

**Data Sheet**

## Plain Ended Welding Fittings - BS 4825 Part 2

Alchem offer a wide range of plain ended weld fittings to suit both hygienic and pharmaceutical applications. These include bends, tees, and reducers, both concentric and eccentric. We also offer a wide range Y-Pieces, and Swept Bends, Swept Tees and Crosses, fabricated to suit the customers' requirements.

Extended weld fittings are also offered to suit orbital welding techniques and to meet the requirements of the ASME BPE 2002 standard for pharmaceutical installations. We can also offer pharmaceutical fittings in DIN 11852 including Bends, Tees, Reducers and Manifolds.

Specially fabricated products are also offered in addition to non-standard bends tees, manifolds and reducers.

We can also provide large rolled bends with up to 1.0 Metre Bend Radius, as used in sugar and granule transfer systems.

### Related Products:

Fabrication facility for fully welded products  
90° Bends in 1D, 1.5D, 2D and 3D radius  
Y Pieces and Swept Bends  
Jacketed Pipework including Bends and Tees  
Weld Rings for Jacket assembly  
Rolled Bends up to 1.0 Metre Diameter  
Equal Tees, Pulled Tees, Reducing Tees and Manifolds  
Filters, Screens and Sampling Equipment



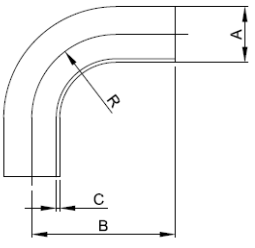
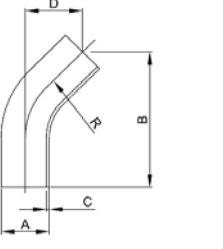
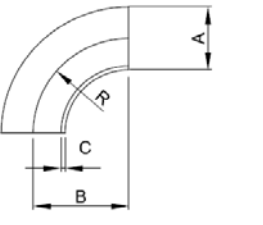
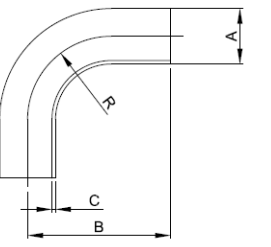
### Full range of Butterfly Valves, Ball Valves, Pressure Relief and Non-Return

### Associated Standards:

- BS 4825 Part 1 - Stainless Steel Tube for Food Industry and Hygienic Applications
- BS 4825 Part 2 - Stainless Steel Bends and Tees for the Food Industry
- ASTM A270 - Stainless Steel Tube for Sanitary, Dairy and Food Industries
- ASTM A269 - Stainless Steel Tubes for General Duties Duties
- ASME BPE - Pharmaceutical Tube, Imperial
- ISO 2037 - Stainless Steel Tubes for the Food Industry
- ISO 1127 - Stainless Steel Tubes
- ISO 2851 - Stainless Steel Bends and Tees for the Food Industry

