

**SECTION 23 22 13**  
**STEAM AND CONDENSATE HEATING PIPING**

**PART 1 - GENERAL**

**1.1 DESCRIPTION**

- A. Steam, condensate and vent piping inside buildings. Boiler plant and outside steam distribution piping is covered in specification Section 33 63 00, STEAM ENERGY DISTRIBUTION and Section 23 21 11, BOILER PLANT PIPING SYSTEMS.

**1.2 RELATED WORK**

- A. General mechanical requirements and items, which are common to more than one section of Division 23: Section 23 05 11, COMMON WORK RESULTS FOR HVAC AND STEAM GENERATION.
- B. Piping insulation: Section 23 07 11, HVAC, PLUMBING, AND BOILER PLANT INSULATION.

**1.3 QUALITY ASSURANCE**

Section 23 05 11, COMMON WORK RESULTS FOR HVAC AND STEAM GENERATION, which includes welding qualifications.

**1.4 SUBMITTALS**

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Manufacturer's Literature and Data:
  - 1. Pipe and equipment supports.
  - 2. Pipe and tubing, with specification, class or type, and schedule.
  - 3. Pipe fittings, including miscellaneous adapters and special fittings.
  - 4. Flanges, gaskets and bolting.
  - 5. Valves of all types.
  - 6. Strainers.
  - 7. Flexible connectors.
  - 8. Pipe alignment guides.
  - 9. Expansion joints.
  - 10. Expansion compensators.
  - 11. Flexible ball joints: Catalog sheets, performance charts, schematic drawings, specifications and installation instructions.
  - 12. All specified steam system components.
  - 14. Gages.
  - 15. Thermometers and test wells.
  - 16. Electric heat tracing systems.
- C. Coordination Drawings: Refer to Article, SUBMITTALS of Section 23 05 11, COMMON WORK RESULTS FOR HVAC AND STEAM GENERATION.

- D. As-Built Piping Diagrams: Provide drawing as follows for steam and steam condensate piping and other central plant equipment.
1. One wall-mounted stick file for prints. Mount stick file in the chiller plant or adjacent control room along with control diagram stick file.
  2. One set of reproducible drawings.

#### 1.5 APPLICABLE PUBLICATIONS

- A. The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by the basic designation only.
- B. American National Institute Standard (ANSI):
- B1.20.1-01.....Pipe Threads, General Purpose (Inch)
- C. American Society of Mechanical Engineers (ASME):
- B16.1-98.....Cast Iron Pipe Flanges and Flanged Fittings
- B16.3-98.....Malleable Iron Threaded Fittings
- B16.4-98.....Gray Iron Threaded Fittings
- B16.9-01.....Factory-Made Wrought Buttwelding Fittings
- B16.11-02.....Forged Fittings, Socket-Welding and Threaded
- B16.14-91.....Ferrous Pipe Plugs, Bushings, and Locknuts with  
Pipe Threads
- B16.22-98.....Wrought Copper and Copper Alloy Solder-Joint  
Pressure Fittings
- B16.23-92.....Cast Copper Alloy Solder Joint Drainage Fittings
- B16.24-01.....Cast Copper Alloy Pipe Flanges and Flanged  
Fittings, Class 150, 300, 400, 600, 900, 1500  
and 2500
- B16.39-98.....Malleable Iron Threaded Pipe Unions, Classes  
150, 250, and 300
- B31.1-01.....Power Piping
- B31.9-96.....Building Services Piping
- B40.100-98.....Pressure Gauges and Gauge Attachments
- Boiler and Pressure Vessel Code: SEC VIII D1-2001, Pressure Vessels,  
Division 1
- D. American Society for Testing and Materials (ASTM):
- A47-99.....Ferritic Malleable Iron Castings
- A53-01.....Pipe, Steel, Black and Hot-Dipped, Zinc-Coated,  
Welded and Seamless
- A106-99.....Seamless Carbon Steel Pipe for High-Temperature  
Service

