

**Межгосударственный стандарт**

**Детали трубопроводов бесшовные приварные  
из углеродистой и низколегированной стали**

**ОТВОДЫ КРУТОИЗОГНУТЫЕ  
ТИПА 3D (R ≈ 1,5 DN)**

**Конструкция**

Издание официальное

Предисловие

1. РАЗРАБОТАН ОАО «Корпорация МОНТАЖСПЕЦСТРОЙ»

ВНЕСЕН Государственным комитетом Российской Федерации по стандартизации и метрологии.

2. ПРИНЯТ Межгосударственным советом по стандартизации, метрологии и сертификации (протокол № 20 от 1 ноября 2001 г.)

За принятие проголосовали:

| Наименование государства   | Наименование национального органа по стандартизации |
|----------------------------|---|
| Азербайджанская Республика | Азгосстандарт                                       |
| Республика Армения         | Армгосстандарт                                      |
| Республика Беларусь        | Госстандарт Республики Беларусь                     |
| Грузия                     | Грузстандарт  |
| Республика Казахстан       | Госстандарт Республики Казахстан                    |
| Кыргызская республика      | Кыргызстандарт                                      |
| Республика Молдова         | Молдовастандарт                                     |
| Российская федерация       | Госстандарт России                                  |
| Туркменистан               | Главгосслужба «Туркменстандартлары»                 |
| Республика Узбекистан      | Узгосстандарт                                       |
| Украина                    | Госстандарт Украины                                 |

3. Стандарт соответствует ИСО 3419-81 «Фитинги и легированной и нелегированной стали приварные встык» в части конструкции отводов.

4. Постановление Государственного комитета Российской Федерации по стандартизации и метрологии от 27 мая 2002 г. № 205-ст межгосударственный стандарт ГОСТ 17375-2001 (ИСО 3419-81) введен в действие непосредственно в качестве государственного стандарта Российской Федерации с 1 января 2003 г.

5. ВЗАМЕН ГОСТ 17375-83

# Межгосударственный стандарт

## Детали трубопроводов бесшовные приварные из углеродистой и низколегированной стали

### ОТВОДЫ КРУТОИЗОГНУТЫЕ ТИПА 3D ( $R \approx 1,5 DN$ )

#### Конструкция

Carbom and low-alloy steel butt-welding fitting/ Sharply curved bends type 3D ( $R \approx 1,5 DN$ )/ Design

Дата введения 2003-01-01

#### 1. Область применения

Настоящий стандарт распространяется на бесшовные приварные отводы из углеродистой и низколегированной стали типа  $R \approx 1,5 DN$  и  $\theta = 90^\circ$  и  $\theta = 180^\circ$ , изготавливаемые из труб методами штамповки или протяжки по рогообразному сердечнику.

Область применения отводов-в соответствии с разделом 1 ГОСТ 17380.

Требования пункта 4.1. и раздела 5 являются обязательными, остальные требования - рекомендуемыми.

#### 2. Нормативные ссылки

В настоящем стандарте использована ссылка на ГОСТ 17380-2001. Детали трубопроводов бесшовные приварные из углеродистой и низколегированной стали. Общие технические условия.

#### 3. Определения, обозначения и сокращения

Термины, их определения, обозначения и сокращения по ГОСТ 17380.

#### 4. Конструкция и размеры

4.1. Конструкция и размеры отводов должны соответствовать указанным на рисунке 1 в таблицах 1 и 2.

