

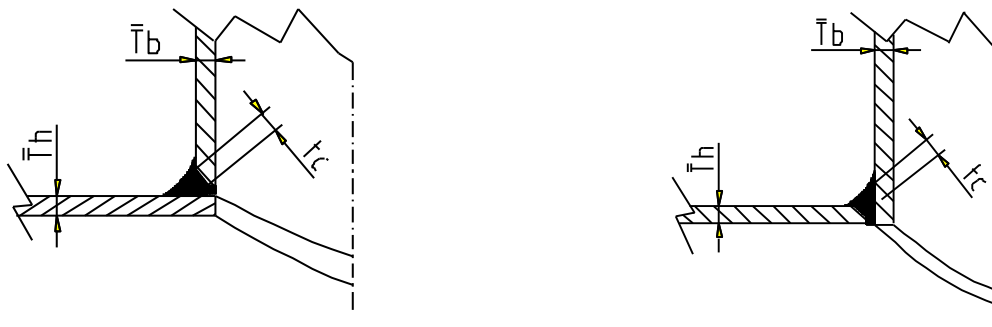
Title: **PIPING CLASS EDMESTON SX**

Approved by:

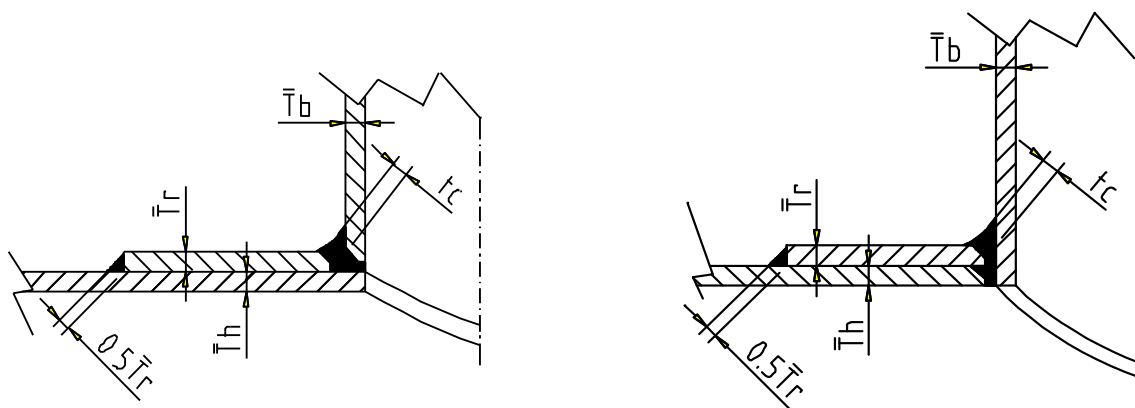
Subject: **WELDING BRANCH CONNECTIONS**

AHD

Branch connections (including integrally reinforced proprietary branch connection fittings) which abut the outside of the run or which are inserted in an opening in the run shall be attached by fully penetrated groove welds. The welds shall be finished with cover fillet welds having a throat dimension not less than t_c . The dimension, t_c , to be $0.7T_b$.



If a reinforcing pad or saddle shall be attached to the main pipe, it shall be performed by either, a fully penetrated groove weld finished with a cover fillet weld having a throat dimension not less than t_c , or a fillet weld having a throat dimension not less than $0.7 t_{min}$. The outer edge of a reinforcing pad or saddle shall be attached to the run pipe by a fillet weld having a throat dimension not less than $0.5 T_r$.



Reinforcing pads and saddles shall have a good fit with the parts to which they are attached. A vent hole shall be provided at the side (not at the crotch) of any pad or saddle to reveal leakage in the weld between branch and run and to allow venting during welding and heat treatment. A pad or saddle may be made in more than one piece if joints between pieces have strength equivalent to pad or saddle parent metal, and if each piece has a vent hole.