

SECTION 15520 - STEAM AND CONDENSATE HEATING PIPING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes the following for LP steam and condensate piping:
 1. Pipe and fittings.
 2. Strainers.
 3. Flash tanks.
 4. Safety valves.
 5. Pressure-reducing valves.
 6. Steam traps.
 7. Thermostatic air vents and vacuum breakers.

1.3 DEFINITIONS

- A. HP Systems: High-pressure piping operating at more than 15 psig (104 kPa) as required by ASME B31.1.
- B. LP Systems: Low-pressure piping operating at 15 psig (104 kPa) or less as required by ASME B31.9.

1.4 PERFORMANCE REQUIREMENTS

- A. Components and installation shall be capable of withstanding the following minimum working pressures and temperatures:
 1. HP Steam Piping: 60 psig (414kPa).
 2. LP Steam Piping: 7 psig (48kPa).
 3. Condensate Piping: 60 psig (414kPa) at 250 deg F (121 deg C).
 4. Makeup-Water Piping: 80 psig (552 kPa) at 150 deg F (66 deg C).
 5. Blowdown-Drain Piping: Equal to pressure of the piping system to which it is attached.
 6. Air-Vent and Vacuum-Breaker Piping: Equal to pressure of the piping system to which it is attached.
 7. Safety-Valve-Inlet and -Outlet Piping: Equal to pressure of the piping system to which it is attached.

1.5 SUBMITTALS

- A. Product Data: For each type of the following:
 1. Pressure-reducing and safety valve.
 2. Steam trap.
 3. Air vent and vacuum breaker.
 4. Flash tank.

- B. Shop Drawings: Detail, 1/4 inch equals 1 foot (1:50) scale, flash tank assemblies and fabrication of pipe anchors, hangers, pipe, multiple pipes, alignment guides, and expansion joints and loops and their attachment to the building structure. Detail locations of anchors, alignment guides, and expansion joints and loops.
- C. Qualification Data: For Installer.
- D. Welding certificates.
- E. Field quality-control test reports.
- F. Operation and Maintenance Data: For valves, safety valves, pressure-reducing valves, steam traps, air vents, and vacuum breakers to include in emergency, operation, and maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Steel Support Welding: Qualify processes and operators according to AWS D1.1, "Structural Welding Code - Steel."
- B. Pipe Welding: Qualify processes and operators according to the following:
 1. Comply with provisions in ASME B31 Series, "Code for Pressure Piping."
 2. Certify that each welder has passed AWS qualification tests for welding processes involved and that certification is current.
- C. ASME Compliance: Comply with ASME B31.1, "Power Piping" and ASME B31.9, "Building Services Piping" for materials, products, and installation. Safety valves and pressure vessels shall bear the appropriate ASME label. Fabricate and stamp flash tanks to comply with ASME Boiler and Pressure Vessel Code: Section VIII, Division 1.

PART 2 - PRODUCTS

2.1 COPPER TUBE AND FITTINGS

- A. Drawn-Temper Copper Tubing: ASTM B 88, Type L (ASTM B 88M, Type B).
- B. Annealed-Temper Copper Tubing: ASTM B 88, Type K (ASTM B 88M, Type A).
- C. Wrought-Copper Fittings and Unions: ASME B16.22.

2.2 STEEL PIPE AND FITTINGS

- A. Steel Pipe: ASTM A 53/A 53M, black steel, plain ends, Type, Grade, and Schedule as indicated in Part 3 piping applications articles.
- B. Cast-Iron Threaded Fittings: ASME B16.4; Classes 125, 150, and 300 as indicated in Part 3 piping applications articles.
- C. Malleable-Iron Threaded Fittings: ASME B16.3; Classes 150 and 300 as indicated in Part 3 piping applications articles.