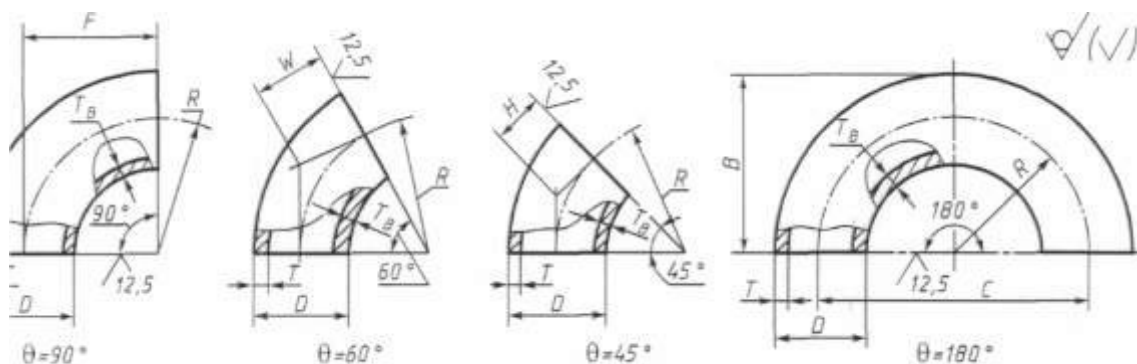


Рисунок 1

## ГОСТ 17375-2001

Таблица 1 – Отводы исполнения 1

Размеры в миллиметрах

| DN  | D     | T    | F = R | H   | C   | B   | Масса, кг,<br>Отвода с $\theta$ |       |        |
|-----|-------|------|-------|-----|-----|-----|---------------------------------|-------|--------|
|     |       |      |       |     |     |     | 45°                             | 90°   | 180°   |
| 15  | 21,3  | 2,0  | 28    | 14  | 56  | 38  | 0,02                            | 0,04  | 0,08   |
|     |       | 3,2  |       |     |     |     | 0,03                            | 0,06  | 0,12   |
|     |       | 4,0  |       |     |     |     | 0,04                            | 0,07  | 0,14   |
| 20  | 26,9  | 2,0  | 29    | 14  | 58  | 43  | 0,03                            | 0,06  | 0,11   |
|     |       | 3,2  |       |     |     |     | 0,04                            | 0,08  | 0,17   |
|     |       | 4,0  |       |     |     |     | 0,06                            | 0,10  | 0,20   |
| 25  | 33,7  | 2,3  | 38    | 18  | 76  | 56  | 0,05                            | 0,11  | 0,21   |
|     |       | 3,2  |       |     |     |     | 0,08                            | 0,16  | 0,23   |
|     |       | 4,5  |       |     |     |     | 0,09                            | 0,19  | 0,38   |
| 32  | 42,4  | 2,6  | 48    | 23  | 96  | 69  | 0,10                            | 0,19  | 0,39   |
|     |       | 3,6  |       |     |     |     | 0,13                            | 0,26  | 0,52   |
|     |       | 5,0  |       |     |     |     | 0,17                            | 0,35  | 0,60   |
| 40  | 48,3  | 2,6  | 57    | 29  | 114 | 82  | 0,13                            | 0,26  | 0,53   |
|     |       | 3,6  |       |     |     |     | 0,18                            | 0,36  | 0,72   |
|     |       | 5,0  |       |     |     |     | 0,24                            | 0,47  | 0,95   |
| 50  | 60,3  | 2,9  | 76    | 35  | 152 | 106 | 0,25                            | 0,50  | 0,99   |
|     |       | 4,0  |       |     |     |     | 0,33                            | 0,67  | 1,30   |
|     |       | 5,6  |       |     |     |     | 0,50                            | 0,89  | 1,80   |
| 65  | 76,1  | 2,9  | 95    | 44  | 190 | 133 | 0,40                            | 0,79  | 1,60   |
|     |       | 5,0  |       |     |     |     | 0,72                            | 1,50  | 2,90   |
|     |       | 7,1  |       |     |     |     | 0,90                            | 1,80  | 3,60   |
| 80  | 88,9  | 3,2  | 114   | 51  | 228 | 159 | 0,60                            | 1,20  | 2,40   |
|     |       | 5,6  |       |     |     |     | 1,00                            | 2,10  | 4,10   |
|     |       | 8,0  |       |     |     |     | 1,40                            | 2,80  | 5,70   |
| 100 | 114,3 | 3,6  | 152   | 64  | 304 | 210 | 1,20                            | 2,40  | 4,70   |
|     |       | 6,3  |       |     |     |     | 2,00                            | 4,00  | 8,00   |
|     |       | 8,8  |       |     |     |     | 2,80                            | 5,40  | 11,00  |
| 125 | 139,7 | 4,0  | 190   | 79  | 380 | 260 | 2,00                            | 4,00  | 8,00   |
|     |       | 6,3  |       |     |     |     | 3,10                            | 6,20  | 12,00  |
|     |       | 10,0 |       |     |     |     | 4,80                            | 9,60  | 19,00  |
| 150 | 168,3 | 4,5  | 229   | 95  | 457 | 313 | 3,20                            | 6,50  | 13,00  |
|     |       | 7,1  |       |     |     |     | 5,10                            | 10,00 | 20,00  |
|     |       | 11,0 |       |     |     |     | 7,70                            | 15,00 | 31,00  |
| 200 | 219,1 | 6,3  | 305   | 127 | 610 | 414 | 8,00                            | 16,00 | 32,00  |
|     |       | 8,0  |       |     |     |     | 9,90                            | 20,00 | 40,00  |
|     |       | 12,5 |       |     |     |     | 14,00                           | 31,00 | 61,00  |
| 250 | 273,0 | 6,3  | 381   | 159 | 762 | 518 | 12,00                           | 25,00 | 50,00  |
|     |       | 10,0 |       |     |     |     | 19,00                           | 39,00 | 78,00  |
| 300 | 323,9 | 7,1  | 457   | 190 | 914 | 619 | 20,00                           | 40,00 | 80,00  |
|     |       | 10,0 |       |     |     |     | 28,00                           | 56,00 | 111,00 |

