SECTION 23 22 13
STEAM AND CONDENSATE HEATING PIPING

PART 1 - GENERAL

1.1 DESCRIPTION

A. Steam, condensate and vent piping inside buildings.

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.

C. Water treatment for open and closed systems: Section 23 25 00, HVAC WATER TREATMENT.

D. Heating Coils and Humidifiers: Section 23 73 00, INDOOR CENTRAL-STATION AIR-HANDLING UNITS and SECTION 23 31 00, HVAC DUCTS AND CASING.

E. Heating and cooling radiant panels: Section 23 82 00, CONVECTION HEATING AND COOLING UNITS.

F. Heating coils: Section 23 82 16, AIR COILS.

G. Temperature and pressure sensors and valve operators: Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC.

1.3 QUALITY ASSURANCE

A. 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. Pipe alignment guides.
8. Expansion joints.
9. Expansion compensators.
10. Flexible ball joints: Catalog sheets, performance charts, schematic drawings, specifications and installation instructions.
11. All specified steam system components.

12. Gages.
13. Thermometers and test wells.

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 Society of Mechanical Engineers/American National Standards Institute (ASME/ANSI):
   B1.20.1-83(R2006).....Pipe Threads, General Purpose (Inch)
   B16.4-2006.....Gray Iron Threaded Fittings

C. American Society of Mechanical Engineers (ASME):
   B16.1-2005.....Gray Iron Pipe Flanges and Flanged Fittings
   B16.3-2006.....Malleable Iron Threaded Fittings
   B16.9-2007.....Factory-Made Wrought Buttwelding Fittings
   B16.11-2005.....Forged Fittings, Socket-Welding and Threaded
   B16.14-91.....Ferrous Pipe Plugs, Bushings, and Locknuts with Pipe Threads
   B16.22-2001.....Wrought Copper and Copper Alloy Solder-Joint Pressure Fittings
   B16.23-2002.....Cast Copper Alloy Solder Joint Drainage Fittings
   B16.24-2006.....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
   B31.1-2007.....Power Piping
   B31.9-2008.....Building Services Piping
   B40.100-2005.....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

A53-2007.....Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless

A106-2008.....Seamless Carbon Steel Pipe for High-Temperature Service

A126-2004.....Standard Specification for Gray Iron Castings for Valves, Flanges, and Pipe Fittings

A181-2006.....Carbon Steel Forgings, for General-Purpose Piping

A183-2003 ..... Carbon Steel Track Bolts and Nuts

A216-2008 ..... 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

A307-2007 ..... Carbon Steel Bolts and Studs, 60,000 PSI Tensile Strength

A516-2006 ..... Pressure Vessel Plates, Carbon Steel, for Moderate-and- Lower Temperature Service

A536-84(2004)e1 ..... Standard Specification for Ductile Iron Castings

B32-2008 ..... Solder Metal

B61-2008 ..... Steam or Valve Bronze Castings

B62-2009 ..... Composition Bronze or Ounce Metal Castings

B88-2003 ..... Seamless Copper Water Tube

F439-06 ..... Socket-Type Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80

F441-02(2008) ..... Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe, Schedules 40 and 80

E. American Welding Society (AWS):

A5.8-2004.....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

A. 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 and Pumped 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.

C. Vent Piping: Steel, ASTM A53, Grade B, seamless or ERW; A106 Grade B, Seamless; Schedule 40, galvanized.

2.3 FITTINGS FOR STEEL PIPE

A. 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 or 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.

B. 65 mm (2-1/2 inches) and Larger: Welded or flanged joints.

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.
   b. Flange bolting: Carbon steel machine bolts or studs and nuts, ASTM A307, Grade B.

C. Welded Branch and Tap Connections: Forged steel weldolets, or branchlets and threadolets 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 FITTINGS FOR COPPER TUBING

A. Solder Joint:
   1. Joints shall be made up in accordance with recommended practices of the materials applied. Apply 95/5 tin and antimony on all copper piping.

