

SECTION 23 21 13
HYDRONIC PIPING

PART 1 - GENERAL

1.1 DESCRIPTION

- A. Water piping to connect HVAC equipment, including the following:
 - 1. Chilled water, ground source heat pump condenser water and drain piping.
 - 2. Extension of domestic water make-up piping.
 - 3. Glycol-water piping.

1.2 RELATED WORK

- A. Section 01 00 00, GENERAL REQUIREMENTS.
- B. Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- C. Section 23 05 11, COMMON WORK RESULTS FOR HVAC: General mechanical requirements and items, which are common to more than one section of Division 23.
- D. Section 23 07 11, HVAC AND PLUMBING INSULATION: Piping insulation.
- E. Section 23 21 13, HYDRONIC PIPING: Underground chilled water piping.
- F. Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC: Temperature and pressure sensors and valve operators.
- G. Section 22 05 33, HEAT TRACING FOR PLUMBING PIPING: Heat tracing for freeze protection.

1.3 QUALITY ASSURANCE

- A. Section 23 05 11, COMMON WORK RESULTS FOR HVAC, which includes welding qualifications.
- B. Submit prior to welding of steel piping a certificate of Welder's certification. The certificate shall be current and not more than one year old.

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 for water service.

8. Pipe alignment guides.
 9. Expansion joints.
 10. Expansion compensators.
 11. All specified hydronic system components.
 12. Water flow measuring devices.
 13. Gages.
 14. Thermometers and test wells.
 15. Electric heat tracing systems.
- C. Submit prior to welding of steel piping a certificate of Welder's certification. The certificate shall be current and not more than one year old.
- D. As-Built Piping Diagrams: Provide drawing as follows for chilled water and other piping systems and equipment.
1. One wall-mounted stick file with complete set of prints.
 2. One complete set of reproducible drawings.
 3. One complete set of drawings in electronic pdf format.

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 (ASME):
- B1.20.1-83 (R2006).....Pipe Threads, General Purpose (Inch)
 - B16.1-2005.....Cast Iron Pipe Flanges and Flanged Fittings
 - B16.3-2006.....Malleable Iron Threaded Fittings
 - B16.4-2006.....Gray Iron Threaded Fittings Classes 125 and 250
 - B16.5-03.....Pipe Flanges and Flanged Fittings
 - B16.9-2007.....Factory-Made Wrought Buttwelding Fittings
 - B16.11-05.....Forged Fittings, Socket-Welding and Threaded
 - B16.14-91.....Ferrous Pipe Plugs, Bushings, and Locknuts with
Pipe Threads
 - B16.22-01.....Wrought Copper and Copper Alloy Solder-Joint
Pressure Fittings
 - B16.23-02.....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

- B16.42-98.....Ductile Iron Pipe Flanges and Flanged Fittings:
Classes 150 and 300
- B31.9-2008.....Building Services Piping
- B40.100-05.....Pressure Gauges and Gauge Attachments
- C. American National Standards Institute, Inc. (ANSI):
- B16.18-2001.....Cast Copper Alloy Solder joint Pressure fittings
- D. American Society for Testing and Materials (ASTM):
- A47/A47M-99 (2004).....Ferritic Malleable Iron Castings
- A53/A53M-07.....Standard Specification for Pipe, Steel, Black and
Hot-Dipped, Zinc-Coated, Welded and Seamless
- A106/A106M-08.....Standard Specification for Seamless Carbon Steel
Pipe for High-Temperature Service
- A126-04.....Standard Specification for Gray Iron Castings for
Valves, Flanges, and Pipe Fittings
- A181/A181M-06.....Standard Specification for Carbon Steel Forgings,
for General-Purpose Piping
- A183-03.....Standard Specification for Carbon Steel Track
Bolts and Nuts
- A216/A216M-08.....Standard Specification for Steel Castings,
Carbon, Suitable for Fusion Welding, for High
Temperature Service
- A234/A234M-07.....Piping Fittings of Wrought Carbon Steel and Alloy
Steel for Moderate and High Temperature Service
- A307-07b.....Standard Specification for Carbon Steel Bolts and
Studs, 60,000 PSI Tensile Strength
- A536-84 (2004)e1.....Standard Specification for Ductile Iron Castings
- B32-08.....Standard Specification for Solder Metal
- B61-08.....Standard Specification for Steam or Valve Bronze
Castings
- B62-09.....Standard Specification for Composition Bronze or
Ounce Metal Castings
- B88-05.....Standard Specification for Seamless Copper Water
Tube
- C177-04Standard Test Method for Steady State Heat Flux
Measurements and Thermal Transmission Properties
by Means of the Guarded Hot Plate Apparatus
- C552-07.....Cellular Glass Thermal Insulation
- D 3350-08Polyethylene Plastics Pipe and Fittings Materials