Окончание таблицы 1

Размеры в миллиметрах

| DN   | D      | T    | F = R | H   | C    | B    | Масса, кг,<br>Отвода с $\theta$ |        |        |
|------|--------|------|-------|-----|------|------|---------------------------------|--------|--------|
|      |        |      |       |     |      |      | 45°                             | 90°    | 180°   |
| 350  | 355,6  | 8,0  | 533   | 222 | 1066 | 711  | 24,00                           | 57,00  | 114,00 |
|      |        | 11,0 |       |     |      |      | 39,00                           | 78,00  | 156,00 |
| 400  | 406,4  | 8,8  | 610   | 254 | 1220 | 813  | 41,00                           | 82,00  | 165,00 |
|      |        | 12,5 |       |     |      |      | 58,00                           | 117,00 | 234,00 |
| 450  | 457,0  | 10,0 | 686   | 286 | 1372 | 914  | 59,00                           | 119,00 | 237,00 |
| 500  | 508,0  | 11,0 | 762   | 318 | 1524 | 1016 | 81,00                           | 126,00 | 323,00 |
| 600  | 610,0  | 12,5 | 914   | 381 | 1828 | 1219 | 133,00                          | 266,00 | 531,00 |
| 700  | 711,0  | -    | 1067  | 444 | 2134 | 1422 | -                               | -      | -      |
| 800  | 813,0  | -    | 1219  | 507 | 2238 | -    | -                               | -      | -      |
| 900  | 914,0  | -    | 1372  | 570 | 2744 | -    | -                               | -      | -      |
| 1000 | 1016,0 | -    | 1524  | 634 | 3048 | -    | -                               | -      | -      |

**П р и м е ч а н и я**

1. Масса приведена для справок.
2. Отводы с  $\theta = 60^\circ$  исполнения 1 не предусматриваются.

Таблица 2 – Отводы исполнения 2

Размеры в миллиметрах

| DN  | D   | T   | F = R | W  | H  | C   | B   | Масса отвода<br>с $\theta = 90^\circ$ , кг |
|-----|-----|-----|-------|----|----|-----|-----|--|
| 25  | 32  | 2,0 | 38    | 22 | 18 | 76  | 56  | 0,1  |
|     |     | 2,5 |       |    |    |     |     | 0,2  |
|     |     | 3,0 |       |    |    |     |     | 0,2  |
|     |     | 3,5 |       |    |    |     |     | 0,2  |
| 32  | 38  | 2,0 | 48    | 28 | 23 | 96  | 69  | 0,2  |
|     |     | 2,5 |       |    |    |     |     | 0,2  |
|     |     | 3,0 |       |    |    |     |     | 0,2  |
|     |     | 3,5 |       |    |    |     |     | 0,3  |
|     |     | 4,0 |       |    |    |     |     | 0,3  |
| 40  | 45  | 2,5 | 60    | 35 | 25 | 120 | 83  | 0,3  |
|     |     | 3,0 |       |    |    |     |     | 0,3  |
|     |     | 3,5 |       |    |    |     |     | 0,4  |
|     |     | 4,0 |       |    |    |     |     | 0,4  |
|     |     | 5,0 |       |    |    |     |     | 0,5  |
| 50  | 57  | 2,5 | 75    | 43 | 80 | 150 | 104 | 0,4  |
|     |     | 3,0 |       |    |    |     |     | 0,5  |
|     |     | 3,5 |       |    |    |     |     | 0,6  |
|     |     | 4,0 |       |    |    |     |     | 0,7  |
|     |     | 4,5 |       |    |    |     |     | 0,7  |
|     |     | 5,0 |       |    |    |     |     | 0,8  |
|     |     | 5,5 |       |    |    |     |     | 0,9  |
| 6,0 | 1,0 |     |       |    |    |     |     |  |