B. Bronze Flanges and Flanged Fittings: ASME B16.24.

C. Fittings: ANSI/ASME B16.18 cast copper or ANSI/ASME B16.22 solder wrought copper.

2.5 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.

E. Contractor’s option: On pipe sizes 2” and smaller, screwed end brass gate valves // or dielectric nipples // may be used in lieu of dielectric unions.

2.6 SCREWED JOINTS

A. Pipe Thread: ANSI B1.20.

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

2.7 VALVES

A. Asbestos packing is not acceptable.

B. All valves of the same type shall be products of a single manufacturer.

C. Provide chain operators for valves 150 mm (6 inches) and larger when the centerline is located 2100 mm (7 feet) or more above the floor or operating platform.

D. Shut-Off Valves

1. Gate Valves:

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

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

1) 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 25 mm (1 inch) factory installed bypass with globe valve on valves 100 mm (4 inches) and larger.

2) All other services: MSS-SP 70, iron body, bronze mounted, 861 kPa (125 psig) wedge disc.

E. Globe and Angle Valves:

1. Globe Valves:

a. 50 mm (2 inches) and smaller: MSS-SP 80, bronze, 1034 kPa (150 lb.) Globe valves shall be union bonnet with metal plug type disc.

b. 65 mm (2 1/2 inches) and larger:

1) Globe valves for high pressure steam 413 kPa (60 psig) and above nominal MPS system): Cast steel body, ASTM A216 grade WCB, flanged, OS&Y, 1034 kPa (150 psig) at 260 degrees C (500 degrees F), 11-1/2 to 13 percent chrome stainless steel disc and renewable seat rings.

2) All other services: 861 kPa (125 psig), flanged, iron body, bronze trim, MSS-SP-85 for globe valves.

2. Angle Valves

a. 50 mm (2 inches) and smaller: MSS-SP 80, bronze, 1034 kPa (150 lb.) Angle valves shall be union bonnet with metal plug type disc.

b. 65 mm (2 1/2 inches) and larger:

1) Angle valves for high pressure steam 413 kPa (60 psig) and above nominal MPS system): Cast steel body, ASTM A216 grade WCB, flanged, OS&Y, 1034 kPa (150 psig) at 260 degrees C (500 degrees F), 11-1/2 to 13 percent chrome stainless steel disc and renewable seat rings.

2) All other services: 861 kPa (125 psig), flanged, iron body, bronze trim, MSS-SP-85 for angle valves.

F. Swing Check Valves

1. 50 mm (2 inches) and smaller: MSS-SP 80, bronze, 1034 kPa (150 psig), 45 degree swing disc.
2. 65 mm (2-1/2 inches) and Larger:
   a Check valves for high pressure steam 413 kPa (60 psig) and above nominal MPS system: Cast steel body, ASTM A216 grade WCB, flanged, OS&Y, 1034 kPa (150 psig) at 260 degrees C (500 degrees F), 11-1/2 to 13 percent chrome stainless steel disc and renewable seat rings.
   b. All other services: 861 kPa (125 psig), flanged, iron body, bronze trim, MSS-SP-71 for check valves.

G. Manual Radiator/Convector Valves: Brass, packless, with position indicator.

2.8 STRAINERS

A. Basket or Y Type. Tee type is acceptable for gravity flow and pumped steam condensate service.

B. High Pressure Steam: Rated 1034 kPa (150 psig) saturated steam.
   1. 50 mm (2 inches) and smaller: Iron, ASTM A116 Grade B, or bronze, ASTM B-62 body with screwed connections (250 psig).
   2. 65 mm (2-1/2 inches) and larger: Flanged cast steel or 1723 kPa (250 psig) cast iron.

C. All Other Services: Rated 861 kPa (125 psig) saturated steam.
   1. 50 mm (2 inches) and smaller: Cast iron or bronze.
   2. 65 mm (2-1/2 inches) and larger: Flanged, iron body.

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.

2.9 PIPE ALIGNMENT

A. Guides: Provide factory-built guides along the pipe line to permit axial movement only and to restrain lateral and angular movement. Guides must be designed to withstand a minimum of 15 percent of the axial force which will be imposed on the expansion joints and anchors. Field-built guides may be used if detailed on the contract drawings.

