



# Weld & Metal Seal Fittings

## 焊接接头

- 特征:**
- ◎ 弯头流道圆滑过渡, 降低流道阻力, 确保流体平稳流动
  - ◎ 加工精确, 直径与 Tube 管直径匹配
  - ◎ 焊接端口平直, 无毛刺
  - ◎ 可手动或自动焊接
  - ◎ Tube 管壁厚均匀, 提高焊接的可重复性
  - ◎ M系列、L系列焊接接头标准平均表面粗糙度 Ra 0.25  $\mu\text{m}$  或电解抛光 Ra 0.13  $\mu\text{m}$  可选
  - P系列焊接接头标准平均表面粗糙度 Ra 0.38  $\mu\text{m}$ 或电解抛光 Ra 0.25  $\mu\text{m}$  可选
  - ◎ 每个接头上都刻有品牌、材料和炉号

### 技术数据:

- ◎ 材料

材料	棒料 <sup>①</sup>	锻件 <sup>②</sup>	代号
316 SS	ASTM A479	ASTM A182	16
316L SS	SEMI F20	SEMI F20	40
316L VAR SS			40V
316L VIM+VAR SS			40W

① 仅适用于直通型和所有M系列焊接接头。

② 包含所有弯头, 三通和四通接头, 不包含M系列和P系列接头。

- ◎ 焊接端管尺寸及壁厚

英制		公制	
Tube 管外径 in.	壁厚 in.	Tube 管外径 mm	壁厚 mm
1/8	0.028	6	1.0
1/4	0.035	8	1.0
3/8	0.035	10	1.0
1/2	0.049	12	1.0
3/4	0.065	18	1.5
1	0.065		
1 1/2	0.065		
2	0.065		

- ◎ 工作温度

材料	最低温度	最高温度
316 SS	-198 °C (-325 °F)	538 °C (1000 °F)
316L SS		
316L VAR SS		
316L VIM+VAR SS		

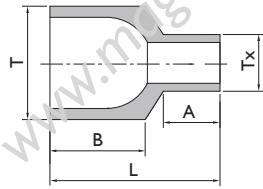
- ◎ 工作压力

- a. 样本所示工作压力是在室温下根据 ASME B31.3 和 B31.1 计算
- b. 为了得到在升温条件下的最大工作压力, 使用室温下的最大工作压力值乘以对应温度下的升温系数。  
具体请参考迈格诺科Tubing管高温系数表。

### 注意

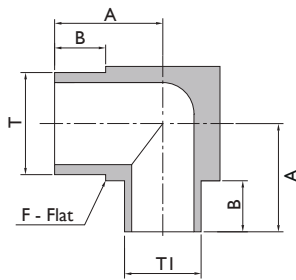
- ◎ 尺寸仅供参考, 可能有变动
- ◎ 推荐使用相同材料进行焊接, 因为这些材料具有相同的热膨胀系数, 降低出现圆度不够或尺寸变化等焊接缺陷的可能性

## Micro Reducer 微焊变径



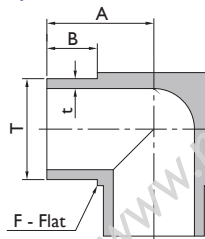
Size (OD)	Size (OD1)	Ordering Number	Dimensions .mm				
			A	B	L	T	Tx
3/8"	1/4"	M6 x 4R6	6.35	10.4	19.1	9.53	6.35
1/2"	1/4"	M8 x 4R6	6.35	10.4	19.1	12.70	6.35
1/2"	3/8"	M8 x 6R6	6.35	10.4	19.1	12.70	9.53
3/4"	1/4"	M12 x 4R6	6.35	10.4	19.1	19.05	6.35
3/4"	3/8"	M12 x 6R6	6.35	10.4	19.1	19.05	9.53
3/4"	1/2"	M12 x 8R6	6.35	10.4	19.1	19.05	12.70

## Micro Reducing 90° Elbow 微焊90° 变径弯头



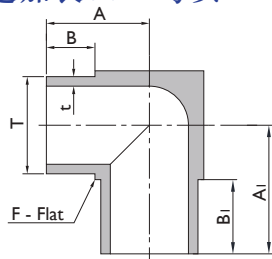
Size (T)	Size (T1)	Ordering Number	Dimensions, mm			
			A	B	T	Tx
3/8"	1/4"	M6 x 4E6	11.91	6.35	9.53	6.35
1/2"	1/4"	M8 x 4E6	13.50	6.35	12.70	6.35
1/2"	3/8"	M8 x 6E6	13.50	6.35	12.70	9.53
3/4"	1/4"	M12 x 4E6	16.68	6.35	19.05	6.35
3/4"	3/8"	M12 x 6E6	16.68	6.35	19.05	9.53
3/4"	1/2"	M12 x 8E6	16.68	6.35	19.05	12.70