- D. Malleable-Iron Unions: ASME B16.39; Classes 150, 250, and 300 as indicated in Part 3 piping applications articles.
- E. Cast-Iron Threaded Flanges and Flanged Fittings: ASME B16.1, Classes 125 and 250 as indicated in Part 3 piping applications articles; raised ground face, and bolt holes spot faced.
- F. Wrought-Steel Fittings: ASTM A 234/A 234M, wall thickness to match adjoining pipe.
- G. Wrought-Steel Flanges and Flanged Fittings: ASME B16.5, including bolts, nuts, and gaskets of the following material group, end connections, and facings:
 - 1. Material Group: 1.1.
 - 2. End Connections: Butt welding.
 - 3. Facings: Raised face.
- H. Steel Pipe Nipples: ASTM A 733, made of ASTM A 53/A 53M, black steel of same Type, Grade, and Schedule as pipe in which installed.
- I. Stainless-Steel Bellows, Flexible Connectors:
 - 1. Body: Stainless-steel bellows with woven, flexible, bronze, wire-reinforced, protective jacket.
 - 2. End Connections: Threaded or flanged to match equipment connected.
 - 3. Performance: Capable of 3/4-inch (20-mm) misalignment.
 - 4. CWP Rating: 150-psig (1035-kPa).
 - 5. Maximum Operating Temperature: 250 deg F (121 deg C).

2.3 JOINING MATERIALS

- A. Pipe-Flange Gasket Materials: Suitable for chemical and thermal conditions of piping system contents.
 - 1. ASME B16.21, nonmetallic, flat, asbestos free, 1/8-inch (3.2-mm) maximum thickness unless thickness or specific material is indicated.
 - a. Full-Face Type: For flat-face, Class 125, cast-iron and cast-bronze flanges.
 - b. Narrow-Face Type: For raised-face, Class 250, cast-iron and steel flanges.
- B. Flange Bolts and Nuts: ASME B18.2.1, carbon steel, unless otherwise indicated.
- C. Solder Filler Metals: ASTM B 32, lead-free alloys. Include water-flushable flux according to ASTM B 813.
- D. Brazing Filler Metals: AWS A5.8, BCuP Series, copper-phosphorus alloys for joining copper with copper; or BAg-1, silver alloy for joining copper with bronze or steel.
- E. Welding Filler Metals: Comply with AWS D10.12 (AWS D10.12M) for welding materials appropriate for wall thickness and chemical analysis of steel pipe being welded.
- F. Welding Materials: Comply with Section II, Part C, of ASME Boiler and Pressure Vessel Code for welding materials appropriate for wall thickness and for chemical analysis of pipe being welded.

2.4 DIELECTRIC FITTINGS

- A. Description: Combination fitting of copper alloy and ferrous materials with threaded, solder-joint, plain, or weld-neck end connections that match piping system materials.
- B. Insulating Material: Suitable for system fluid, pressure, and temperature.
- C. Dielectric Unions:
 - 1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Capitol Manufacturing Company.
 - b. Central Plastics Company.
 - c. Hart Industries, International Inc.
 - d. Watts Water Technologies, Inc.
 - e. Zurn Plumbing Products Group.
 - 2. Factory-fabricated union assembly, for **250-psig (1725-kPa)** minimum working pressure at **180 deg F (82 deg C)**.
- D. Dielectric Flanges:
 - 1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Capitol Manufacturing Company.
 - b. Central Plastics Company.
 - c. Watts Water Technologies, Inc..
 - 2. Factory-fabricated companion-flange assembly, for **150- or 300-psig (1035- or 2070-kPa)** minimum working pressure as required to suit system pressures.
- E. Dielectric-Flange Kits:
 - 1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Advance Products & Systems, Inc.
 - b. Calpico, Inc.
 - c. Central Plastics Company.
 - d. Pipeline Seal and Insulator, Inc.
 - 2. Companion-flange assembly for field assembly. Include flanges, full-face- or ring-type neoprene or phenolic gasket, phenolic or polyethylene bolt sleeves, phenolic washers, and steel backing washers.
 - 3. Separate companion flanges and steel bolts and nuts shall have **150- or 300-psig (1035- or 2070-kPa)** minimum working pressure as required to suit system pressures.

2.5 VALVES

- A. Gate, Globe, Check, and Ball Valves: Comply with requirements specified in Division 15 Section "General-Duty Valves for HVAC Piping."