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Продолжение таблицы 2

Размеры в миллиметрах

| DN  | D   | T    | F = R | W   | H  | C   | B    | Масса отвода<br>с $\theta = 90^\circ$ , кг |    |    |     |     |     |
|-----|-----|------|-------|-----|----|-----|------|--|----|----|-----|-----|-----|
| 65  | 76  | 3,0  | 100   | 57  | 41 | 200 | 138  | 0,8  |    |    |     |     |     |
|     |     | 3,5  |       |     |    |     |      | 1,0  |    |    |     |     |     |
|     |     | 4,0  |       |     |    |     |      | 1,1  |    |    |     |     |     |
|     |     | 4,5  |       |     |    |     |      | 1,3  |    |    |     |     |     |
|     |     | 5,0  |       |     |    |     |      | 1,4  |    |    |     |     |     |
|     |     | 5,5  |       |     |    |     |      | 1,6  |    |    |     |     |     |
|     |     | 6,0  |       |     |    |     |      | 1,7  |    |    |     |     |     |
|     |     | 7,0  |       |     |    |     |      | 2,0  |    |    |     |     |     |
|     |     | 8,0  |       |     |    |     |      | 2,2  |    |    |     |     |     |
| 80  | 89  | 3,0  | 120   | 69  | 50 | 240 | 165  | 1,2  |    |    |     |     |     |
|     |     | 3,5  |       |     |    |     |      | 1,4  |    |    |     |     |     |
|     |     | 4,0  |       |     |    |     |      | 1,5  |    |    |     |     |     |
|     |     | 4,5  |       |     |    |     |      | 1,7  |    |    |     |     |     |
|     |     | 5,0  |       |     |    |     |      | 1,9  |    |    |     |     |     |
|     |     | 5,5  |       |     |    |     |      | 2,1  |    |    |     |     |     |
|     |     | 6,0  |       |     |    |     |      | 2,3  |    |    |     |     |     |
|     |     | 7,0  |       |     |    |     |      | 2,7  |    |    |     |     |     |
|     |     | 8,0  |       |     |    |     |      | 3,0  |    |    |     |     |     |
| 100 | 102 | 3,5  | 150   | 87  | 62 | 300 | 201  | 2,1  |    |    |     |     |     |
|     |     | 4,0  |       |     |    |     |      | 2,4  |    |    |     |     |     |
|     |     | 4,5  |       |     |    |     |      | 2,6  |    |    |     |     |     |
|     |     | 5,0  |       |     |    |     |      | 2,9  |    |    |     |     |     |
|     |     | 6,0  |       |     |    |     |      | 3,4  |    |    |     |     |     |
|     |     | 7,0  |       |     |    |     |      | 3,9  |    |    |     |     |     |
|     |     | 8,0  |       |     |    |     |      | 4,5  |    |    |     |     |     |
|     |     | 9,0  |       |     |    |     |      | 5,0  |    |    |     |     |     |
|     |     | 10,0 |       |     |    |     |      | 5,5  |    |    |     |     |     |
|     | 108 | 108  |       |     |    |     | 3,5  | 150  | 87 | 62 | 300 | 204 | 2,2 |
|     |     |      |       |     |    |     | 4,0  |  |    |    |     |     | 2,5 |
|     |     |      |       |     |    |     | 4,5  |  |    |    |     |     | 2,8 |
|     |     |      |       |     |    |     | 5,0  |  |    |    |     |     | 3,1 |
|     |     |      |       |     |    |     | 6,0  |  |    |    |     |     | 3,6 |
|     |     |      |       |     |    |     | 7,0  |  |    |    |     |     | 4,1 |
|     |     |      |       |     |    |     | 8,0  |  |    |    |     |     | 4,7 |
|     |     |      |       |     |    |     | 9,0  |  |    |    |     |     | 5,3 |
|     |     |      |       |     |    |     | 10,0 |  |    |    |     |     | 5,8 |
| 114 | 114 | 3,5  | 150   | 87  | 62 | 300 | 207  | 2,2  |    |    |     |     |     |
|     |     | 4,0  |       |     |    |     |      | 2,6  |    |    |     |     |     |
|     |     | 4,5  |       |     |    |     |      | 2,9  |    |    |     |     |     |
|     |     | 5,0  |       |     |    |     |      | 3,3  |    |    |     |     |     |
|     |     | 6,0  |       |     |    |     |      | 3,8  |    |    |     |     |     |
|     |     | 7,0  |       |     |    |     |      | 4,4  |    |    |     |     |     |
|     |     | 8,0  |       |     |    |     |      | 5,0  |    |    |     |     |     |
|     |     | 9,0  |       |     |    |     |      | 5,7  |    |    |     |     |     |
|     |     | 10,0 |       |     |    |     |      | 6,1  |    |    |     |     |     |
| 125 | 133 | 3,5  | 190   | 110 | 79 | 380 | 257  | 3,3  |    |    |     |     |     |
|     |     | 4,0  |       |     |    |     |      | 3,8  |    |    |     |     |     |
|     |     | 4,5  |       |     |    |     |      | 4,3  |    |    |     |     |     |
|     |     | 5,0  |       |     |    |     |      | 4,8  |    |    |     |     |     |
|     |     | 6,0  |       |     |    |     |      | 5,7  |    |    |     |     |     |
| 7,0 | 6,5 |      |       |     |    |     |      |  |    |    |     |     |     |