**Data Sheet**

**Plain Ended Weld Fittings - Imperial**

Plain Ended Weld Fittings - Imperial						
<p>Bends 1.5 D, 90° BS Long, Polished</p> 	Size	A	B	C	R	Part No
	½"	12.7	62.5	1.6	25	<a href="#">2040-A013</a>
	¾"	19.05	62.5	1.6	32	<a href="#">2040-A019</a>
	1"	25.4	65	1.6	38	<a href="#">2040-A026</a>
	1¼"	31.8	85	1.6	51	<a href="#">2040-A032</a>
	1½"	38.1	85	1.6	57	<a href="#">2040-A038</a>
	2"	50.8	110	1.6	76	<a href="#">2040-A051</a>
	2½"	63.5	135	1.6	95	<a href="#">2040-A064</a>
	3"	76.2	155	1.6	114	<a href="#">2040-A076</a>
	4"	101.6	195	2.0	152	<a href="#">2040-A102</a>
<p>Bends R=1.5 D, 45° BS Short, Polished</p> 	Size	A	B	C	D	Part No
	1"	25.4	51.5	1.6	22	<a href="#">2046-A026</a>
	1½"	38.1	70.5	1.6	29	<a href="#">2046-A038</a>
	2"	50.8	100	1.6	42	<a href="#">2046-A051</a>
	2½"	63.5	130	1.6	54	<a href="#">2046-A064</a>
	3"	76.2	154	1.6	64	<a href="#">2046-A076</a>
	4"	101.6	209	2.0	86	<a href="#">2046-A102</a>
<p>Bends R=1.5 D, 90° BS Short, Polished</p> 	Size	A	B	C	R	Part No
	1"	25.4	44	1.6	38	<a href="#">2041-A026</a>
	1½"	38.1	64	1.6	57	<a href="#">2046-A038</a>
	2"	50.8	89	1.6	76	<a href="#">2046-A051</a>
	2½"	63.5	114	1.6	95	<a href="#">2046-A064</a>
	3"	76.2	134	1.6	114	<a href="#">2046-A076</a>
	4"	101.6	174	2.0	152	<a href="#">2046-A102</a>
<p>Bends R=1.0 D, 90°, Polished</p> 	Size	A	B	C	R	Part No
	1"	25.4	55	1.6	25	<a href="#">2049-A026</a>
	1½"	38.1	70	1.6	38	<a href="#">2049-A038</a>
	2"	50.8	82	1.6	51	<a href="#">2049-A051</a>
	2½"	63.5	105	1.6	64	<a href="#">2049-A064</a>
	3"	76.2	110	1.6	76	<a href="#">2049-A076</a>

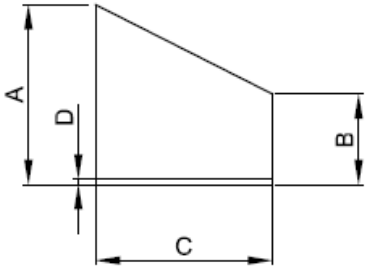
Notes:

Please check length at the time of enquiry

**Data Sheet**

## Welding Fittings - Eccentric Reducers

Eccentric Weld Reducers, 316L, Polished						
Size	A	B	C	D	Part No	
1" x 1/2"	25.4	12.7	21	1.6	2054-A026-013	
1" x 3/4"	25.4	19.1	28	1.6	2054-A026-019	
1 1/2" x 1"	38.1	25.4	29	1.6	2054-A038-026	
2" x 1"	50.8	25.4		1.6	2054-A51-026	
2" x 1 1/2"	50.8	38.1	40	1.6	2054-A051-38	
2 1/2" x 1"	63.5	25.4	80	1.6	2054-A064-026	
2 1/2" x 1 1/2"	63.5	38.1	78	1.6	2054-A064-038	
2 1/2" x 2"	63.5	50.8	39	1.6	2054-A064-051	
3" x 1"	76.2	25.4	108	1.6	2054-A076-026	
3" x 1 1/2"	76.2	38.1	90	1.6	2054-A072-038	
3" x 2"	76.2	50.8	78	1.6	2054-A076-051	
3" x 2 1/2"	76.2	63.5	39	1.6	2054-A076-064	
4" x 1"	101.6	25.4	138	2.0	2054-A102-026	
4" x 1 1/2"	101.6	38.1	116	2.0	2054-A102-038	
4" x 2"	101.6	50.8	76	2.0	2054-A102-051	
4" x 2 1/2"	101.6	63.5	117	2.0	2054-A102-064	
4" x 3"	101.6	76.2	78	2.0	2054-A102-076	

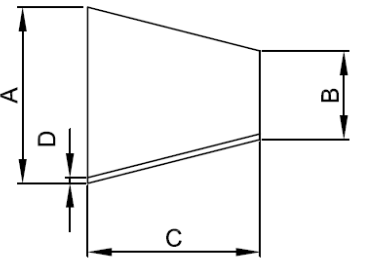


**Notes:**

- Lengths are subject to change, please check at the time of enquiry.
- Other options including 1.1/4" and metric variations available on request.