- B. Stop-Check Valves:
1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Crane Co.
 - b. Jenkins Valves; a Crane Company.
 - c. Lunkenheimer Valves.
 - d. A.Y. McDonald Mfg. Co.
 2. Body and Bonnet: Malleable iron.
 3. End Connections: Flanged.
 4. Disc: Cylindrical with removable liner and machined seat.
 5. Stem: Brass alloy.
 6. Operator: Outside screw and yoke with cast-iron handwheel.
 7. Packing: Polytetrafluoroethylene-impregnated packing with two-piece packing gland assembly.
 8. Pressure Class: 250.

2.6 STRAINERS

- A. Y-Pattern Strainers:
1. Body: ASTM A 126, Class B cast iron, with bolted cover and bottom drain connection.
 2. End Connections: Threaded ends for strainers NPS 2 (DN 50) and smaller; flanged ends for strainers NPS 2-1/2 (DN 65) and larger.
 3. Strainer Screen: Stainless-steel, 20 mesh strainer, and perforated stainless-steel basket with 50 percent free area.
 4. Tapped blowoff plug.
 5. CWP Rating: 250-psig (1725-kPa) working steam pressure.
- B. Basket Strainers:
1. Body: ASTM A 126, Class B cast iron, with bolted cover and bottom drain connection.
 2. End Connections: Threaded ends for strainers NPS 2 (DN 50) and smaller; flanged ends for strainers NPS 2-1/2 (DN 65) and larger.
 3. Strainer Screen: Stainless-steel, 20 mesh strainer, and perforated stainless-steel basket with 50 percent free area.
 4. CWP Rating: 250-psig (1725-kPa) working steam pressure.

2.7 SAFETY VALVES

- A. Bronze or Brass Safety Valves:
1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Armstrong International, Inc.
 - b. Kunkle Valve; a Tyco International Ltd. Company.
 - c. Spirax Sarco, Inc.
 - d. Watts Water Technologies, Inc.
 2. Disc Material: Forged copper alloy.
 3. End Connections: Threaded inlet and outlet.
 4. Spring: Fully enclosed steel spring with adjustable pressure range and positive shutoff, factory set and sealed.
 5. Pressure Class: 250.

6. Drip-Pan Elbow: Cast iron and having threaded inlet and outlet with threads complying with ASME B1.20.1.
7. Size and Capacity: As required for equipment according to ASME Boiler and Pressure Vessel Code.

B. Cast-Iron Safety Valves:

1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Armstrong International, Inc.
 - b. Kunkle Valve; a Tyco International Ltd. Company.
 - c. Spirax Sarco, Inc.
 - d. Watts Water Technologies, Inc.
2. Disc Material: Forged copper alloy with bronze nozzle.
3. End Connections: Raised-face flanged inlet and threaded or flanged outlet connections.
4. Spring: Fully enclosed cadmium-plated steel spring with adjustable pressure range and positive shutoff, factory set and sealed.
5. Pressure Class: 250.
6. Drip-Pan Elbow: Cast iron and having threaded inlet, outlet, and drain, with threads complying with ASME B1.20.1.
7. Exhaust Head: Cast iron and having threaded inlet and drain, with threads complying with ASME B1.20.1.
8. Size and Capacity: As required for equipment according to ASME Boiler and Pressure Vessel Code.

2.8 STEAM TRAPS

A. Thermostatic Traps:

1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Armstrong International, Inc.
 - b. Barnes & Jones, Inc.
 - c. Dunham-Bush, Inc.
 - d. Hoffman Specialty; Division of ITT Industries.
 - e. Spirax Sarco, Inc.
 - f. Sterling.
2. Body: Bronze angle-pattern body with integral union tailpiece and screw-in cap.
3. Trap Type: Balanced-pressure.
4. Bellows: Stainless steel or monel.
5. Head and Seat: Replaceable, hardened stainless steel.
6. Pressure Class: 125.

B. Float and Thermostatic Traps:

1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Armstrong International, Inc.
 - b. Barnes & Jones, Inc.
 - c. Dunham-Bush, Inc.
 - d. Hoffman Specialty; Division of ITT Industries.