- C591-08a.....Unfaced Preformed Rigid Cellular Polyisocyanurate
Thermal Insulation
- D3139-98(2005).....Joints for Plastic Pressure Pipes Using Flexible
Elastomeric Seals
- F477-08.....Elastomeric Seals Gaskets) for Joining Plastic
Pipe
- E. American Welding Society (AWS):
- A5.8/A5.8M-04.....Specification for Filler Metals for Brazing and
Braze Welding
- B2.1/B2.1M-09.....Standard Welding Procedure Specification
- F. Copper Development Association, Inc. (CDA):
- 4013-3939; 1993.....Copper Tube Handbook
- G. Expansion Joint Manufacturer's Association, Inc. (EJMA):
- EMJA-9th EditionExpansion Joint Manufacturer's Association
Standards, Eighth Edition
- H. Manufacturers Standardization Society (MSS) of the Valve and Fitting
Industry, Inc.:
- SP-67-2002a.....Butterfly Valves
- SP-70-2006.....Gray Iron Gate Valves, Flanged and Threaded Ends
- SP-71-2005.....Gray Iron Swing Check Valves, Flanged and
Threaded Ends
- SP-72-1999.....Ball Valves with Flanged or Butt-Welding Ends for
General Service
- SP-78-2005a.....Gray Iron Plug Valves Flanged and Threaded Ends
- SP-80-2008.....Bronze Gate, Globe, Angle and Check Valves
- SP-85-2002.....Cast Iron Globe and Angle Valves, Flanged and
Threaded Ends
- I. National Fire Protection Association (NFPA):
- 70-08.....National Electrical Code (NEC)

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.

2.2 PIPE AND TUBING

- A. Chilled Water (above ground), Glycol-Water, and Vent Piping:
1. Steel: ASTM A53 Grade B, seamless or ERW, Schedule 40.
 2. Copper water tube option: ASTM B88, Type K or L, hard drawn.

B. Cooling Coil Condensate Drain Piping:

From Unitary Equipment: Copper water tube, ASTM B88, Type L.

C. Pipe supports, including insulation shields, for above ground piping:

Section 23 05 11, COMMON WORK RESULTS FOR HVAC.

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. Water service: Weld neck or slip-on, plain face, with 6 mm (1/8 inch) thick full face neoprene gasket suitable for 104 degrees C (220 degrees F).

1) Contractor's option: Convuluted, cold formed 150 pound steel flanges, with teflon gaskets, may be used for water service.

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

B. 50 mm (2 inches) and Smaller: Screwed or welded. Mechanical couplings are optional for water piping only.

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

4. Unions: ASME B16.39.

5. Water hose connection adapter: Brass, pipe thread to 20 mm (3/4 inch) garden hose thread, with hose cap nut.

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.

D. Mechanical Pipe Couplings and Fittings: May be used, with cut or roll grooved pipe, in water service up to 110 degrees C (230 degrees F) in lieu of welded, screwed or flanged connections.

1. Grooved mechanical couplings: Malleable iron, ASTM A47 or ductile iron, ASTM A536, fabricated in two or more parts, securely held

- together by two or more track-head, square, or oval-neck bolts, ASTM A183.
2. Gaskets: Rubber product recommended by the coupling manufacturer for the intended service.
 3. Grooved end fittings: Malleable iron, ASTM A47; ductile iron, ASTM A536; or steel, ASTM A53 or A106, designed to accept grooved mechanical couplings. Tap-in type branch connections are acceptable.

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.
2. Mechanically formed tee connection in water and drain piping: Form mechanically extracted collars in a continuous operation by drilling pilot hole and drawing out tube surface to form collar, having a height of not less than three times the thickness of tube wall. Adjustable collaring device shall insure proper tolerance and complete uniformity of the joint. Notch and dimple joining branch tube in a single process to provide free flow where the branch tube penetrates the fitting.

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

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, 99 degrees C (210 degrees F).