- A126-01.....Standard Specification for Gray Iron Castings  
for Valves, Flanges, and Pipe Fittings
- A181-01.....Carbon Steel Forgings, for General-Purpose  
Piping
- A183-98 ..... Carbon Steel Track Bolts and Nuts
- A216-98 ..... Standard Specification for Steel Castings,  
Carbon, Suitable for Fusion Welding, for High  
Temperature Service
- A285-01 ..... Pressure Vessel Plates, Carbon Steel, Low-and-  
Intermediate-Tensile Strength
- A307-00 ..... Carbon Steel Bolts and Studs, 60,000 PSI Tensile  
Strength
- A516-01 ..... Pressure Vessel Plates, Carbon Steel, for  
Moderate-and- Lower Temperature Service
- A536-99 ..... Standard Specification for Ductile Iron Castings
- B32-00 ..... Solder Metal
- B61-93 ..... Steam or Valve Bronze Castings
- B62-93 ..... Composition Bronze or Ounce Metal Castings
- B88-99 ..... Seamless Copper Water Tube
- F439-01 ..... Socket-Type Chlorinated Poly (Vinyl Chloride)  
(CPVC) Plastic Pipe Fittings, Schedule 80
- F441-99 ..... Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic  
Pipe, Schedules 40 and 80
- E. American Welding Society (AWS):
- A5.8-92.....Filler Metals for Brazing and Braze Welding
- B2.1-00.....Welding Procedure and Performance Qualifications
- F. Manufacturers Standardization Society (MSS) of the Valve and Fitting  
Industry, Inc.:
- SP-67-95.....Butterfly Valves
- SP-70-98.....Cast Iron Gate Valves, Flanged and Threaded Ends
- SP-71-97.....Gray Iron Swing Check Valves, Flanged and  
Threaded Ends
- SP-72-99.....Ball Valves with Flanged or Butt-Welding Ends  
for General Service
- SP-78-98.....Cast Iron Plug Valves, Flanged and Threaded Ends
- SP-80-97.....Bronze Gate, Globe, Angle and Check Valves
- SP-85-94.....Cast Iron Globe and Angle Valves, Flanged and  
Threaded Ends

G. Military Specifications (Mil. Spec.):

MIL-S-901D-1989.....Shock Tests, H.I. (High Impact) Shipboard  
Machinery, Equipment, and Systems

H. National Board of Boiler and Pressure Vessel Inspectors (NB): Relieving  
Capacities of Safety Valves and Relief Valves

I. Tubular Exchanger Manufacturers Association: TEMA 18th Edition, 2000

**PART 2 - PRODUCTS**

**2.1 PIPE AND EQUIPMENT SUPPORTS, PIPE SLEEVES, AND WALL AND CEILING PLATES**

Provide in accordance with Section 23 05 11, COMMON WORK RESULTS FOR  
HVAC AND STEAM GENERATION.

**2.2 PIPE AND TUBING**

A. Steam Piping: Steel, ASTM A53, Grade B, seamless or ERW; A106 Grade B,  
Seamless; Schedule 40.

B. Steam Condensate Piping:

1. Concealed above ceiling, in wall or chase: Copper water tube ASTM  
B88, Type K, hard drawn.
2. All other locations: Copper water tube ASTM B88, Type K, hard drawn;  
or steel, ASTM A53, Grade B, Seamless or ERW, or A106 Grade B  
Seamless, Schedule 80.

**2.3 FITTINGS FOR STEEL PIPE**

A. 65 mm (2-1/2 inches) and Larger: Welded or flanged joints. Mechanical  
couplings and fittings are optional for water piping only.

1. Butt welding fittings: ASME B16.9 with same wall thickness as  
connecting piping. Elbows shall be long radius type, unless otherwise  
noted.
2. Welding flanges and bolting: ASME B16.5:
  - a. Steam service: Weld neck or slip-on, raised face, with  
non-asbestos gasket. Non-asbestos gasket shall either be stainless  
steel spiral wound strip with flexible graphite filler or  
compressed inorganic fiber with nitrile binder rated for saturated  
and superheated steam service 750 degrees F and 1500 psi.
  - c. Flange bolting: Carbon steel machine bolts or studs and nuts, ASTM  
A307, Grade B.

B. 50 mm (2 inches) and Smaller: Screwed or welded.

1. Butt welding: ASME B16.9 with same wall thickness as connecting  
piping.
2. Forged steel, socket welding or threaded: ASME B16.11.
3. Screwed: 150 pound malleable iron, ASME B16.3. 125 pound cast iron,  
ASME B16.4, may be used in lieu of malleable iron, except for steam  
and steam condensate piping. Provide 300 pound malleable iron, ASME

B16.3 for steam and steam condensate piping. Cast iron fittings are piping is not acceptable for steam and steam condensate piping.

Bushing reduction of a single pipe size, or use of close nipples, is not acceptable.

4. Unions: ASME B16.39.

5. Steam line drip station and strainer quick-couple blowdown hose connection: Straight through, plug and socket, screw or cam locking type for 15 mm (1/2 inch) ID hose. No integral shut-off is required.

C. Welded Branch and Tap Connections: Forged steel weldolets, or branchlets and thredolets may be used for branch connections up to one pipe size smaller than the main. Forged steel half-couplings, ASME B16.11 may be used for drain, vent and gage connections.