## Welding Fittings – Concentric Reducers

Concentric Weld Reducers, 316L, Polished						
Size	A	B	C	D	Part No	
1" x 1/2"	25.4	12.7	22	1.6	2051-A026-013	
1" x 3/4"	25.4	19.1	28	1.6	2051-A026-019	
1 1/2" x 1"	38.1	25.4	37	1.6	2051-A038-026	
2" x 1"	50.8	25.4	54	1.6	2051-A051-026	
2" x 1 1/2"	50.8	38.1	36	1.6	2051-A051-038	
2 1/2" x 1"	63.5	25.4	60	1.6	2051-A064-026	
2 1/2" x 1 1/2"	63.5	38.1	66	1.6	2051-A064-038	
2 1/2" x 2"	63.5	50.8	34	1.6	2051-A64-051	
3" x 1"	76.2	25.4	88	1.6	2051-A076-026	
3" x 1 1/2"	76.2	38.1	90	1.6	2051-A076-038	
3" x 2"	76.2	50.8	66	1.6	2051-A076-051	
3" x 2 1/2"	76.2	63.5	44	1.6	2051-A076-064	
4" x 1"	101.6	25.4	150	2.0	2051-A102-026	
4" x 1 1/2"	101.6	38.1	125	2.0	2051-A102-038	
4" x 2"	101.6	50.8	100	2.0	2051-A102-051	
4" x 2 1/2"	101.6	63.5	73	2.0	2051-A102-064	
4" x 3"	101.6	76.2	77	2.0	2051-A102-076	

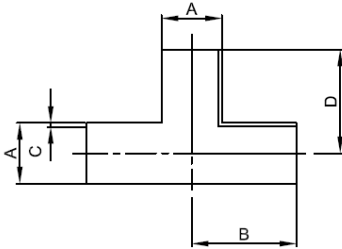
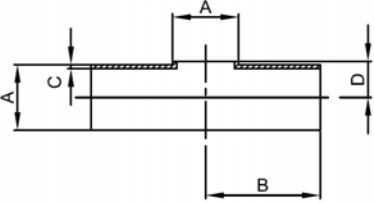
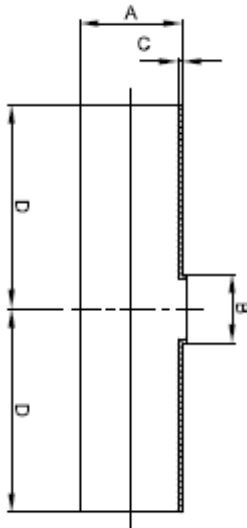


**Notes:**

- Lengths are subject to change, please check at the time of enquiry.
- Other options including 1.1/4" and metric variations available on request.

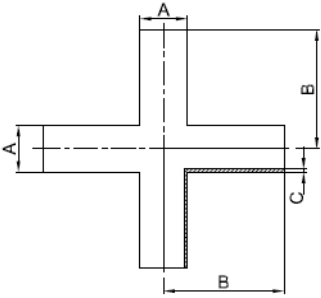
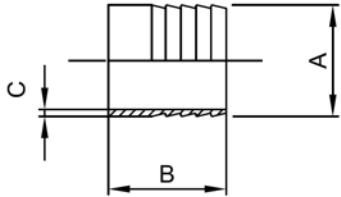
**Data Sheet**