2.10 EXPANSION JOINTS

A. Factory built devices, inserted in the pipe lines, designed to absorb axial cyclical pipe movement which results from thermal expansion and

contraction. This includes factory-built or field-fabricated guides located along the pipe lines to restrain lateral pipe motion and direct the axial pipe movement into the expansion joints.

B. Minimum Service Requirements:
   1. Pressure Containment:
      a. Steam Service 35-200 kPa (5-30 psig): Rated 345 kPa (50 psig) at 148 degrees C (298 degrees F).
      b. Steam Service 214-850 kPa (31-125 psig): Rated 1025 kPa (150 psig) at 186 degrees C (366 degrees F).
      c. Steam Service 869-1025 kPa (126-150 psig): Rated 1375 kPa (200 psig) at 194 degrees C (382 degrees F).
      d. Condensate Service: Rated 690 kPa (100 psig) at 154 degrees C (310 degrees F).
   2. Number of Full Reverse Cycles without failure: Minimum 1000.
   3. Movement: As shown on drawings plus recommended safety factor of manufacturer.

C. Manufacturing Quality Assurance: Conform to Expansion Joints Manufacturers Association Standards.

D. Bellows - Internally Pressurized Type:
   1. Multiple corrugations of Type 304 or Type A240-321 stainless steel.
   2. Internal stainless steel sleeve entire length of bellows.
   3. External cast iron equalizing rings for services exceeding 340 kPa (50 psig).
   4. Welded ends.
   5. Design shall conform to standards of EJMA and ASME B31.1.
   6. External tie rods designed to withstand pressure thrust force upon anchor failure if one or both anchors for the joint are at change in direction of pipeline.
   7. Integral external cover.

E. Bellows - Externally Pressurized Type:
   1. Multiple corrugations of Type 304 stainless steel.
   2. Internal and external guide integral with joint.
   3. Design for external pressurization of bellows to eliminate squirm.
   4. Welded ends.
   5. Conform to the standards of EJMA and ASME B31.1.
   6. Threaded connection at bottom, 25 mm (one inch) minimum, for drain or drip point.
   7. Integral external cover and internal sleeve.

F. Expansion Joint Identification: Provide stamped brass or stainless steel nameplate on each expansion joint listing the manufacturer, the

allowable movement, flow direction, design pressure and temperature, date of manufacture, and identifying the expansion joint by the identification number on the contract drawings.

2.11 FLEXIBLE BALL JOINTS

A. Design and Fabrication: One piece component construction, fabricated from steel with welded ends, designed for a working steam pressure of 1720 kPa (250 psig) and a temperature of 232 degrees C (450 degrees F). Each joint shall provide for 360 degrees rotation in addition to a minimum angular flexible movement of 30 degrees for sizes 6 mm (1/4 inch) to 150 mm (6 inch) inclusive, and 15 degrees for sizes 65 mm (2-1/2 inches) to 750 mm (30 inches). Joints through 350 mm (14 inches) shall have forged pressure retaining members; while size 400 mm (16 inches) through 760 mm (30 inches) shall be of one piece construction.

B. Material:

1. Cast or forged steel pressure containing parts and bolting in accordance with Section II of the ASME Boiler Code or ASME B31.1. Retainer may be ductile iron ASTM A536, Grade 65-45-12, or ASME Section II SA 515, Grade 70.
2. Gaskets: Steam pressure molded composition design for a temperature range of from minus 10 degrees C (50 degrees F) to plus 274 degrees C (525 degrees F).

C. Certificates: Submit qualifications of ball joints in accordance with the following test data:

1. Low pressure leakage test: 41 kPa (6psig) saturated steam for 60 days.
2. Flex cycling: 800 Flex cycles at 3445 kPa (500 psig) saturated steam.
3. Thermal cycling: 100 saturated steam pressure cycles from atmospheric pressure to operating pressure and back to atmospheric pressure.
4. Environmental shock tests: Forward certificate from a recognized test laboratory, that ball joints of the type submitted has passed shock testing in accordance with Mil. Spec MIL-S-901.
5. Vibration: 170 hours on each of three mutually perpendicular axis at 25 to 125 Hz; 1.3 mm to 2.5 mm (0.05 inch to 0.1 inch) double amplitude on a single ball joint and 3 ball joint off set.