- e. Spirax Sarco, Inc.
- f. Sterling.
- 2. Body and Bolted Cap: ASTM A 126, cast iron.
- 3. End Connections: Threaded.
- 4. Float Mechanism: Replaceable, stainless steel.
- 5. Head and Seat: Hardened stainless steel.
- 6. Trap Type: Balanced pressure.
- 7. Thermostatic Bellows: Stainless steel or monel.
- 8. Thermostatic air vent capable of withstanding 45 deg F (25 deg C) of superheat and resisting water hammer without sustaining damage.
- 9. Vacuum Breaker: Thermostatic with phosphor bronze bellows, and stainless steel cage, valve, and seat.
- 10. Maximum Operating Pressure: 125 psig (860 kPa).

C. Inverted Bucket Traps:

- 1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Armstrong International, Inc.
 - b. Barnes & Jones, Inc.
 - c. Dunham-Bush, Inc.
 - d. Hoffman Specialty; Division of ITT Industries.
 - e. Spirax Sarco, Inc.
 - f. Sterling.
- 2. Body and Cap: Cast iron.
- 3. End Connections: Threaded.
- 4. Head and Seat: Stainless steel.
- 5. Valve Retainer, Lever, and Guide Pin Assembly: Stainless steel.
- 6. Bucket: Brass or stainless steel.
- 7. Strainer: Integral stainless-steel inlet strainer within the trap body.
- 8. Air Vent: Stainless-steel thermostatic vent.
- 9. Pressure Rating: 250 psig (1725 kPa).

2.9 THERMOSTATIC AIR VENTS AND VACUUM BREAKERS

A. Thermostatic Air Vents:

- 1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Armstrong International, Inc.
 - b. Barnes & Jones, Inc.
 - c. Dunham-Bush, Inc.
 - d. Hoffman Specialty; Division of ITT Industries.
 - e. Spirax Sarco, Inc.
 - f. Sterling.
- 2. Body: Cast iron, bronze or stainless steel.
- 3. End Connections: Threaded.
- 4. Float, Valve, and Seat: Stainless steel.
- 5. Thermostatic Element: Phosphor bronze bellows in a stainless-steel cage.
- 6. Pressure Rating: 125 psig (861 kPa).
- 7. Maximum Temperature Rating: 350 deg F (177 deg C).

- B. Vacuum Breakers:
1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Armstrong International, Inc.
 - b. Dunham-Bush, Inc.
 - c. Hoffman Specialty; Division of ITT Industries.
 - d. Johnson Corporation (The).
 - e. Spirax Sarco, Inc.
 2. Body: Cast iron, bronze, or stainless steel.
 3. End Connections: Threaded.
 4. Sealing Ball, Retainer, Spring, and Screen: Stainless steel.
 5. O-ring Seal: EPR.
 6. Pressure Rating: 125 psig (861 kPa).
 7. Maximum Temperature Rating: 350 deg F (177 deg C).

PART 3 - EXECUTION

3.1 LP STEAM PIPING APPLICATIONS

- A. LP Steam Piping, NPS 2 (DN 50) and Smaller: Schedule 40, Type S, Grade B, steel pipe; Class 125 cast-iron fittings; and threaded joints.
- B. LP Steam Piping, NPS 2-1/2 through NPS 12 (DN 65 through DN 300): Schedule 40, Type E, Grade B, steel pipe; Class 150 wrought-steel fittings, flanges, and flange fittings; and welded and flanged joints.
- C. Condensate piping above grade, NPS 2 (DN 50) and smaller, shall be the following:
 1. Schedule 80, Type S, Grade B, steel pipe; Class 125 cast-iron fittings; and threaded joints.
- D. Condensate piping above grade, NPS 2-1/2 (DN 65) and larger, shall be the following:
 1. Schedule 80, Type E, Grade B, steel pipe; Class 150 wrought-steel fittings, flanges, and flange fittings; and welded and flanged joints.

