



Standard Specification for Non-Reinforced Extruded Tee Connections for Piping Applications¹

This standard is issued under the fixed designation F 2014; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers the pipe materials and dimensions for producing non-reinforced extruded tee connections manufactured by mechanical forming processes. The term “extruded tee connection” applies to butt-weld or socket-weld connections. This specification refers to the forming process that leads to welding or brazing.

1.2 The non-reinforced extruded pipe tee connection is an alternative to the tee fittings, nozzle, and other welded connections.

1.3 The non-reinforced extruded pipe tee connection has been widely used for systems in the marine, process piping, food, pharmaceutical, and similar industries.

1.4 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.5 The extruded tee connection will be welded in accordance with Specification F 722. Brazing of tee connections will be in accordance with ANSI B31.5.

2. Referenced Documents

2.1 ASTM Standards:

- A 53/A 53M Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless²
- A 106 Specification for Seamless Carbon Steel Pipe for High-Temperature Service²
- A 135 Specification for Electric-Resistance-Welded Steel Pipe²
- A 139 Specification for Electric-Fusion (Arc)-Welded Steel Pipe (NPS 4 and Over)²
- A 161 Specification for Seamless Low-Carbon and Carbon-Molybdenum Steel Still Tubes for Refinery Service²
- A 178/A 178M Specification for Electric-Resistance-Welded Carbon Steel and Carbon-Manganese Steel Boiler and Superheater Tubes²

A 199/A 199M Standard Specification for Seamless Cold-Drawn Intermediate Alloy-Steel Heat-Exchanger and Condenser Tubes³

A 200 Specification for Seamless Intermediate Alloy-Steel Still Tubes for Refinery Service²

A 209/A 209M Specification for Seamless Carbon-Molybdenum Alloy-Steel Boiler and Superheater Tubes²

A 210/A 210M Specification for Seamless Medium-Carbon Steel Boiler and Superheater Tubes²

A 250/A 250M Specification for Electric-Resistance-Welded Ferritic Alloy-Steel Boiler and Superheater Tubes²

A 252 Specification for Welded and Seamless Steel Pipe Piles²

A 312/A 312M Specification for Seamless and Welded Austenitic Stainless Steel Pipes²

A 333/A 333M Specification for Seamless and Welded Steel Pipe for Low-Temperature Service²

A 334/A 334M Specification for Seamless and Welded Carbon and Alloy-Steel Tubes for Low-Temperature Service²

A 500 Specification for Cold-Formed Welded and Seamless Carbon-Steel Structural Tubing in Rounds and Shapes²

A 512 Specification for Cold-Drawn Buttweld Carbon-Steel Mechanical Tubing²

A 519 Specification for Seamless Carbon and Alloy Steel Mechanical Tubing²

A 587 Specification for Electric-Resistance-Welded Low-Carbon Steel Pipe for the Chemical Industry²

A 589 Specification for Seamless and Welded Carbon-Steel Water-Well Pipe²

A 672 Specification for Electric-Fusion-Welded Steel Pipe for High-Pressure Service at Moderate Temperatures²

B 88 Specification for Seamless Copper Water Tube⁴

B 88M Specification for Seamless Copper Water Tube [Metric]⁴

B 280 Specification for Seamless Copper Tube for Air Conditioning and Refrigeration Field Service⁴

B 337 Specification for Seamless and Welded Titanium and

¹ This specification is under the jurisdiction of ASTM Committee F25 on Ships and Marine Technology and is the direct responsibility of Subcommittee F25.11 on Machinery and Piping Systems.

Current edition approved May 10, 2000. Published September 2000.

² *Annual Book of ASTM Standards*, Vol 01.01.

³ Discontinued; see 1994 *Annual Book of ASTM Standards*, Vol 01.01. Replaced by Specification A 200.

⁴ *Annual Book of ASTM Standards*, Vol 02.01.