## Micro 90° Elbow 微焊90° 弯头



Size (OD)	Ordering Number	Dimensions, mm		
		A	B	T
1/4"	M4E6	10.32	6.35	6.35
3/8"	M6E6	11.91	6.35	9.53
1/2"	M8E6	13.50	6.35	12.70
3/4"	M12E6	16.68	6.35	19.05

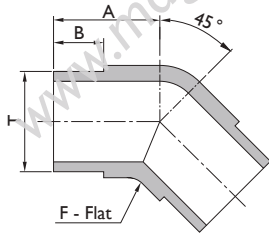
## Micro Extended Leg 90° Elbow 微焊单边加长90° 弯头



Size (OD)	Ordering Number	Dimensions, mm				
		A	A1	B	B1	T
1/4"	M4EX1	12.30	17.38	6.35	11.43	6.35

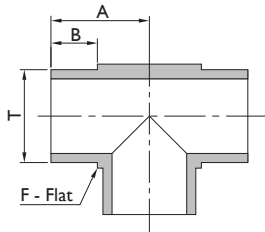
# Weld & Metal Seal Fittings

## Micro 45° Elbow 微焊45° 弯头



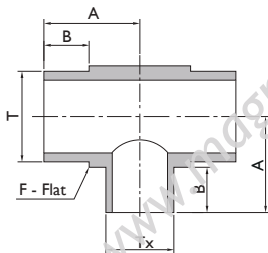
Size (OD)	Ordering Number	Dimensions, mm		
		A	B	T
1/4"	M4HE6	10.32	6.35	6.35
3/8"	M6HE6	11.91	6.35	9.53
1/2"	M8HE6	13.50	6.35	12.70
3/4"	M12HE6	16.68	6.35	19.05

## Micro Tee 微焊三通



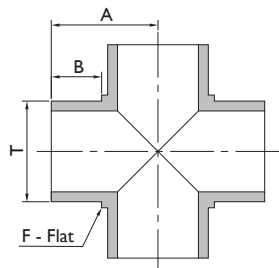
Size (OD)	Ordering Number	Dimensions, mm		
		A	B	T
1/4"	M4T6	10.32	6.35	6.35
3/8"	M6T6	11.91	6.35	9.53
1/2"	M8T6	13.50	6.35	12.70
3/4"	M12T6	16.68	6.35	19.05

## Micro Reducing Tee 微焊变径三通



Size (OD)	Size (OD <sub>1</sub> )	Ordering Number	Dimensions, mm			
			A	B	T	TX
3/8"	1/4"	M6 x 4T6	11.91	6.35	9.53	6.35
1/2"	1/4"	M8 x 4T6	13.50	6.35	12.70	6.35
1/2"	3/8"	M8 x 6T6	13.50	6.35	12.70	9.53
3/4"	1/4"	M12 x 4T6	16.68	6.35	19.05	6.35
3/4"	3/8"	M12 x 6T6	16.68	6.35	19.05	9.53
3/4"	1/2"	M12 x 8T6	16.68	6.35	19.05	12.70

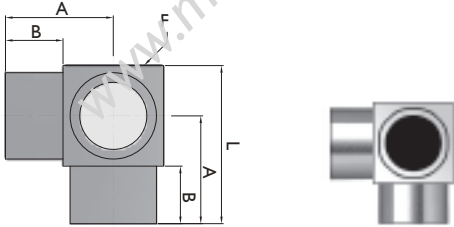
## Micro Cross 微焊四通



Size (OD)	Ordering Number	Dimensions, mm		
		A	B	T
1/4"	M4CT6	10.32	6.35	6.35
3/8"	M6CT6	11.91	6.35	9.53
1/2"	M8CT6	13.50	6.35	12.70
3/4"	M12CT6	16.68	6.35	19.05