3.2 HP STEAM PIPING APPLICATIONS

- A. HP Steam Piping, NPS 2 (DN 50) and Smaller: Schedule 40, Type S, Grade B, steel pipe; Class 125 cast-iron fittings; and threaded joints.
- B. HP Steam Piping, NPS 2-1/2 through NPS 12 (DN 65 through DN 300): Schedule 40, Type E, Grade B, steel pipe; Class 150 wrought-steel fittings, flanges, and flange fittings; and welded and flanged joints.

3.3 ANCILLARY PIPING APPLICATIONS

- A. Makeup-water piping installed above grade shall be the following:
 1. Drawn-temper copper tubing, wrought-copper fittings, and soldered joints.

- B. Blowdown-Drain Piping: Same materials and joining methods as for piping specified for the service in which blowdown drain is installed.
- C. Air-Vent Piping:
 1. Inlet: Same as service where installed.
 2. Outlet: Type **K (A)** annealed-temper copper tubing with soldered or flared joints.
- D. Vacuum-Breaker Piping: Outlet, same as service where installed.
- E. Safety-Valve-Inlet and -Outlet Piping: Same materials and joining methods as for piping specified for the service in which safety valve is installed.

3.4 VALVE APPLICATIONS

- A. Install shutoff duty valves at branch connections to steam supply mains, at steam supply connections to equipment, and at the outlet of steam traps.
- B. Install safety valves on pressure-reducing stations and elsewhere as required by ASME Boiler and Pressure Vessel Code. Install safety-valve discharge piping, without valves, to nearest floor drain or as indicated on Drawings. Comply with ASME Boiler and Pressure Vessel Code: Section VIII, Division 1, for installation requirements.

3.5 PIPING INSTALLATION

- A. Drawing plans, schematics, and diagrams indicate general location and arrangement of piping systems. Use indicated piping locations and arrangements if such were used to size pipe and calculate friction loss, expansion, and other design considerations. Install piping as indicated unless deviations to layout are approved on Coordination Drawings.
- B. Install piping in concealed locations, unless otherwise indicated and except in equipment rooms and service areas.
- C. Install piping indicated to be exposed and piping in equipment rooms and service areas at right angles or parallel to building walls. Diagonal runs are prohibited unless specifically indicated otherwise.
- D. Install piping above accessible ceilings to allow sufficient space for ceiling panel removal.
- E. Install piping to permit valve servicing.
- F. Install piping free of sags and bends.
- G. Install fittings for changes in direction and branch connections.
- H. Install piping to allow application of insulation.
- I. Select system components with pressure rating equal to or greater than system operating pressure.
- J. Install groups of pipes parallel to each other, spaced to permit applying insulation and servicing of valves.

- K. Install drains, consisting of a tee fitting, NPS 3/4 (DN 20) full port-ball valve, and short NPS 3/4 (DN 20) threaded nipple with cap, at low points in piping system mains and elsewhere as required for system drainage.
- L. Install steam supply piping at a minimum uniform grade of 0.2 percent downward in direction of steam flow.
- M. Install condensate return piping at a minimum uniform grade of 0.4 percent downward in direction of condensate flow.
- N. Reduce pipe sizes using eccentric reducer fitting installed with level side down.
- O. Install branch connections to mains using tee fittings in main pipe, with the branch connected to top of main pipe.
- P. Install valves according to Division 15 Section "General-Duty Valves for HVAC Piping."
- Q. Install unions in piping, NPS 2 (DN 50) and smaller, adjacent to valves, at final connections of equipment, and elsewhere as indicated.
- R. Install flanges in piping, NPS 2-1/2 (DN 65) and larger, at final connections of equipment and elsewhere as indicated.
- S. Install strainers on supply side of control valves, pressure-reducing valves, traps, and elsewhere as indicated. Install NPS 3/4 (DN 20) nipple and full port ball valve in blowdown connection of strainers NPS 2 (DN 50) and larger. Match size of strainer blowoff connection for strainers smaller than NPS 2 (DN 50).
- T. Install expansion loops, expansion joints, anchors, and pipe alignment guides as specified in Division 15 Section "Expansion Fittings and Loops for HVAC Piping."
- U. Identify piping as specified in Division 15 Section "Identification for HVAC Piping and Equipment."
- V. Install drip legs at low points and natural drainage points such as ends of mains, bottoms of risers, and ahead of pressure regulators, and control valves.
 1. On straight runs with no natural drainage points, install drip legs at intervals not exceeding 300 feet (90 m).
 2. Size drip legs same size as main. In steam mains NPS 6 (DN 150) and larger, drip leg size can be reduced, but to no less than NPS 4 (DN 100).
 3. Install full-port ball valve, and swing check valve on condensate outlet.

