.062
1 1/2"	300 - SW	0.202"	0.245"	0.202"	0.245"	.062
2"	300 - SW	0.245"	0.301"	0.245"	0.301"	.062
1/2"	300 - THD	0.140"	0.164"	0.140"	0.164"	.062
3/4"	300 - THD	0.161"	0.191"	0.161"	0.191"	.062
1"	300 - THD	0.182"	0.218"	0.182"	0.218"	.062
1 1/4"	300 - THD	0.182"	0.218"	0.182"	0.218"	.062
1 1/2"	300 - THD	0.202"	0.245"	0.202"	0.245"	.062
2"	300 - THD	0.245"	0.301"	0.245"	0.301"	.062

**TYPICAL STAINLESS, CHROME, AND ALLOY WELD SECTION PROFILE
OF THE BONNEY FORGE FLEXOLET & WFI PIPET**

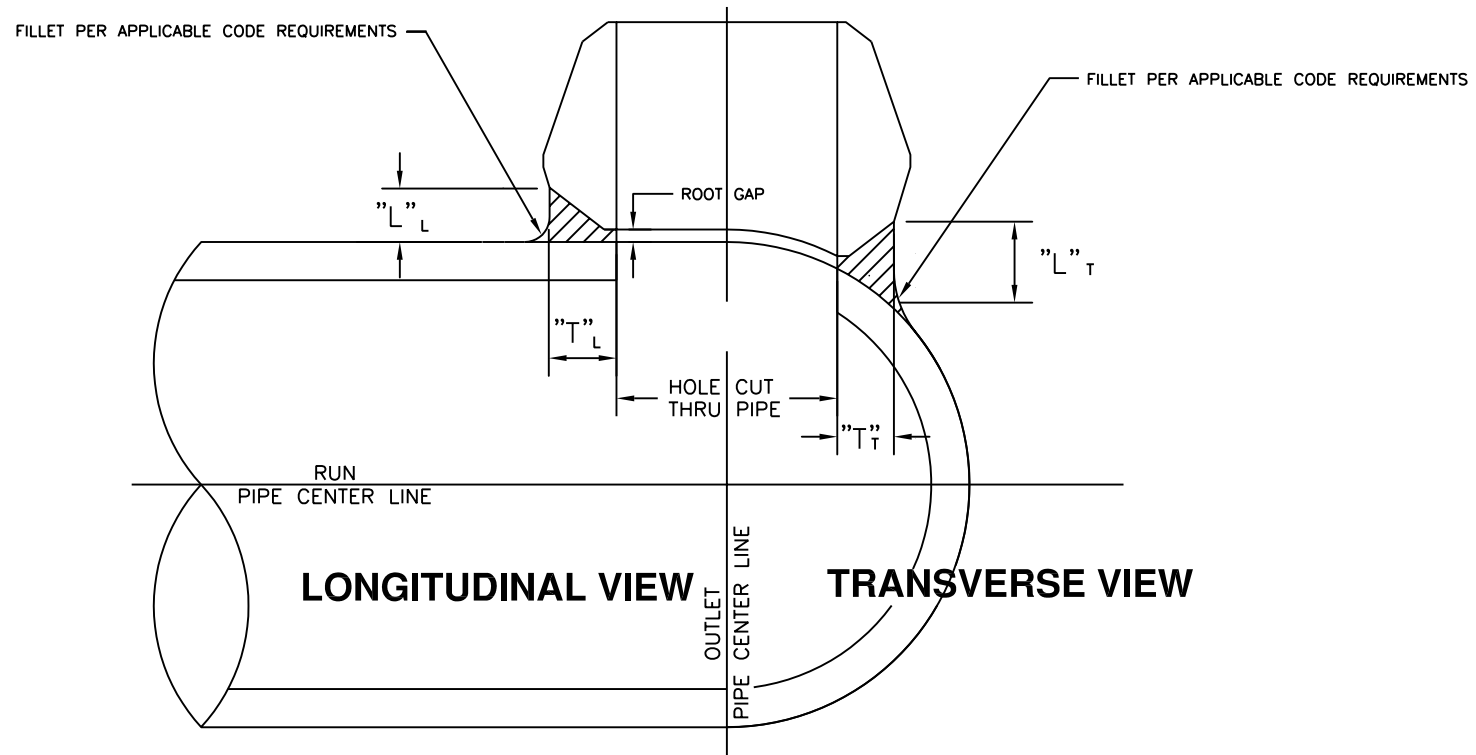


OUTLET SIZE	SCHEDULE	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
3/8"	STD	0.209"	0.254"	0.209"	0.222"	.062
1/2"	STD	0.207"	0.252"	0.207"	0.188"	.062
3/4"	STD	0.274"	0.338"	0.274"	0.275"	.062
1"	STD	0.283"	0.351"	0.283"	0.224"	.062
1 1/4"	STD	0.348"	0.435"	0.348"	0.246"	.062
1 1/2"	STD	0.356"	0.445"	0.356"	0.224"	.062
2"	STD	0.372"	0.467"	0.372"	0.217"	.062
2 1/2"	STD	0.490"	0.578"	0.490"	0.218"	.094
3"	STD	0.404"	0.466"	0.404"	0.275"	.094
4"	STD	0.547"	0.612"	0.547"	0.326"	.125
6"	STD	0.628"	0.718"	0.628"	0.357"	.125
3/8"	XS	0.236"	0.289"	0.236"	0.257"	.062
1/2"	XS	0.237"	0.290"	0.237"	0.258"	.062
3/4"	XS	0.305"	0.379"	0.305"	0.316"	.062
1"	XS	0.319"	0.397"	0.319"	0.302"	.062
1 1/4"	XS	0.387"	0.486"	0.387"	0.360"	.062
1 1/2"	XS	0.398"	0.500"	0.398"	0.311"	.062
2"	XS	0.422"	0.531"	0.422"	0.297"	.062
2 1/2"	XS	0.498"	0.589"	0.498"	0.331"	.094
3"	XS	0.468"	0.550"	0.468"	0.379"	.094