Продолжение таблицы 2

Размеры в миллиметрах

| DN   | D    | T    | F = R | W   | H   | C   | B   | Масса отвода<br>с $\theta = 90^\circ$ , кг |      |
|------|------|------|-------|-----|-----|-----|-----|--|------|
| 125  | 133  | 8,0  | 190   | 110 | 79  | 380 | 257 | 7,4  |      |
|      |      | 9,0  |       |     |     |     |     | 8,2  |      |
|      |      | 10,0 |       |     |     |     |     | 9,1  |      |
|      |      | 11,0 |       |     |     |     |     | 10,0                                       |      |
|      |      | 12,0 |       |     |     |     |     | 11,0                                       |      |
| 150  | 159  | 4,0  | 225   | 130 | 93  | 450 | 305 | 5,4  |      |
|      |      | 4,5  |       |     |     |     |     | 6,1  |      |
|      |      | 5,0  |       |     |     |     |     | 6,7  |      |
|      |      | 6,0  |       |     |     |     |     | 8,1  |      |
|      |      | 7,0  |       |     |     |     |     | 9,4  |      |
|      |      | 8,0  |       |     |     |     |     | 11,0                                       |      |
|      |      | 9,0  |       |     |     |     |     | 12,0                                       |      |
|      |      | 10,0 |       |     |     |     |     | 13,0                                       |      |
|      |      | 11,0 |       |     |     |     |     | 14,0                                       |      |
|      |      | 12,0 |       |     |     |     |     | 16,0                                       |      |
|      | 13,0 | 17,0 |       |     |     |     |     |  |      |
|      | 14,0 | 18,0 |       |     |     |     |     |  |      |
|      | 168  |      |       |     |     |     |     | 4,0  | 5,6  |
|      |      |      |       |     |     |     |     | 4,50                                       | 6,4  |
|      |      |      |       |     |     |     |     | 5,0  | 7,1  |
|      |      |      |       |     |     |     |     | 6,0  | 8,5  |
|      |      |      |       |     |     |     |     | 7,0  | 9,8  |
|      |      |      |       |     |     |     |     | 8,0  | 11,2 |
|      |      |      |       |     |     |     |     | 9,0  | 12,5 |
| 10,0 |      |      | 14,0  |     |     |     |     |  |      |
| 11,0 |      |      | 15,0  |     |     |     |     |  |      |
| 12,0 | 16,0 |      |       |     |     |     |     |  |      |
| 13,0 | 17,5 |      |       |     |     |     |     |  |      |
| 14,0 | 19,0 |      |       |     |     |     |     |  |      |
| 200  | 219  | 5,0  | 300   | 173 | 124 | 600 | 410 | 13,0                                       |      |
|      |      | 6,0  |       |     |     |     |     | 15,0                                       |      |
|      |      | 7,0  |       |     |     |     |     | 17,0                                       |      |
|      |      | 8,0  |       |     |     |     |     | 20,0                                       |      |
|      |      | 9,0  |       |     |     |     |     | 22,0                                       |      |
|      |      | 10,0 |       |     |     |     |     | 25,0                                       |      |
|      |      | 11,0 |       |     |     |     |     | 27,0                                       |      |
|      |      | 12,0 |       |     |     |     |     | 29,0                                       |      |
|      |      | 13,0 |       |     |     |     |     | 32,0                                       |      |
|      |      | 14,0 |       |     |     |     |     | 34,0                                       |      |
|      |      | 15,0 |       |     |     |     |     | 37,0                                       |      |
|      |      | 16,0 |       |     |     |     |     | 39,0                                       |      |
|      |      | 17,0 |       |     |     |     |     | 42,0                                       |      |
| 18,0 | 44,0 |      |       |     |     |     |     |  |      |
| 250  | 273  | 6,0  | 375   | 217 | 155 | 750 | 512 | 23,0                                       |      |
|      |      | 7,0  |       |     |     |     |     | 27,0                                       |      |
|      |      | 8,0  |       |     |     |     |     | 31,0                                       |      |
|      |      | 9,0  |       |     |     |     |     | 35,0                                       |      |
|      |      | 10,0 |       |     |     |     |     | 39,0                                       |      |
|      |      | 11,0 |       |     |     |     |     | 43,0                                       |      |
|      |      | 12,0 |       |     |     |     |     | 46,0                                       |      |
|      |      | 13,0 |       |     |     |     |     | 50,0                                       |      |
| 14,0 | 54,0 |      |       |     |     |     |     |  |      |