3.6 STEAM-TRAP INSTALLATION

- A. Install steam traps in accessible locations as close as possible to connected equipment.
- B. Install full-port ball valve, strainer, and union upstream from trap; install union, check valve, and full-port ball valve downstream from trap unless otherwise indicated.

3.7 SAFETY VALVE INSTALLATION

- A. Install safety valves according to ASME B31.1, "Power Piping" and ASME B31.9, "Building Services Piping."
- B. Pipe safety-valve discharge without valves to atmosphere outside the building.
- C. Install drip-pan elbow fitting adjacent to safety valve and pipe drain connection to nearest floor drain.
- D. Install exhaust head with drain to waste, on vents equal to or larger than **NPS 2-1/2 (DN 65)**.

3.8 HANGERS AND SUPPORTS

- A. Install hangers and supports according to Division 15 Section "Hangers and Supports for HVAC Piping and Equipment." Comply with requirements below for maximum spacing.
- B. Install the following pipe attachments:
 - 1. Adjustable steel clevis hangers for individual horizontal piping less than **20 feet (6 m)** long.
 - 2. Adjustable roller hangers and spring hangers for individual horizontal piping **20 feet (6 m)** or longer.
 - 3. Pipe Roller: MSS SP-58, Type 44 for multiple horizontal piping **20 feet (6 m)** or longer, supported on a trapeze.
 - 4. Spring hangers to support vertical runs.
- C. Install hangers with the following maximum spacing and minimum rod sizes:
 - 1. **NPS 3/4 (DN 20)**: Maximum span, **9 feet (2.7 m)**; minimum rod size, **1/4 inch (6.4 mm)**.
 - 2. **NPS 1 (DN 25)**: Maximum span, **9 feet (2.7 m)**; minimum rod size, **1/4 inch (6.4 mm)**.
 - 3. **NPS 1-1/2 (DN 40)**: Maximum span, **12 feet (3.7 m)**; minimum rod size, **3/8 inch (10 mm)**.
 - 4. **NPS 2 (DN 50)**: Maximum span, **13 feet (4 m)**; minimum rod size, **3/8 inch (10 mm)**.
 - 5. **NPS 2-1/2 (DN 65)**: Maximum span, **14 feet (4.3 m)**; minimum rod size, **3/8 inch (10 mm)**.
 - 6. **NPS 3 (DN 80)**: Maximum span, **15 feet (4.6 m)**; minimum rod size, **3/8 inch (10 mm)**.
 - 7. **NPS 4 (DN 100)**: Maximum span, **17 feet (5.2 m)**; minimum rod size, **1/2 inch (13 mm)**.
 - 8. **NPS 6 (DN 150)**: Maximum span, **21 feet (6.4 m)**; minimum rod size, **1/2 inch (13 mm)**.
 - 9. **NPS 8 (DN 200)**: Maximum span, **24 feet (7.3 m)**; minimum rod size, **5/8 inch (16 mm)**.
- D. Install hangers for drawn-temper copper piping with the following maximum spacing and minimum rod sizes:
 - 1. **NPS 1/2 (DN 15)**: Maximum span, **4 feet (1.2 m)**; minimum rod size, **1/4 inch (6.4 mm)**.
 - 2. **NPS 3/4 (DN 20)**: Maximum span, **5 feet (1.5 m)**; minimum rod size, **1/4 inch (6.4 mm)**.
 - 3. **NPS 1 (DN 25)**: Maximum span, **6 feet (1.8 m)**; minimum rod size, **1/4 inch (6.4 mm)**.
 - 4. **NPS 1-1/2 (DN 40)**: Maximum span, **8 feet (2.4 m)**; minimum rod size, **3/8 inch (10 mm)**.
 - 5. **NPS 2 (DN 50)**: Maximum span, **8 feet (2.4 m)**; minimum rod size, **3/8 inch (10 mm)**.
 - 6. **NPS 2-1/2 (DN 65)**: Maximum span, **9 feet (2.7 m)**; minimum rod size, **3/8 inch (10 mm)**.
 - 7. **NPS 3 (DN 80)**: Maximum span, **10 feet (3 m)**; minimum rod size, **3/8 inch (10 mm)**.