4"	XS	0.528"	0.587"	0.528"	0.420"	.125
6"	XS	0.745"	0.870"	0.745"	0.441"	.125

OUTLET SIZE	CLASS	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/4"	3M	0.211"	0.236"	0.211"	0.149"	.062
3/8"	3M	0.178"	0.213"	0.178"	0.213"	.062
1/2"	3M	0.209"	0.254"	0.209"	0.251"	.062
3/4"	3M	0.235"	0.287"	0.235"	0.275"	.062
1"	3M	0.290"	0.360"	0.290"	0.287"	.062
1 1/4"	3M	0.290"	0.359"	0.290"	0.246"	.062
1 1/2"	3M	0.300"	0.372"	0.300"	0.256"	.062
2"	3M	0.323"	0.402"	0.323"	0.196"	.062
1/2"	6M	0.311"	0.387"	0.311"	0.387"	.062
3/4"	6M	0.408"	0.513"	0.408"	0.346"	.062
1"	6M	0.409"	0.514"	0.409"	0.514"	.062
1 1/4"	6M	0.491"	0.621"	0.491"	0.544"	.062
1 1/2"	6M	0.505"	0.640"	0.505"	0.580"	.062
2"	6M	0.604"	0.768"	0.604"	0.655"	.062

OUTLET SIZE	CLASS	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/4"	3M	0.132"	0.154"	0.132"	0.154"	.062
3/8"	3M	0.148"	0.174"	0.148"	0.116"	.062
1/2"	3M	0.166"	0.194"	0.166"	0.197"	.062
3/4"	3M	0.191"	0.231"	0.191"	0.210"	.062
1"	3M	0.241"	0.296"	0.241"	0.252"	.062
1 1/4"	3M	0.258"	0.318"	0.258"	0.248"	.062
1 1/2"	3M	0.266"	0.328"	0.266"	0.248"	.062
2"	3M	0.283"	0.350"	0.283"	0.288"	.062
1/4"	6M	0.223"	0.272"	0.223"	0.250"	.062
3/8"	6M	0.278"	0.344"	0.278"	0.250"	.062
1/2"	6M	0.275"	0.340"	0.275"	0.288"	.062
3/4"	6M	0.300"	0.372"	0.300"	0.280"	.062
1"	6M	0.393"	0.493"	0.393"	0.397"	.062
1 1/4"	6M	0.367"	0.460"	0.367"	0.287"	.062
1 1/2"	6M	0.460"	0.581"	0.460"	0.357"	.062
2"	6M	0.519"	0.657"	0.519"	0.394"	.062