#### **2.4 DIELECTRIC FITTINGS**

A. Provide where copper tubing and ferrous metal pipe are joined.

B. 50 mm (2 inches) and Smaller: Threaded dielectric union, ASME B16.39.

C. 65 mm (2 1/2 inches) and Larger: Flange union with dielectric gasket and bolt sleeves, ASME B16.42.

D. Temperature Rating, 121 degrees C (250 degrees F) for steam condensate and as required for steam service.

#### **2.5 SCREWED JOINTS**

A. Pipe Thread: ANSI B1.20.

B. Lubricant or Sealant: Oil and graphite or other compound approved for the intended service.

#### **2.6 VALVES**

A. Asbestos packing is not acceptable.

B. All valves of the same type shall be products of a single manufacturer. Provide gate and globe valves with packing that can be replaced with the valve under full working pressure.

C. Provide chain operators for valves 100 mm (4 inches) and larger when the centerline is located 2400 mm (8 feet) or more above the floor or operating platform.

D. Gate Valves:

1. 50 mm (2 inches) and smaller: MSS-SP80, Bronze, 1034 kPa (150 lb.), wedge disc, rising stem, union bonnet.

2. 65 mm (2 1/2 inches) and larger: Flanged, outside screw and yoke.

a. High pressure steam 413 kPa (60 psig) and above nominal MPS system): Cast steel body, ASTM A216 grade WCB, 1034 kPa (150 psig) at 260 degrees C (500 degrees F), 11-1/2 to 13 percent chrome stainless steel solid disc and seats. Provide factory installed bypass with globe valve on valves 100 mm (4 inches) and larger.

- b. All other services: MSS-SP 70, iron body, bronze mounted, 861 kPa (125 psig) wedge disc.
- E. Butterfly Valves: May be used in lieu of gate valves in water service except for direct buried pipe. Provide stem extension to allow 50 mm (2 inches) of pipe insulation without interfering with valve operation.
  - 1. MSS-SP 67, flange lug type (for end of line service) or grooved end rated 1205 kPa (175 psig) working pressure at 93 degrees C (200 degrees F).
    - a. Body: Cast iron, ASTM A126, Class B. Malleable iron, ASTM A47 electro-plated, or ductile iron, ASTM A536, Grade 65-45-12 electro-plated.
    - b. Trim: Bronze, aluminum bronze, or 300 series stainless steel disc, bronze bearings, 316 stainless steel shaft and manufacturer's recommended resilient seat. Resilient seat shall be field replaceable, and fully line the body to completely isolate the body from the product. A phosphate coated steel shaft or stem is acceptable, if the stem is completely isolated from the product.
    - c. Actuators: Field interchangeable. Valves for balancing service shall have adjustable memory stop to limit open position.
      - 1) Valves 150 mm (6 inches) and smaller: Lever actuator with minimum of seven locking positions, except where chain wheel is required.
      - 2) Valves 200 mm (8 inches) and larger: Enclosed worm gear with handwheel, and where required, chain-wheel operator.
- H. Manual Radiator/Convactor Valves: Brass, packless, with position indicator.

## **2.7 STRAINERS**

- A. Basket or Y Type. Tee type is acceptable for water service.
- B. High Pressure Steam: Rated 1034 kPa (150 psig) saturated steam.
  - 1. 65 mm (2-1/2 inches) and larger: Flanged cast steel or 1723 kPa (250 psig) cast iron.
  - 2. 50 mm (2 inches) and smaller: Iron, ASTM A116 Grade B, or bronze, ASTM B-62 body with screwed connections (250 psig).
  - 3. Mechanical coupled pipe: Grooved end, ductile iron.
- C. All Other Services: Rated 861 kPa (125 psig) saturated steam.
  - 1. 65 mm (2-1/2 inches) and larger: Flanged, iron body.
  - 2. 50 mm (2 inches) and smaller: Cast iron or bronze.
- D. Screens: Bronze, monel metal or 18-8 stainless steel, free area not less than 2-1/2 times pipe area, with perforations as follows:

1. 75 mm (3 inches) and smaller: 20 mesh for steam and 1.1 mm (0.045 inch) diameter perforations for liquids.
2. 100 mm (4 inches) and larger: 1.1 mm (0.045) inch diameter perforations for steam and 3.2 mm (0.125 inch) diameter perforations for liquids.