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Продолжение таблицы 2

Размеры в миллиметрах

| DN   | D     | T    | F = R | W   | H   | C    | B   | Масса отвода<br>с $\theta = 90^\circ$ , кг |
|------|-------|------|-------|-----|-----|------|-----|--|
| 250  | 273   | 15,0 | 375   | 217 | 155 | 750  | 512 | 58,0                                       |
|      |       | 16,0 |       |     |     |      |     | 61,0                                       |
|      |       | 17,0 |       |     |     |      |     | 66,0                                       |
|      |       | 18,0 |       |     |     |      |     | 70,0                                       |
|      |       | 20,0 |       |     |     |      |     | 78,0                                       |
|      |       | 22,0 |       |     |     |      |     | 85,0                                       |
|      |       |      |       |     |     |      |     |  |
| 300  | 325   | 7,0  | 450   | 260 | 186 | 900  | 613 | 39,0                                       |
|      |       | 8,0  |       |     |     |      |     | 45,0                                       |
|      |       | 9,0  |       |     |     |      |     | 50,0                                       |
|      |       | 10,0 |       |     |     |      |     | 56,0                                       |
|      |       | 11,0 |       |     |     |      |     | 61,0                                       |
|      |       | 12,0 |       |     |     |      |     | 66,0                                       |
|      |       | 13,0 |       |     |     |      |     | 72,0                                       |
|      |       | 14,0 |       |     |     |      |     | 77,0                                       |
|      |       | 15,0 |       |     |     |      |     | 82,0                                       |
|      |       | 16,0 |       |     |     |      |     | 87,0                                       |
|      |       | 17,0 |       |     |     |      |     | 92,0                                       |
|      |       | 18,0 |       |     |     |      |     | 96,0                                       |
|      |       | 20,0 |       |     |     |      |     | 107,0                                      |
|      |       | 22,0 |       |     |     |      |     | 118,0                                      |
|      |       | 24,0 |       |     |     |      |     | 130,0                                      |
| 26,0 | 141,0 |      |       |     |     |      |     |  |
| 28,0 | 150,0 |      |       |     |     |      |     |  |
| 350  | 377   | 9,0  | 525   | 303 | 217 | 1050 | 714 | 68,0                                       |
|      |       | 10,0 |       |     |     |      |     | 75,0                                       |
|      |       | 11,0 |       |     |     |      |     | 83,0                                       |
|      |       | 12,0 |       |     |     |      |     | 90,0                                       |
|      |       | 13,0 |       |     |     |      |     | 97,0                                       |
|      |       | 14,0 |       |     |     |      |     | 104,0                                      |
|      |       | 15,0 |       |     |     |      |     | 112,0                                      |
|      |       | 16,0 |       |     |     |      |     | 119,0                                      |
|      |       | 18,0 |       |     |     |      |     | 133,0                                      |
|      |       | 20,0 |       |     |     |      |     | 147,0                                      |
|      |       | 22,0 |       |     |     |      |     | 161,0                                      |
|      |       | 24,0 |       |     |     |      |     | 175,0                                      |
|      |       | 26,0 |       |     |     |      |     | 188,0                                      |
|      |       | 28,0 |       |     |     |      |     | 201,0                                      |
| 30,0 | 214,0 |      |       |     |     |      |     |  |
| 32,0 | 228,0 |      |       |     |     |      |     |  |
| 400  | 426   | 8,0  | 600   | 346 | 248 | 1200 | 813 | 78,0                                       |
|      |       | 9,0  |       |     |     |      |     | 87,0                                       |
|      |       | 10,0 |       |     |     |      |     | 97,0                                       |
|      |       | 11,0 |       |     |     |      |     | 107,0                                      |
|      |       | 12,0 |       |     |     |      |     | 117,0                                      |
|      |       | 13,0 |       |     |     |      |     | 126,0                                      |
|      |       | 14,0 |       |     |     |      |     | 135,0                                      |
|      |       | 15,0 |       |     |     |      |     | 145,0                                      |
|      |       | 16,0 |       |     |     |      |     | 154,0                                      |
|      |       | 17,0 |       |     |     |      |     | 164,0                                      |
|      |       | 18,0 |       |     |     |      |     | 137,0                                      |
|      |       | 20,0 |       |     |     |      |     | 192,0                                      |
|      |       | 22,0 |       |     |     |      |     | 210,0                                      |
| 24,0 | 230,0 |      |       |     |     |      |     |  |