- E. Support vertical runs at roof, at each floor, and at 10-foot (3-m) intervals between floors.

3.9 PIPE JOINT CONSTRUCTION

- A. Join pipe and fittings according to the following requirements and Division 15 Sections specifying piping systems.
- B. Ream ends of pipes and tubes and remove burrs. Bevel plain ends of steel pipe.
- C. Remove scale, slag, dirt, and debris from inside and outside of pipe and fittings before assembly.
- D. Soldered Joints: Apply ASTM B 813, water-flushable flux, unless otherwise indicated, to tube ends. Construct joints according to ASTM B 828 or CDA's "Copper Tube Handbook," using lead-free solder alloy complying with ASTM B 32.
- E. Brazed Joints: Construct joints according to AWS's "Brazing Handbook," "Pipe and Tube" chapter, using copper-phosphorus brazing filler metal complying with AWS A5.8.
- F. Threaded Joints: Thread pipe with tapered pipe threads according to ASME B1.20.1. Cut threads full and clean using sharp dies. Ream threaded pipe ends to remove burrs and restore full ID. Join pipe fittings and valves as follows:
 - 1. Apply appropriate tape or thread compound to external pipe threads unless dry seal threading is specified.
 - 2. Damaged Threads: Do not use pipe or pipe fittings with threads that are corroded or damaged. Do not use pipe sections that have cracked or open welds.
- G. Welded Joints: Construct joints according to AWS D10.12 (AWS D10.12M), using qualified processes and welding operators according to Part 1 "Quality Assurance" Article.
- H. Flanged Joints: Select appropriate gasket material, size, type, and thickness for service application. Install gasket concentrically positioned. Use suitable lubricants on bolt threads.

3.10 TERMINAL EQUIPMENT CONNECTIONS

- A. Size for supply and return piping connections shall be the same as or larger than equipment connections.
- B. Install traps and control valves in accessible locations close to connected equipment.
- C. Install bypass piping with globe valve around control valve. If parallel control valves are installed, only one bypass is required.
- D. Install vacuum breakers downstream from control valve, close to coil inlet connection.
- E. Install a drip leg at coil outlet.

3.11 FIELD QUALITY CONTROL

- A. Prepare steam and condensate piping according to ASME B31.9, "Building Services Piping," and as follows:

1. Leave joints, including welds, uninsulated and exposed for examination during test.
 2. Provide temporary restraints for expansion joints that cannot sustain reactions due to test pressure. If temporary restraints are impractical, isolate expansion joints from testing.
 3. Flush system with clean water. Clean strainers.
 4. Isolate equipment from piping. If a valve is used to isolate equipment, its closure shall be capable of sealing against test pressure without damage to valve. Install blinds in flanged joints to isolate equipment.
- B. Perform the following tests on steam and condensate piping:
1. Use ambient temperature water as a testing medium unless there is risk of damage due to freezing. Another liquid that is safe for workers and compatible with piping may be used.
 2. Subject piping system to hydrostatic test pressure that is not less than 1.5 times the working pressure. Test pressure shall not exceed maximum pressure for any vessel, pump, valve, or other component in system under test. Verify that stress due to pressure at bottom of vertical runs does not exceed 90 percent of specified minimum yield strength.
 3. After hydrostatic test pressure has been applied for at least 10 minutes, examine piping, joints, and connections for leakage. Eliminate leaks by tightening, repairing, or replacing components and repeat hydrostatic test until there are no leaks.
- C. Prepare written report of testing.

END OF SECTION 15520