2.12 STEAM SYSTEM COMPONENTS

A. 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 5. Mechanism: Brass, stainless steel or corrosion resistant alloy. 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.

6. Floats: Stainless steel.

7. Inverted bucket traps: Provide bi-metallic thermostatic element for rapid release of non-condensables.

B. 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.

C. Steam Humidifiers:

1. Steam separator type that discharges steam into the air stream through a dispersion tube. Humidifiers shall be complete with Y-type steam supply strainer; modulating, normally closed steam control valve; normally closed condensate temperature switch; and manufacturer's standard steam trap.

2. Steam separator: Stainless steel or cast iron.

3. Distribution manifold: Stainless steel, composed of dispersion pipe and surrounding steam jacket, manifold shall span the width of duct or air handler, and shall be multiple manifold type under any of the following conditions:

a. Duct section height exceeds 900 mm (36 inches).

b. Duct air velocity exceeds 5.1 m/s (1000 feet per minute).

b. If within 900 mm (3 feet) upstream of fan, damper or pre-filter.

d. If within 3000 mm (10 feet) upstream of after-filter.

2.13 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 and steam condensate to 103 kPa(15 psig)	0 to 207 kPa (30 psig).
Medium pressure steam and steam condensate nominal 413 kPa (60 psig)	0 to 689 kPa (100 psig).
High pressure steam and steam condensate nominal 620 kPa to 861 kPa (90 to 125 psig)	0 to 1378 kPa (200 psig).
Pumped condensate, steam condensate, gravity or vacuum (30” HG to 30 psig)	0 to 415 kPa (60 psig)

2.14 PRESSURE/TEMPERATURE TEST PROVISIONS

A. Provide one each of the following test items to the Resident Engineer:

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 (32-220 degrees F) pocket thermometer one-half degree accuracy, 25 mm (one inch) dial, 125 mm (5 inch) long stainless steel stem, plastic case.

2.15 FIRESTOPPING MATERIAL

A. 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. 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.

K. Pipe vents to the exterior. Where a combined vent is provided, the cross sectional area of the combined vent shall be equal to sum of individual vent areas. Slope vent piping one inch in 40 feet (0.25 percent) in direction of flow. Provide a drip trap elbow on relief valve outlets if the vent rises to prevent backpressure. Terminate vent minimum 0.3 M (12 inches) above the roof or through the wall minimum 2.5 M (8 feet) above grade with down turned elbow.

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 EXPANSION JOINTS (BELLOWS AND SLIP TYPE)

A. Anchors and Guides: Provide type, quantity and spacing as recommended by manufacturer of expansion joint and as shown. A professional engineer shall verify in writing that anchors and guides are properly designed for forces and moments which will be imposed.

B. Cold Set: Provide setting of joint travel at installation as recommended by the manufacturer for the ambient temperature during the installation.

C. Preparation for Service: Remove all apparatus provided to restrain joint during shipping or installation. Representative of manufacturer shall visit the site and verify that installation is proper.

D. Access: Expansion joints must be located in readily accessible space. Locate joints to permit access without removing piping or other devices. Allow clear space to permit replacement of joints and to permit access to devices for inspection of all surfaces and for adding packing.

3.4 STEAM TRAP PIPING

A. 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.

3.6 LEAK TESTING

A. Inspect all joints and connections for leaks and workmanship and make corrections as necessary, to the satisfaction of the Resident Engineer in accordance with the specified requirements. Testing shall be performed in accordance with the specification requirements.

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.

3.7 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.

3.8 OPERATING AND PERFORMANCE TEST AND INSTRUCTION

A. Refer to PART 3, Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION.

B. Adjust red set hand on pressure gages to normal working pressure.

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