TYPICAL CARBON STEEL WELD SECTION PROFILE OF THE BONNEY FORGE FLEXOLET & WFI PIPET

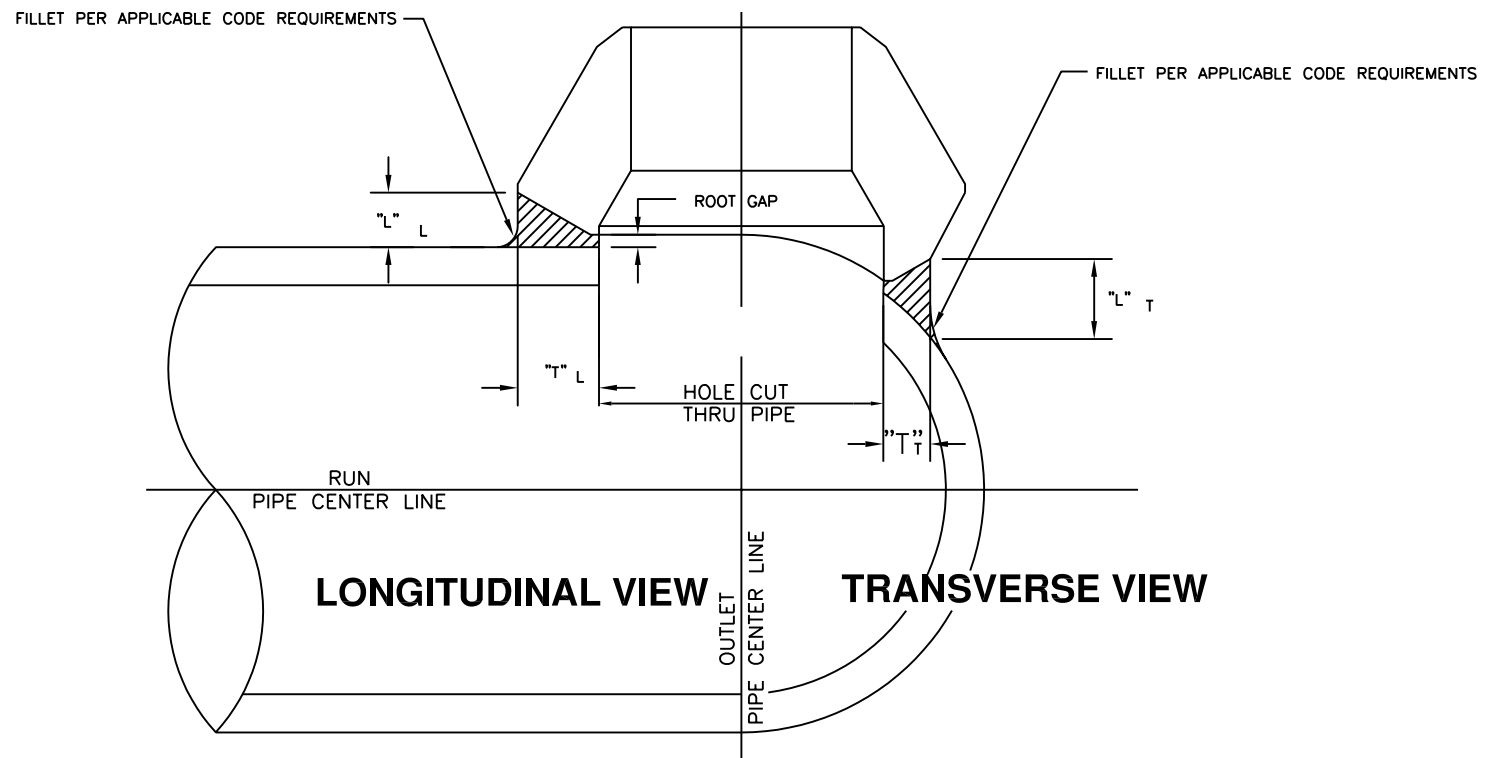


OUTLET SIZE	SCHEDULE	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
3/8"	STD	0.209"	0.254"	0.209"	0.222"	.062
1/2"	STD	0.207"	0.252"	0.207"	0.188"	.062
3/4"	STD	0.274"	0.338"	0.274"	0.275"	.062
1"	STD	0.283"	0.351"	0.278"	0.224"	.062
1 1/4"	STD	0.348"	0.435"	0.348"	0.246"	.062
1 1/2"	STD	0.339"	0.432"	0.325"	0.224"	.062
2"	STD	0.363"	0.459"	0.348"	0.217"	.062
2 1/2"	STD	0.473"	0.550"	0.521"	0.218"	.094
3"	STD	0.404"	0.466"	0.243"	0.275"	.094
4"	STD	0.512"	0.574"	0.393"	0.326"	.125
6"	STD	0.631"	0.725"	0.631"	0.419"	.125
3/8"	XS	0.236"	0.289"	0.236"	0.257"	.062
1/2"	XS	0.237"	0.290"	0.237"	0.258"	.062
3/4"	XS	0.305"	0.379"	0.305"	0.316"	.062
1"	XS	0.290"	0.368"	0.278"	0.302"	.062
1 1/4"	XS	0.387"	0.486"	0.387"	0.360"	.062
1 1/2"	XS	0.339"	0.398"	0.325"	0.311"	.062
2"	XS	0.363"	0.459"	0.348"	0.297"	.062
2 1/2"	XS	0.473"	0.550"	0.521"	0.331"	.094
3"	XS	0.452"	0.539"	0.243"	0.379"	.094
4"	XS	0.512"	0.574"	0.393"	0.420"	.125
6"	XS	0.759"	0.893"	0.759"	0.642"	.125

OUTLET SIZE	CLASS	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/4"	3M	0.211"	0.236"	0.211"	0.149"	.062
3/8"	3M	0.178"	0.213"	0.178"	0.213"	.062
1/2"	3M	0.209"	0.254"	0.209"	0.251"	.062
3/4"	3M	0.235"	0.287"	0.235"	0.275"	.062
