

DIN 11852 (welding bends, tees and reducers)

In addition to the EN 10357-A (DIN 11850-R2), the DIN 11852 describes the technical specifications for the welding bends, tees and reducers. All other weld fittings like the tee-bends or Y-pieces, cross pieces or end caps aren't described in the norm, but are produced of tubes according EN 10357-A (DIN 11850-R2). The norm describes only welding bends, tees and reducers. For these parts, the dimensions and specifications are fixed. The other parts can vary per producer.

Type

Bends BS short and BL long in 45°, 90° and 180°

Tees TS long and TK short in symmetric and reducing type

Reducers RK conical and RE eccentric

Dimension range and material

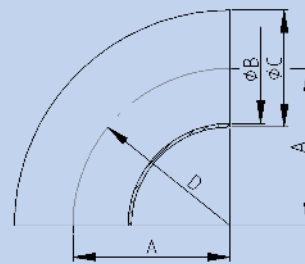
According EN 10357-A (DIN 11850-R2)

Tolerances and specifications

According DIN ISO 2468-1, ISO2768-c, DIN 2609 tbl.5 and DIN 6784
Ra internal 0,8µm and on seam < 1,6µm, in deformation field the value may deviate with factor 2.



Also unannealed available



BEND 90° BS ANNEALED DIN 11852 BS (SERIE 2)

DN	A	B	C	D	E	Kg	304L mat	304L polished	316L mat	316L polished
10	26,0	10,0	13,0	26,0		0,010	04034001R2	04634001R2	04038001R2	04638001R2
15	35,0	16,0	19,0	35,0		0,030	04034002R2	04634002R2	04038002R2	04638002R2
20	40,0	20,0	23,0	40,0		0,040	04034003R2	04634003R2	04038003R2	04638003R2
25	50,0	26,0	29,0	50,0		0,050	04034005R2	04634005R2	04038005R2	04638005R2
32	55,0	32,0	35,0	55,0		0,080	04034007R2	04634007R2	04038007R2	04638007R2
40	60,0	38,0	41,0	60,0		0,100	04034009R2	04634009R2	04038009R2	04638009R2
50	70,0	50,0	53,0	70,0		0,170	04034011R2	04634011R2	04038011R2	04638011R2
65	80,0	66,0	70,0	80,0		0,350	04034013	04634013	04038013	04638013
80	90,0	81,0	85,0	90,0		0,540	04034015	04634015	04038015	04638015
100	100,0	100,0	104,0	100,0		0,730	04034017	04634017	04038017	04638017
125	187,5	125,0	129,0	187,5		1,780	04034019	04634019	04038019	04638019
150	225,0	150,0	154,0	225,0		2,680	04034020	04634020	04038020	04638020
200	300,0	200,0	204,0	300,0		4,720	04034021	04634021	04038021	04638021

BEND 90° BS ANNEALED "OLD DIN RANGE"

DN	A	B	C	D	E	Kg	304L mat	304L polished	316L mat	316L polished
10	26,0	9,0	12,0	26,0		0,010	04034001	04634001	04038001	04638001
15	35,0	15,0	18,0	35,0		0,030	04034002	04634002	04038002	04638002
20	40,0	19,0	22,0	40,0		0,040	04034003	04634003	04038003	04638003
25	50,0	25,0	28,0	50,0		0,070	04034005	04634005	04038005	04638005
32	55,0	31,0	34,0	55,0		0,100	04034007	04634007	04038007	04638007
40	60,0	37,0	40,0	60,0		0,130	04034009	04634009	04038009	04638009
50	70,0	49,0	52,0	70,0		0,200	04034011	04634011	04038011	04638011