

Weld-In Nozzle (ISA 1932) EDUB 800 / EDUA 800

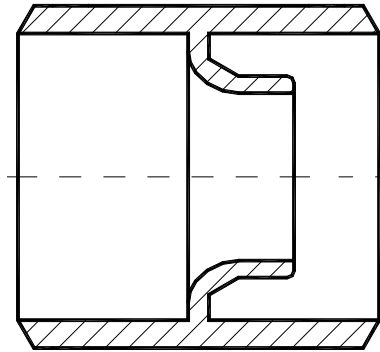
Application

Weld-in ISA 1932 nozzles are used as flow elements for flow measurement of aggressive and non-aggressive gases, steam and liquids.

Design

Weld-in ISA 1932 nozzles are mainly used for high pressure, high temperature applications, especially in power plants.

The pressure tapings can be designed as single bore holes (EDUB 800) or as a ring chamber (EDUA 800). If needed, we can weld inlet and outlet pipe sections to the nozzle. These pipe sections are usually provided by the customer. The welding seams are mechanically processed in order to meet the surface roughness requirements of the respective calculation standard.



Advantages

Weld-In flow elements are the recommended choice for high pressure and high temperature appliances because they avoid any kind of leakage.

The single bore tapings (EDUB 800) are easy to clean and thus suitable for process fluids which may accumulate, become resinous or for plants which are not operating constantly. The ring chamber design (EDUA 800) ensures that the pressure values are averaged over the cross section. This results in a steady measurement signal.

Measuring Uncertainty

ca. 0,8% - 1,2% of the discharge coefficient C, depending on the use case

Pressure Loss

The pressure loss depends on the diameter ratio β (d/D) and amounts to ca. 30 - 80% of the differential pressure.

Nominal Diameter (ISO 5167)

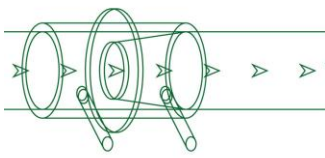
DN 50 to DN 500 / DN 2" to DN 20" (if requested other sizes are possible)

Pressure Rating

PN 40 to PN 400 / 150# to 2500# (ASME)

Connection Type

Weld preparation according to EN ISO 9692 (DIN 2559), ASME B16.25 or customer standard.



Standard Installation Lengths L (similar to DIN 19215)

The total length includes welded inlet and outlet pipe sections, often provided by the customer.

If longer inlet and outlet pipe sections are needed we recommend our ring chamber design EDUA 800 to ensure proper mechanical processing of the welding seams according to the requirements of ISO 5167.

Bore Diameter "d"

The calculation of the bore diameter is based on the supplied process data. All relevant standards and regulations will be considered. The calculation is part of the scope of supply.

Pressure Taps

Pressure taps will be designed according to customer requirements. Typical tap designs are:

- plain ends for fittings
- butt weld ends
- threaded ends
- flanged ends

The typical tapping length is ca. 100 mm.

Marking

Tag no. of flow element

Pressure rating "PN"

Pipe inner diameter "D"

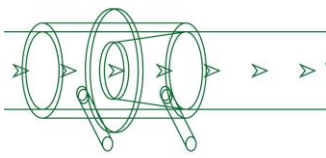
Bore diameter "d"

Material, direction of flow and tagging of pressure tappings with "+" and "-"

Materials

The following table shows a selection of typical materials utilized for weld-in nozzles. The material is chosen based on process medium, pressure and temperature. The pressure tap material is selected to be equivalent to the pipe material.

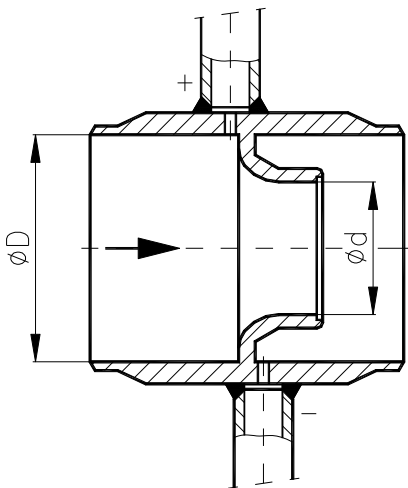
DN	Inlet length (mm)	Total length (mm)
50	150	250
65	180	300
80	230	350
100	280	400
125	350	500
150	400	600
200	570	800
250	690	1000
300	820	1200
350	950	1400
400	1050	1500
450	1200	1700
500	1370	2000



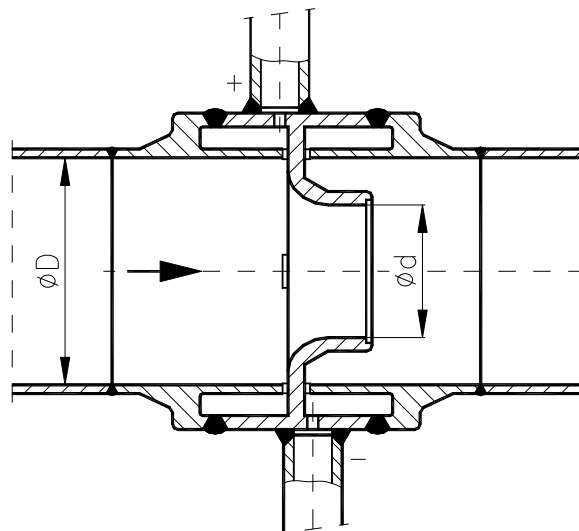
Material nozzle	short name	DIN material no.	ASTM / UNS
non-alloy steels	P 250GH (C22.8)	1.0460	~A105
	A105	~1.0432	A105
heat resistant/alloved steels	16Mo3	1.5415	A182 Gr. F1
	13CrMo45	1.7335	A182 Gr. F11
	10CrMo910	1.7380	A182 Gr. F22
	15 NiCuMoNb 5	1.6368	-
	X10CrNiMoNb91	1.4903	A182 Gr. F91
stainless steels	X2CrNiMo17-12-2	1.4404	316L
	X6CrNiMoTi 17 12 2	1.4571	316Ti
high corrosion-resistant alloys	Hastelloy C276	2.4819	N 10276
	Monel 400	2.4360	N 04400

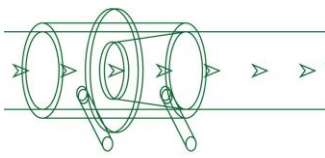
Example Designs

Single bore tapings
(EDUB 800)



Ring chamber design
(EDUA 800)





Installation

To be welded to pipes on construction site.

Quality Control

Manufacture and Test work is done according to the relevant codes and standards such as AD 2000, EN 13480, ASME Codes (without stamp) or customer specifications.

Inspection certificates according to EN 10204 3.1 and 3.2. may be furnished. Special inspections are also possible.

Accessories

Tap valves, condensate pots, manifolds, mounting accessories may be offered for additional charges.