1"	3M	0.331"	0.360"	0.280"	0.287"	.062
1 1/4"	3M	0.308"	0.359"	0.290"	0.246"	.062
1 1/2"	3M	0.356"	0.445"	0.335"	0.256"	.062
2"	3M	0.360"	0.426"	0.397"	0.196"	.062
2 1/2"	3M	0.490"	0.578"	0.339"	0.298"	.094
3"	3M	0.477"	0.572"	0.477"	0.426"	.094
4"	3M	0.643"	0.737"	0.801"	0.404"	.125
1/2"	6M	0.269"	0.342"	0.241"	0.310"	.062
3/4"	6M	0.299"	0.381"	0.272"	0.346"	.062
1"	6M	0.429"	0.541"	0.402"	0.512"	.062
1 1/4"	6M	0.491"	0.621"	0.491"	0.544"	.062
1 1/2"	6M	0.523"	0.667"	0.472"	0.580"	.062
2"	6M	0.517"	0.658"	0.488"	0.624"	.062

OUTLET SIZE	CLASS	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/4"	3M	0.132"	0.154"	0.132"	0.154"	.062
3/8"	3M	0.148"	0.174"	0.148"	0.116"	.062
1/2"	3M	0.224"	0.274"	0.186"	0.197"	.062
3/4"	3M	0.391"	0.356"	0.227"	0.280"	.062
1"	3M	0.296"	0.367"	0.280"	0.252"	.062
1 1/4"	3M	0.291"	0.373"	0.294"	0.248"	.062
1 1/2"	3M	0.314"	0.391"	0.335"	0.248"	.062
2"	3M	0.326"	0.406"	0.379"	0.288"	.062
2 1/2"	3M	0.430"	0.500"	0.339"	0.295"	.094
3"	3M	0.391"	0.449"	0.477"	0.302"	.094
4"	3M	0.653"	0.750"	0.801"	0.503"	.125
1/4"	6M	0.223"	0.272"	0.223"	0.250"	.062
3/8"	6M	0.278"	0.344"	0.278"	0.250"	.062
1/2"	6M	0.269"	0.342"	0.241"	0.288"	.062
3/4"	6M	0.299"	0.381"	0.272"	0.280"	.062
1"	6M	0.429"	0.541"	0.402"	0.397"	.062
1 1/4"	6M	0.367"	0.460"	0.367"	0.287"	.062
1 1/2"	6M	0.506"	0.641"	0.472"	0.357"	.062
2"	6M	0.517"	0.658"	0.488"	0.394"	.062