## Welding Fittings – Tees

<b>Welding Fittings – Tees</b>						
<p style="text-align: center;">Equal Tee, 316, Polished OD</p> 	Size	A	B	C	D	Part No
	½"	12.7		1.6		204P-A012
	¾"	19.05		1.6		204P-A019
	1"	25.4	44	1.6	44	204P-A026
	1½"	38.1	64	1.6	64	204P-A038
	2"	50.8	89	1.6	89	204P-A051
	2½"	63.5	114	1.6	114	204P-A064
	3"	76.2	134	1.6	134	204P-A076
	4"	101.6	174	2.0	174	204P-A102
<p style="text-align: center;">Pulled Equal Tee, 316, Polished OD</p> 	Size	A	B	C	D	Part No
	1"	25.4	44	1.6	14	204T-A026
	1½"	38.1	64	1.6	19	204T-A038
	2"	50.8	89	1.6	29	204T-A051
	2½"	63.5	114	1.6	35	204T-A064
	3"	76.2	134	1.6	41	204T-A076
4"	101.6	174	2.0	55	204T-A102	
<p style="text-align: center;">Pulled Reducing Tees, 316L, Polished OD</p> 	Size	A	B	C	D	Part No
	1" x ½"	25.4	12.7	1.5		204V-A026-013
	1" x ¾"	25.4	19.1	1.5		204V-A026-019
	1½" x ½"	38.1	12.7	1.5		204V-A38-013
	1½" x ¾"	38.1	19.1	1.5		204V-A038-019
	1½" x 1"	38.1	25.4	1.5		204V-A038-026
	2" x ½"	50.8	12.7	1.5		204V-A051-013
	2" x ¾"	50.8	19.1	1.5		204V-A051-019
	2" x 1"	50.8	25.4	1.5		204V-A051-026
	2" x 1½"	50.8	38.1	1.5		204V-A051-038
	2½" x ½"	63.5	12.7	1.5		204V-A064-013
	2½" x ¾"	63.5	19.1	1.5		204V-A064-019
	2½" x 1"	63.5	25.4	1.5		204V-A064-025
	2½" x 1½"	63.5	38.1	1.5		204V-A064-038
	2½" x 2"	63.5	50.8	1.5		204V-A064-051
	3" x ½"	76.2	12.7	1.5		204V-A076-013
	3" x ¾"	76.2	19.1	1.5		204V-A076-019
	3" x 1"	76.2	25.4	1.5		204V-A076-026
	3" x 1½"	76.2	38.1	1.5		204V-A076-038
	3" x 2"	76.2	50.8	1.5		204V-A076-051
	3" x 2½"	76.2	63.5	1.5		204V-A076-064
	4" x 1"	101.6	25.4	2.0		204V-A102-026
	4" x 1½"	101.6	38.1	2.0		204V-A102-038
	4" x 2"	101.6	50.8	2.0		204V-A102-051
	4" x 2½"	101.6	63.5	2.0		204V-A102-064
	4" x 3"	101.6	76.2	2.0		204V-A102-076
<p>Other options including 1.1/4" and metric variations available on request. Please check lengths at the time of enquiry.</p>						

**Data Sheet**

## Welding Fittings – Crosses

Welding Fittings – Crosses						
<p>Equal Cross, 316L, Polished OD</p> 	Size	A	B	C	D	Part No
	1"	25.4		1.5		204X-A026
	1½"	38.1		1.5		204X-A038
	2"	50.8		1.5		204X-A051
	2½"	63.5		1.5		204X-A064
	3"	76.2		1.5		204X-A076
	4"	101.6		2.0		204X-A102
Leg lengths are to be confirmed at the time of enquiry						
<p>Plain Hosetail, 316L, Polished OD</p> 	Size	A	B	C	D	Part No
	½"	12.7		1.5		2059-A013
	¾"	19.1		1.5		2059-A019
	1"	25.4		1.5		2059-A026
	1½"	38.1		1.5		2059-A038
	2"	50.8		1.5		2059-A051
	2½"	63.5		1.5		2059-A064
3"	76.2		1.5		2059-A076	
4"	101.6		2.0		2059-A102	
Lengths are to be confirmed at the time of enquiry						