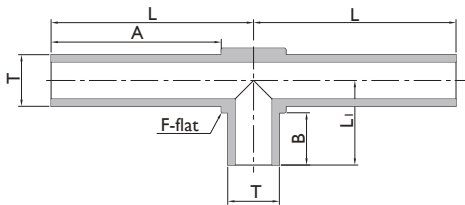
# Weld & Metal Seal Fittings

## Micro Tribow 微焊立体三通



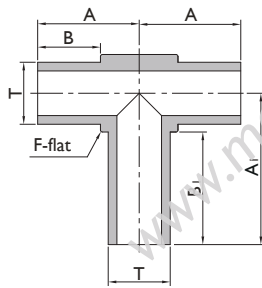
Size (OD)	Ordering Number	Dimensions, mm		
		A	B	L
1/4"	M4TB6	10.32	6.35	14.29
3/8"	M6TB6	11.91	6.35	17.46
1/2"	M8TB6	13.50	6.35	20.64
3/4"	M12TB6	16.68	6.35	27.00

## Micro Extended Run Tee 微焊加长三通



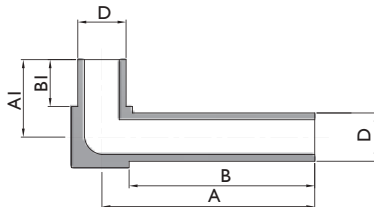
Size (OD)	Ordering Number	Dimensions, mm				
		A	B	L <sub>1</sub>	L	T
1/4"	MEXT50	21.05	6.35	10.32	25.00	6.35

## Micro Extended Branch Leg Tee 微焊支管加长三通



Size (OD)	Ordering Number	Dimensions, mm				
		A	A <sub>1</sub>	B	B <sub>1</sub>	T
1/4"	MEXT25	10.35	25.00	6.35	21.00	6.35

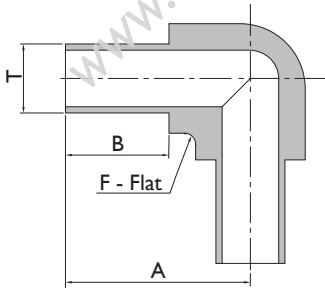
## Micro Extended Leg 90° Elbow 微焊单边特长90°弯头



Size (OD)	Ordering Number	Dimensions, mm				
		A	A <sub>1</sub>	B	B <sub>1</sub>	D
1/4"	MEXE29	25.00	10.32	21.05	6.35	6.35

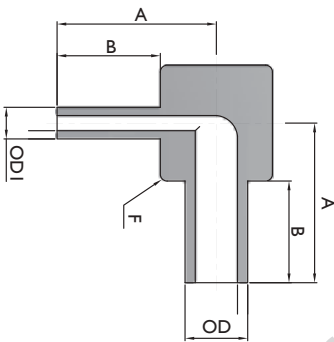
# Weld & Metal Seal Fittings

## 90° Elbow 90° 长焊弯头



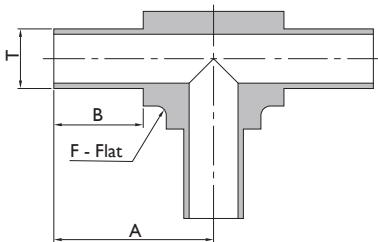
Size (OD)	Ordering Number	Dimensions, mm		
		A	B	T
1/4"	L4E19	25.0	19.05	6.35
3/8"	L6E19	25.0	19.05	9.53
1/2"	L8E19	29.0	19.05	12.70
1/4"	L4E10	15.9	10.00	6.35
3/8"	L6E10	15.9	10.00	9.53
1/2"	L8E10	19.9	10.00	12.70
3/4"	L12E10	22.4	10.00	19.05
3/4"	L12E22	33.5	22.5	19.05
1"	L16E23	38.5	23.3	25.4

## Reducing 90° Elbow 90° 变径长焊弯头



Size (OD)	Size (OD <sub>1</sub> )	Ordering Number	Dimensions, mm	
			A	B
3/8"	1/4"	L6 x 4E19	25	19.05
1/2"	1/4"	L8 x 4E19	29	19.05
1/2"	3/8"	L8 x 6E19	29	19.05
3/4"	1/4"	L12 x 4E22	34	22.5
1"	1/2"	L16 x 8E23	38.3	23.3