## **2.8 STEAM SYSTEM COMPONENTS**

- A. Safety Valves and Accessories: Comply with ASME Boiler and Pressure Vessel Code, Section VIII. Capacities shall be certified by National Board of Boiler and Pressure Vessel Inspectors, maximum accumulation 10 percent. Provide lifting lever. Provide drip pan elbow where shown.
- B. Steam PRV for Individual Equipment: Cast iron or bronze body, screwed ends, rated 861 kPa (125 psig) working pressure. Single-seated, diaphragm operated, spring loaded, adjustable range, all parts renewable.
- C. Steam Trap: Each type of trap shall be the product of a single manufacturer. Provide trap sets at all low points and at 61 m (200 feet) intervals on the horizontal main lines.
  1. Floats and linkages shall provide sufficient force to open trap valve over full operating pressure range available to the system. Unless otherwise indicated on the drawings, traps shall be sized for capacities indicated at minimum pressure drop as follows:
    - a. For equipment with modulating control valve: 1.7 kPa (1/4 psig), based on a condensate leg of 300 mm (12 inches) at the trap inlet and gravity flow to the receiver.
    - b. For main line drip trap sets and other trap sets at steam pressure: Up to 70 percent of design differential pressure. Condensate may be lifted to the return line.
  2. Trap bodies: Bronze, cast iron, or semi-steel, constructed to permit ease of removal and servicing working parts without disturbing connecting piping. For systems without relief valve traps shall be rated for the pressure upstream of the PRV supplying the system.
  3. Balanced pressure thermostatic elements: Phosphor bronze, stainless steel or monel metal.
  4. Valves and seats: Suitable hardened corrosion resistant alloy.
  5. Mechanism: Brass, stainless steel or corrosion resistant alloy.
  6. Floats: Stainless steel.
  7. Inverted bucket traps: Provide bi-metallic thermostatic element for rapid release of non-condensables.
- D. Pressure Powered Condensate Pump: Cast iron body and cover, stainless steel valve mechanism and linkage, bronze body check valves, rated 861

kPa (125 psig) operating pressure, for lifting steam condensate using steam or compressed air pressure.

- E. Thermostatic Air Vent (Steam): Brass or iron body, balanced pressure bellows, stainless steel (renewable) valve and seat, rated 861 kPa (125 psig) working pressure, 20 mm (3/4 inch) screwed connections. Air vents shall be balanced pressure type that responds to steam pressure-temperature curve and vents air at any pressure.
- F. Steam Hose and Accessories: Hose shall be sufficiently flexible to be placed in a 100 mm (4 feet) diameter coil.

## 2.9 GAGES, PRESSURE AND COMPOUND

- A. ASME B40.1, Accuracy Grade 1A, (pressure, vacuum, or compound), initial mid-scale accuracy 1 percent of scale (Qualify grade), metal or phenolic case, 115 mm (4-1/2 inches) in diameter, 6 mm (1/4 inch) NPT bottom connection, white dial with black graduations and pointer, clear glass or acrylic plastic window, suitable for board mounting. Provide red "set hand" to indicate normal working pressure.
- B. Provide brass, lever handle union cock. Provide brass/bronze pressure snubber for gages in water service. Provide brass pigtail syphon for steam gages.
- C. Range of Gages: For services not listed provide range equal to at least 130 percent of normal operating range:

Low pressure steam to 103 kPa(15 psig)	0 to 207 kPa (30 psig).
Medium pressure steam nominal 413 kPa (60 psig)	0 to 689 kPa (100 psig).
High pressure steam nominal 620 kPa to 861 kPa (90 to 125 psig)	0 to 1378 kPa (200 psig).

## 2.10 PRESSURE/TEMPERATURE TEST PROVISIONS

- A. Pete's Plug: 6 mm (1/4 inch) MPT by 75 mm (3 inches) long, brass body and cap, with retained safety cap, nordel self-closing valve cores, permanently installed in piping where shown, or in lieu of pressure gage test connections shown on the drawings.
- B. Provide one each of the following test items to the COR:
  - 1. 6 mm (1/4 inch) FPT by 3 mm (1/8 inch) diameter stainless steel pressure gage adapter probe for extra long test plug. PETE'S 500 XL is an example.



2. 90 mm (3-1/2 inch) diameter, one percent accuracy, compound gage, ,  
762 mm (30 inches) Hg to 689 kPa (100 psig) range.
3. 0 - 104 degrees C (220 degrees F) pocket thermometer one-half degree  
accuracy, 25 mm (one inch) dial, 125 mm (5 inch) long stainless steel  
stem, plastic case.

#### **2.11 FIRESTOPPING MATERIAL**

Refer to Section 23 05 11, COMMON WORK RESULTS FOR HVAC AND STEAM  
GENERATION.

