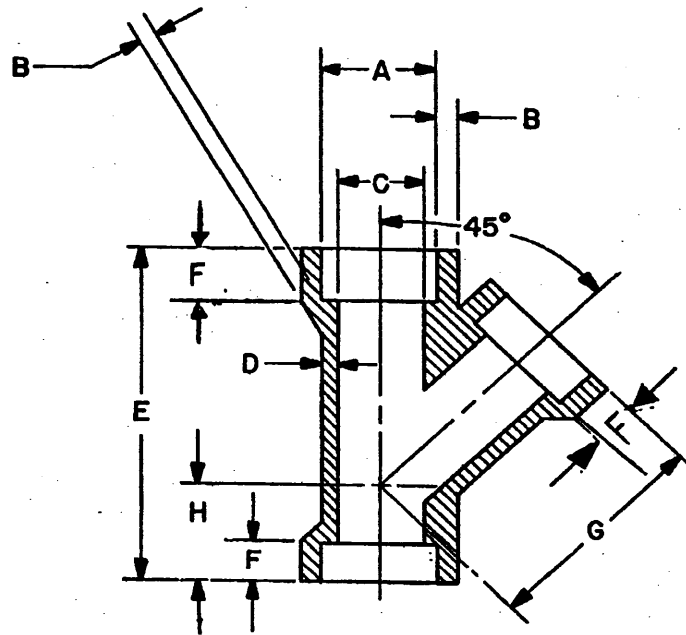


This military standard is approved for use by the Naval Sea Systems Command and is available for use by all Departments and Agencies of the Department of Defense.



(B) denotes changes

P. A. SH Other Cost	INTERNATIONAL INTEREST	TITLE LATERALS, FORGED STEEL SOCKET WELDING 3000 PSI AT 1000°F (MAX.) STEAM SERVICE	MILITARY STANDARD MS18307(SH)
PROCUREMENT SPECIFICATION		SUPERSEDES:	Page 1 of 2

DD FORM 672-1 (LIMITED COORDINATION)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

Project 4730-N463

FED. SUP CLASS
4730

APPROVED 21 NOV 1975 REVISED (A) 23 MAY 1978 (B) 29 JUL 1982

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P. A. SH
Other Cust

INTERNATIONAL
INTEREST

TITLE
LATERALS, FORGED STEEL SOCKET WELDING
3000 PSI AT 1000°F (MAX.)
STEAM SERVICE

MILITARY STANDARD

MS18307(SH)

PROCUREMENT SPECIFICATION

SUPERSEDES:

Page 2 OF 2

DD FORM 672-1 (LIMITED COORDINATION)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

FED. SUP CLASS
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Nominal pipe size	Socket bore dia. A ₂ /	Socket wall thickness B ₁ /		Bore dia. C ₂ /	Body wall dia. D Min.	E Min.	Socket depth F. Min.	G Min.	H Min.
		Avg.	Min.						
1/4	0.565 .555	0.149	0.130	0.394 .334	0.119	2- 5/16	0.380	1- 5/8	11/16
3/8	.700 .690	.158	.138	.523 .463	.126	2-11/16	.380	1- 7/8	11/16
1/2	.865 .855	.184	.161	.652 .592	.147	3	.380	2- 1/8	13/16
3/4	1.075 1.065	.193	.168	.854 .794	.154	3- 9/16	.500	2- 9/16	1
1	1.340 1.330	.224	.196	1.079 1.019	.179	4- 1/8	.500	3	1- 1/16
1-1/4	1.685 1.675	.239	.208	1.410 1.350	.191	4-13/16	.500	3- 1/2	1- 3/16
1-1/2	1.925 1.915	.250	.218	1.640 1.580	.200	5- 7/8	.500	3-15/16	1-15/16
2	2.416 2.406	.273	.238	2.097 2.037	.218	6- 7/16	.620	4- 3/4	1- 5/8

1/ Average of socket wall thickness around periphery shall be no less than listed values.
The minimum values are permitted in localized areas.

2/ Upper and lower values for each size are the respective maximum and minimum dimensions.

NOTES:

1. All procurement documents shall specify the number and revision of this standard and the size required.
2. Material of fittings made from this standard shall be chromium-molybdenum alloy steel, 1-1/4 chromium 1/2 molybdenum per ASTM A-182 grade F-11 or ASTM A-217 grade WC-6.
3. All Dimensions are in inches.
4. Unless otherwise noted on this standard, fittings shall conform to ANSI B-16.11.

APPROVED 29 Jul 1982 Revised (B) For change see page 2.