Продолжение таблицы 2

Размеры в миллиметрах

| DN   | D     | T    | F = R | W   | H    | C    | B    | Масса отвода<br>с $\theta = 90^\circ$ , кг |
|------|-------|------|-------|-----|------|------|------|--|
| 400  | 426   | 26,0 | 600   | 346 | 1200 | 1200 | 813  | 249,0                                      |
|      |       | 28,0 |       |     |      |      |      | 268,0                                      |
|      |       | 30,0 |       |     |      |      |      | 286,0                                      |
|      |       | 32,0 |       |     |      |      |      | 309,0                                      |
|      |       | 34,0 |       |     |      |      |      | 324,0                                      |
|      |       |      |       |     |      |      |      |  |
| 500  | 530   | 9,0  | 750   | 433 | 1500 | 1500 | 1015 | 138,0                                      |
|      |       | 10,0 |       |     |      |      |      | 153,0                                      |
|      |       | 11,0 |       |     |      |      |      | 168,0                                      |
|      |       | 12,0 |       |     |      |      |      | 183,0                                      |
|      |       | 13,0 |       |     |      |      |      | 198,0                                      |
|      |       | 14,0 |       |     |      |      |      | 212,0                                      |
|      |       | 15,0 |       |     |      |      |      | 227,0                                      |
|      |       | 16,0 |       |     |      |      |      | 242,0                                      |
|      |       | 17,0 |       |     |      |      |      | 256,0                                      |
|      |       | 18,0 |       |     |      |      |      | 270,0                                      |
|      |       | 20,0 |       |     |      |      |      | 298,0                                      |
|      |       | 22,0 |       |     |      |      |      | 327,0                                      |
|      |       | 24,0 |       |     |      |      |      | 356,0                                      |
|      |       | 26,0 |       |     |      |      |      | 385,0                                      |
|      |       | 28,0 |       |     |      |      |      | 413,0                                      |
|      |       | 30,0 |       |     |      |      |      | 440,0                                      |
| 32,0 | 467,0 |      |       |     |      |      |      |  |
| 34,0 | 494,0 |      |       |     |      |      |      |  |
| 36,0 | 520,0 |      |       |     |      |      |      |  |
| 600  | 630   | 9,0  | 900   | 519 | 1800 | 1800 | 1215 | 198,0                                      |
|      |       | 10,0 |       |     |      |      |      | 219,0                                      |
|      |       | 11,0 |       |     |      |      |      | 245,0                                      |
|      |       | 12,0 |       |     |      |      |      | 261,0                                      |
|      |       | 13,0 |       |     |      |      |      | 282,0                                      |
|      |       | 14,0 |       |     |      |      |      | 302,0                                      |
|      |       | 15,0 |       |     |      |      |      | 324,0                                      |
|      |       | 16,0 |       |     |      |      |      | 345,0                                      |
|      |       | 17,0 |       |     |      |      |      | 366,0                                      |
|      |       | 18,0 |       |     |      |      |      | 387,0                                      |
|      |       | 20,0 |       |     |      |      |      | 429,0                                      |
|      |       | 22,0 |       |     |      |      |      | 471,0                                      |
|      |       | 24,0 |       |     |      |      |      | 513,0                                      |
|      |       | 26,0 |       |     |      |      |      | 554,0                                      |
|      |       | 28,0 |       |     |      |      |      | 595,0                                      |
|      |       | 30,0 |       |     |      |      |      | 636,0                                      |
| 32,0 | 678,0 |      |       |     |      |      |      |  |
| 700  | 720   | 9,0  | 1000  | 577 | 2000 | 2000 | 1360 | 248,0                                      |
|      |       | 10,0 |       |     |      |      |      | 275,0                                      |
|      |       | 11,0 |       |     |      |      |      | 302,0                                      |
|      |       | 12,0 |       |     |      |      |      | 329,0                                      |
|      |       | 13,0 |       |     |      |      |      | 356,0                                      |
|      |       | 14,0 |       |     |      |      |      | 383,0                                      |
|      |       | 15,0 |       |     |      |      |      | 410,0                                      |
|      |       | 16,0 |       |     |      |      |      | 436,0                                      |
|      |       | 17,0 |       |     |      |      |      | 462,0                                      |
|      |       | 18,0 |       |     |      |      |      | 489,0                                      |
|      |       | 20,0 |       |     |      |      |      | 520,0                                      |
|      |       | 22,0 |       |     |      |      |      | 595,0                                      |