### **PART 3 - EXECUTION**

#### **3.1 GENERAL**

- A. The drawings show the general arrangement of pipe and equipment but do  
not show all required fittings and offsets that may be necessary to  
connect pipes to equipment, fan-coils, coils, radiators, etc., and to  
coordinate with other trades. Provide all necessary fittings, offsets  
and pipe runs based on field measurements and at no additional cost to  
the government. Coordinate with other trades for space available and  
relative location of HVAC equipment and accessories to be connected on  
ceiling grid. Pipe location on the drawings shall be altered by  
contractor where necessary to avoid interferences and clearance  
difficulties.
- B. Store materials to avoid excessive exposure to weather or foreign  
materials. Keep inside of piping relatively clean during installation  
and protect open ends when work is not in progress.
- C. Support piping securely. Refer to PART 3, Section 23 05 11, COMMON WORK  
RESULTS FOR HVAC AND STEAM GENERATION. Install convertors and other heat  
exchangers at height sufficient to provide gravity flow of condensate to  
the flash tank and condensate pump.
- D. Install piping generally parallel to walls and column center lines,  
unless shown otherwise on the drawings. Space piping, including  
insulation, to provide 25 mm (one inch) minimum clearance between  
adjacent piping or other surface. Unless shown otherwise, slope steam,  
condensate and drain piping down in the direction of flow not less than  
25 mm (one inch) in 12 m (40 feet). Provide eccentric reducers to keep  
bottom of sloped piping flat.
- E. Locate and orient valves to permit proper operation and access for  
maintenance of packing, seat and disc. Generally locate valve stems in  
overhead piping in horizontal position. Provide a union adjacent to one  
end of all threaded end valves. Control valves usually require reducers  
to connect to pipe sizes shown on the drawing. Install butterfly valves

with the valve open as recommended by the manufacturer to prevent binding of the disc in the seat.

- F. Offset equipment connections to allow valving off for maintenance and repair with minimal removal of piping. Provide flexibility in equipment connections and branch line take-offs with 3-elbow swing joints where noted on the drawings.
- G. Tee water piping runouts or branches into the side of mains or other branches. Avoid bull-head tees, which are two return lines entering opposite ends of a tee and exiting out the common side.
- H. Connect piping to equipment as shown on the drawings. Install components furnished by others such as:
  - 1. Water treatment pot feeders and condenser water treatment systems.
  - 2. Flow elements (orifice unions), control valve bodies, flow switches, pressure taps with valve, and wells for sensors.
- I. Firestopping: Fill openings around uninsulated piping penetrating floors or fire walls, with firestop material. For firestopping insulated piping refer to Section 23 07 11, HVAC, PLUMBING, AND BOILER PLANT INSULATION.
- J. Where copper piping is connected to steel piping, provide dielectric connections.

### **3.2 PIPE JOINTS**

- A. Welded: Beveling, spacing and other details shall conform to ASME B31.1 and AWS B2.1. See Welder's qualification requirements under "Quality Assurance" in Section 23 05 11, COMMON WORK RESULTS FOR HVAC AND STEAM GENERATION.
- B. Screwed: Threads shall conform to ASME B1.20; joint compound shall be applied to male threads only and joints made up so no more than three threads show. Coat exposed threads on steel pipe with joint compound, or red lead paint for corrosion protection.
- C. 125 Pound Cast Iron Flange (Plain Face): Mating flange shall have raised face, if any, removed to avoid overstressing the cast iron flange.

### **3.3 STEAM TRAP PIPING**

Install to permit gravity flow to the trap. Provide gravity flow (avoid lifting condensate) from the trap where modulating control valves are used. Support traps weighing over 11 kg (25 pounds) independently of connecting piping.

### **3.4 LEAK TESTING**

- A. Inspect all joints and connections for leaks and workmanship and make corrections as necessary, to the satisfaction of the COR. Tests may be either of those below, or a combination, as approved by the COR.

- B. An operating test at design pressure, and for hot systems, design maximum temperature.
- C. A hydrostatic test at 1.5 times design pressure. For water systems the design maximum pressure would usually be the static head, or expansion tank maximum pressure, plus pump head. Factory tested equipment (convertors, exchangers, coils, etc.) need not be field tested. Avoid excessive pressure on mechanical seals and safety devices.

### **3.5 FLUSHING AND CLEANING PIPING SYSTEMS**

- A. Steam, Condensate and Vent Piping: No flushing or chemical cleaning required. Accomplish cleaning by pulling all strainer screens and cleaning all scale/dirt legs during start-up operation.

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