TYPICAL WELD SECTION PROFILE OF THE BONNEY FORGE WELDOLET



OUTLET SIZE	SCHEDULE	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/4"	STD	0.312"	0.203"	0.343"	0.156"	.062"
3/8"	STD	0.281"	0.250"	0.375"	0.218"	.062"
1/2"	STD	0.296"	0.234"	0.250"	0.218"	.062"
3/4"	STD	0.329"	0.219"	0.281"	0.250"	.062"
1"	STD	0.407"	0.345"	0.312"	0.250"	.062"
1 1/4"	STD	0.468"	0.406"	0.312"	0.312"	.062"
1 1/2"	STD	0.484"	0.422"	0.375"	0.312"	.062"
2"	STD	0.494"	0.453"	0.375"	0.312"	.062"
2 1/2"	STD	0.624"	0.531"	0.500"	0.312"	.094"
3"	STD	0.655"	0.562"	0.500"	0.312"	.094"
3 1/2"	STD	0.718"	0.609"	0.500"	0.375"	.094"
4"	STD	0.749"	0.609"	0.500"	0.375"	.125"
5"	STD	0.936"	0.750"	0.625"	0.437"	.125"
6"	STD	0.686"	0.891"	0.625"	0.375"	.125"
8"	STD	0.780"	1.000"	0.687"	0.375"	.156"
10"	STD	0.842"	1.094"	0.750"	0.437"	.156"
12"	STD	0.890"	1.219"	0.812"	0.437"	.156"
14"	STD	0.905"	1.234"	0.875"	0.437"	.156"
16"	STD	0.968"	1.500"	0.875"	0.437"	.156"
18"	STD	1.249"	1.562"	0.875"	0.437"	.187"
20"	STD	1.186"	1.625"	0.875"	0.437"	.187"
24"	STD	1.249"	1.812"	0.875"	0.437"	.187"

OUTLET SIZE	SCHEDULE	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/4"	XS	0.312"	0.203"	0.343"	0.156"	.062"
3/8"	XS	0.281"	0.250"	0.375"	0.218"	.062"
1/2"	XS	0.296"	0.234"	0.250"	0.218"	.062"
3/4"	XS	0.329"	0.219"	0.281"	0.250"	.062"
1"	XS	0.407"	0.345"	0.312"	0.250"	.062"
1 1/4"	XS	0.468"	0.406"	0.312"	0.312"	.062"
1 1/2"	XS	0.484"	0.422"	0.375"	0.312"	.062"
2"	XS	0.494"	0.453"	0.375"	0.312"	.062"
2 1/2"	XS	0.624"	0.531"	0.500"	0.312"	.094"
3"	XS	0.655"	0.562"	0.500"	0.312"	.094"
3 1/2"	XS	0.718"	0.609"	0.500"	0.375"	.094"
4"	XS	0.749"	0.609"	0.500"	0.375"	.125"
5"	XS	0.936"	0.750"	0.625"	0.437"	.125"
6"	XS	0.874"	1.094"	0.625"	0.500"	.125"
8"	XS	1.124"	1.046"	0.875"	0.500"	.156"
10"	XS	1.030"	1.375"	1.187"	0.562"	.156"
12"	XS	1.218"	1.625"	1.312"	0.562"	.156"
14"	XS	1.155"	1.625"	0.875"	0.562"	.156"
16"	XS	1.155"	1.687"	0.937"	0.562"	.156"
18"	XS	1.187"	1.812"	0.875"	0.562"	.187"
20"	XS	1.249"	1.906"	0.875"	0.562"	.187"
24"	XS	1.311"	2.000"	1.000"	0.562"	.187"

OUTLET SIZE	SCHEDULE	LONGITUDINAL SECTION		TRANSVERSE SECTION		ROOT GAP
		L _L Dim.	T _L Dim.	L _T Dim.	T _T Dim.	
1/2"	XXS & S160	0.437"	0.400"	0.274"	0.266"	.062"
3/4"	XXS & S160	0.500"	0.484"	0.293"	0.287"	.062"
1"	XXS & S160	0.562"	0.492"	0.320"	0.316"	.062"
1 1/4"	XXS & S160	0.655"	0.578"	0.312"	0.327"	.062"
1 1/2"	XXS & S160	0.719"	0.609"	0.360"	0.366"	.062"
2"	XXS & S160	0.765"	0.906"	0.373"	0.434"	.062"
2 1/2"	XXS & S160	1.000"	0.845"	0.437"	0.500"	.094"
3"	XXS & S160	1.094"	0.906"	0.549"	0.521"	.094"
3 1/2"	XXS & S160	0.781"	1.281"	0.495"	0.743"	.094"
4"	XXS & S160	1.375"	1.078"	0.631"	0.642"	.125"