Продолжение таблицы 2

Размеры в миллиметрах

| DN   | D      | T    | F = R | W   | H   | C    | B    | Масса отвода<br>с $\theta = 90^\circ$ , кг |
|------|--------|------|-------|-----|-----|------|------|--|
| 700  | 720    | 24,0 | 1000  | 577 | 404 | 2000 | 1360 | 647,0                                      |
|      |        | 26,0 |       |     |     |      |      | 698,0                                      |
|      |        | 28,0 |       |     |     |      |      | 750,0                                      |
|      |        | 30,0 |       |     |     |      |      | 801,0                                      |
|      |        | 32,0 |       |     |     |      |      | 852,0                                      |
| 800  | 820    | 9,0  | 1200  | 693 | 485 | 2400 | 1610 | 339,0                                      |
|      |        | 10,0 |       |     |     |      |      | 376,0                                      |
|      |        | 11,0 |       |     |     |      |      | 413,0                                      |
|      |        | 12,0 |       |     |     |      |      | 450,0                                      |
|      |        | 13,0 |       |     |     |      |      | 487,0                                      |
|      |        | 14,0 |       |     |     |      |      | 524,0                                      |
|      |        | 15,0 |       |     |     |      |      | 561,0                                      |
|      |        | 16,0 |       |     |     |      |      | 598,0                                      |
|      |        | 17,0 |       |     |     |      |      | 636,0                                      |
|      |        | 18,0 |       |     |     |      |      | 670,0                                      |
|      |        | 20,0 |       |     |     |      |      | 743,0                                      |
|      |        | 22,0 |       |     |     |      |      | 815,0                                      |
|      |        | 24,0 |       |     |     |      |      | 887,0                                      |
|      |        | 26,0 |       |     |     |      |      | 959,0                                      |
|      |        | 28,0 |       |     |     |      |      | 1030,0                                     |
| 30,0 | 1101,0 |      |       |     |     |      |      |  |
| 32,0 | 1171,0 |      |       |     |     |      |      |  |

**Примечания**

1 Масса приведена для справок.

2 Масса отводов с  $\theta = 60^\circ$  и  $\theta = 45^\circ$  соответственно в 1,5 и 2 раза меньше, а отводов с  $\theta = 80^\circ$  в 2 раза больше указанной.**Примеры условных обозначений:**- отвода с  $\theta = 90^\circ$ , исполнения 1,  $D = 139,7$  мм,  $T = 4,0$  мм из стали марки TS4:*Отвод 90-1-139,7 • 4-T54 ГОСТ 17375-2001*- отвода с  $\theta = 45^\circ$ , исполнения 2,  $D = 159$  мм,  $T = 4,0$  мм,  $T_B = 6,0$  мм из стали марки 20:*Отвод 45-159 - 4/6 ГОСТ 17375-2001*- отвода с  $\theta = 90^\circ$ , исполнения 2,  $D = 57$  мм,  $T = 5,0$  мм из стали марки 09Г2С:*Отвод 90-57 5-09Г2С ГОСТ 17375-2001*

- то же, для трубопроводов, подконтрольных органам надзора:

*Отвод П90-57 -5-09Г2С ГОСТ 17375-2001*4.2. По согласованию между изготовителем и потребителем (заказчиком) допускается изготовление отводов исполнения 2 с другими размерами и углами  $\theta$ .4.3. Допускается изготовление отводов исполнения 2 с увеличенной толщиной стенки в неторцевых сечениях  $T_B$ .**5 Технические условия**

Технические условия— по ГОСТ 17380.