

HG

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Lining PTFE steel pipes and fittings

衬聚四氟乙烯钢管和管件

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PTFE Lined Steel Pipes and Pipe Fittings

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Notice on Issuance of Chemical Industry Standard *PTFE Lined Steel Pipes and Pipe Fittings*

To chemical departments (bureaus, companies) in provinces, autonomous regions, municipalities directly under the central government, and municipalities with independent planning status, and the related design units:

The *PTFE Lined Steel Pipes and Pipe Fittings Standard* prepared by Shanghai Pharmaceutical Industry Design Institute under the organization of the Process Piping Design Technology Center of the Ministry is hereby approved as a recommended chemical industry standard numbered *HG/T 21562-94* upon review. It will be implemented as of March 1, 1995.

This standard is in the charge of management by the Process Piping Design Technology Center of the Ministry of Chemical Industry; and the Engineering Construction Standard Editing Center of the Ministry of Chemical Industry is responsible for its publication and issuance.

Ministry of Chemical Industry

December 29, 1994

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PTFE Lined Steel Pipes and Pipe Fittings

1 Subject content and scope of application

1.0.1 This standard specifies the dimension, technical conditions, testing, marking, packaging, transportation and storage of PTFE lined steel pipes and pipe fittings.

1.0.2 This standard applies to PTFE lined straight pipes and pipe fittings with carbon steel and cast steel (only for pipe fittings) as the substrate and the design pressure $\leq 1.6MPa$ gauge pressure and fluid medium temperature $> -20^{\circ}C$ - $\leq 180^{\circ}C$. See Table 1.0.2-1.

Table 1.0.2-1

PTFE pipe molding methods	Operating temperature:	Nominal pressure
Winding pipe	$> -20^{\circ}C \sim 150^{\circ}C$	$\leq 0.6MPa$
Welded pipe	$> -20^{\circ}C \sim 180^{\circ}C$	$\leq 1.0MPa$
Ejected and extruded pipes	$> -20^{\circ}C \sim 180^{\circ}C$	$\leq 1.6MPa$

Negative pressure applies only to tight lining, and the relationship between negative pressure and temperature is shown in Table 1.0.2-2.

Table 1.0.2-2

Temperature	Negative pressure
$0^{\circ}C \sim 110^{\circ}C$	$-95kPa$
$> 110^{\circ}C \sim 140^{\circ}C$	$-65kPa$
$> 140^{\circ}C \sim 180^{\circ}C$	$-40kPa$

1.0.3 This standard does not apply to PTFE pipes and pipe fittings with spraying, nor applies to lined steel pipes and fittings processed with pasting method.

2 Referenced Standard

GB 1040 Plastics-Determination of tensile properties

GB 7136 Universal Molding PTFE Resin

GB 8163 Seamless steel tubes for liquid service

GB 8923 Rust grades and preparation grades of steel surfaces before application of paints and related products

GB 9114.2 Hubbed screwed steel pipe flanges with raised face

GB 9116.8 Hubbed slip-on-welding steel pipe flanges with raised face

GB 9117.2 Hubbed socket welding steel pipe flanges with male and female face

GB 9118.1 Loose hubbed steel pipe flanges with welding neck collar with raised face

GB 11352 Carbon steel castings for general engineering purpose

GB 12381.2 Hubbed screwed ductile iron pipe flanges with raised face

GB 12459 Steel butt-welding seamless pipe fittings

ZBG 33001 Polytetrafluoroethylene tube

ZBG 33002 Polyfluortetraethylene plate

HG 20553 Selection series of steel pipe size for chemical piping

HGJ 46 Hubbed slip-on-welding steel pipe flanges with flat face or raised face

HGJ 54 Hubbed socket welding steel pipe flanges with raised face

HGJ 57 Loose plate steel pipe flanges with weld-on collar with raised face

HGJ 229 Code for construction and acceptance of anticorrosive engineering or industrial equipment and pipeline

GBJ 235 Specifications for construction and acceptance of ventilation and air-conditioning work

3 Dimension

Steel pipe adopts I series in *HG 20553 Selection Series of Steel Pipe Dimension for Chemical Piping*; and if I series is required by the project, see the dimension specification in Annex A.

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