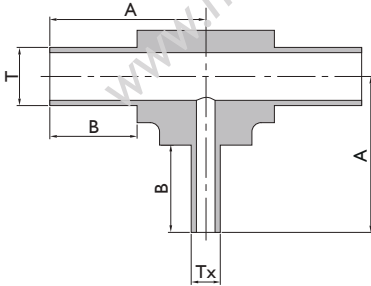
## Tee 长焊三通



Size (OD)	Ordering Number	Dimensions, mm		
		A	B	T
1/4"	L4T19	25.0	19.05	6.35
3/8"	L6T19	25.0	19.05	9.53
1/2"	L8T19	29.0	19.05	12.70
1/4"	L4T10	15.9	10.00	6.35
3/8"	L6T10	15.9	10.00	9.53
1/2"	L8T10	19.9	10.00	12.70
3/4"	L12T10	22.4	10.00	19.05
3/4"	L12T22	33.5	22.5	19.05
1"	L16T23	38.3	23.3	25.4

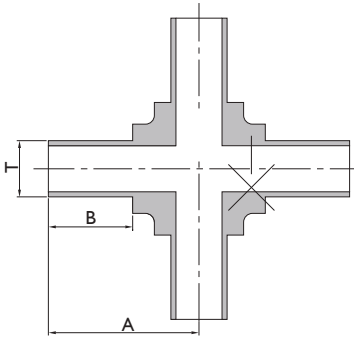
# Weld & Metal Seal Fittings

## Reducing Tee 长焊变径三通



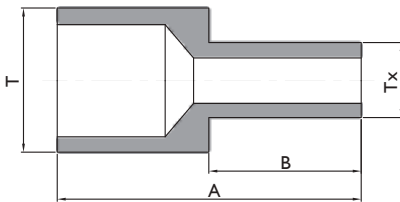
Size (OD)	Size (OD1)	Ordering Number	Dimensions, mm			
			A	B	T	Tx
3/8"	1/4"	L6 x 4T19	25.0	19.05	9.53	6.35
1/2"	1/4"	L8 x 4T19	29.0	19.05	12.70	6.35
1/2"	3/8"	L8 x 6T19	29.0	19.05	12.70	9.53
3/4"	1/4"	L12 x 4T22	33.5	22.5	19.05	6.35
3/4"	3/8"	L12 x 6T22	33.5	22.5	19.05	9.53
3/4"	1/2"	L12 x 8T22	33.5	22.5	19.05	12.7
1"	1/4"	L16 x 4T23	38.3	23.3	25.4	6.35
1"	1/2"	L16 x 8T23	38.3	23.3	25.4	12.7
3/8"	1/4"	L6 x 4T10	15.9	10.00	9.53	6.35
1/2"	1/4"	L8 x 4T10	19.9	10.00	12.70	6.35
1/2"	3/8"	L8 x 6T10	19.9	10.00	12.70	9.53
3/4"	1/4"	L12 x 4T10	22.4	10.00	19.05	6.35
3/4"	3/8"	L12 x 6T10	22.4	10.00	19.05	9.53

## Cross Tee 长焊四通



Size (OD)	Ordering Number	Dimensions, mm		
		A	B	T
1/4"	L4CT19	25.0	19.05	6.35
3/8"	L6CT19	25.0	19.05	9.53
1/2"	L8CT19	29.0	19.05	12.70
3/4"	L12CT19	31.5	19.05	19.05
1/4"	L4CT10	15.9	10.00	6.35
3/8"	L6CT10	15.9	10.00	9.53
1/2"	L8CT10	19.9	10.00	12.70
3/4"	L12CT10	22.4	10.00	19.05

## Reducer 长焊变径



Size (OD)	Size (OD1)	Ordering Number	Dimensions, mm			
			A	B	T	Tx
3/8"	1/4"	L6 x 4R19	19.05	38.1	9.53	6.35
1/2"	1/4"	L8 x 4R19	19.05	38.1	12.70	6.35
1/2"	3/8"	L8 x 6R19	19.05	38.1	12.70	9.53
3/4"	1/4"	L12 x 4R19	19.05	42.9	19.05	6.35
3/4"	3/8"	L12 x 6R19	19.05	42.9	19.05	9.53
3/4"	1/2"	L12 x 8R19	19.05	42.9	19.05	12.70
3/8"	1/4"	L6 x 4R10	10.00	20.0	9.53	6.35
1/2"	1/4"	L8 x 4R10	10.00	20.0	12.70	6.35
1/2"	3/8"	L8 x 6R10	10.00	20.0	12.70	9.53
3/4"	1/4"	L12 x 4R10	10.00	20.0	19.05	6.35
3/4"	3/8"	L12 x 6R10	10.00	20.0	19.05	9.53
3/4"	1/2"	L12 x 8R10	10.00	20.0	19.05	12.70

# MEMO