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. 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. MSS-SP 70, iron body, bronze mounted, 861 kPa (125 psig) wedge disc.
- E. Globe, Angle and Swing Check Valves:
1. 50 mm (2 inches) and smaller: MSS-SP 80, bronze, 1034 kPa (150 lb.)
Globe and angle valves shall be union bonnet with metal plug type disc.
 2. 65 mm (2 1/2 inches) and larger: 861 kPa (125 psig), flanged, iron body, bronze trim, MSS-SP-85 for globe valves and MSS-SP-71 for check valves.
- F. Non-Slam or Silent Check Valve: Spring loaded double disc swing check or internally guided flat disc lift type check for bubble tight shut-off. Provide where check valves are shown in chilled water and hot water piping. Check valves incorporating a balancing feature may be used.
1. Body: Cast iron, ASTM A126, Class B, or steel, ASTM A216, Class WCB, or ductile iron, ASTM 536, flanged, grooved, or wafer type.
 2. Seat, disc and spring: 18-8 stainless steel, or bronze, ASTM B62.
Seats may be elastomer material.
- G. 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.
- H. Ball Valves: Brass or bronze body with chrome-plated ball with full port and Teflon seat at 2760 kPa (400 psig) working pressure rating. Screwed or solder connections. Provide stem extension to allow operation without interfering with pipe insulation.
- I. Water Flow Balancing Valves: For flow regulation and shut-off. Valves shall be line size rather than reduced to control valve size and be one of the following types.
 - 1. Butterfly valve as specified herein with memory stop.
 - 2. Eccentric plug valve: Iron body, bronze or nickel-plated iron plug, bronze bearings, adjustable memory stop, operating lever, rated 861 kPa (125 psig) and 121 degrees C (250 degrees F).
- J. Circuit Setter Valve: A dual purpose flow balancing valve and adjustable flow meter, with bronze or cast iron body, calibrated position pointer, valved pressure taps or quick disconnects with integral check valves and preformed polyurethane insulating enclosure. Provide a readout kit including flow meter, readout probes, hoses, flow charts or calculator, and carrying case.
- K. Automatic Balancing Control Valves: Factory calibrated to maintain constant flow (plus or minus five percent) over system pressure fluctuations of at least 10 times the minimum required for control. Provide standard pressure taps and four sets of capacity charts. Valves shall be line size and be one of the following designs:
 - 1. Gray iron (ASTM A126) or brass body rated 1205 kPa (175 psig) at 93 degrees C (200 degrees F), with stainless steel piston and spring.
 - 2. Brass or ferrous body designed for 2067 kPa (300 psig) service at 121 degrees C (250 degrees F), with corrosion resistant, tamper proof, self-cleaning piston/spring assembly that is easily removable for inspection or replacement.
 - 3. Combination assemblies containing ball type shut-off valves, unions, flow regulators, strainers with blowdown valves and pressure temperature ports shall be acceptable.

2.8 WATER FLOW MEASURING DEVICES

- A. Minimum overall accuracy plus or minus three percent over a range of 70 to 110 percent of design flow. Select devices for not less than 110 percent of design flow rate.
- B. Flow Measurement/Balance Valves: A system comprised of two valves of bronze and stainless steel metallurgy designed for 1205 kPa (175 psig) pressure at 121 degrees C (250 degrees F), with thermal insulation sleeve.
 - 1. Measurement and shut-off valve: An on/off ball valve with integral high regain venturi and dual quick connect valves with integral check valves and color coded safety caps for pressure/temperature readout.
- C. Flow Measuring Device Identification:
 - 1. Metal tag attached by chain to the device.
 - 2. Include meter or equipment number, manufacturer's name, meter model, flow rate factor and design flow rate in l/m (gpm).

2.9 STRAINERS

- A. Y Type.
 - 1. Screens: Bronze, monel metal or 18-8 stainless steel, free area not less than 2-1/2 times pipe area, with perforations as follows: 1.1 mm (0.045 inch) diameter perforations.
 - 2. 100 mm (4 inches) and larger: 3.2 mm (0.125 inch) diameter perforations.
- B. Suction Diffusers: Specified in Section 23 21 23, HYDRONIC PUMPS.

2.10 FLEXIBLE CONNECTORS FOR WATER SERVICE

- A. Flanged Spool Connector:
 - 1. Single arch or multiple arch type. Tube and cover shall be constructed of chlorobutyl elastomer with full faced integral flanges to provide a tight seal without gaskets. Connectors shall be internally reinforced with high strength synthetic fibers impregnated with rubber or synthetic compounds as recommended by connector manufacturer, and steel reinforcing rings.
 - 2. Working pressures and temperatures shall be as follows:
 - a. Connector sizes 50 mm to 100 mm (2 inches to 4 inches), 1137 kPa (165 psig) at 121 degrees C (250 degrees F).
 - b. Connector sizes 125 mm to 300 mm (5 inches to 12 inches), 965 kPa (140 psig) at 121 degrees C (250 degrees F).
 - 3. Provide ductile iron retaining rings and control units.
- B. Mechanical Pipe Couplings:

See other fittings specified under Part 2, PRODUCTS.

2.11 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. Manufacturing Quality Assurance: Conform to Expansion Joints Manufacturers Association Standards.
- C. 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.
- D. 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.
- E. Expansion Compensators:
 - 1. Corrugated bellows, externally pressurized, stainless steel or bronze.
 - 2. Internal guides and anti-torque devices.
 - 3. Threaded ends.
 - 4. External shroud.
 - 5. Conform to standards of EJMA.
- 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.

- G. 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.

2.12 HYDRONIC SYSTEM COMPONENTS

- A. Air Purger: Cast iron or fabricated steel, 861 kPa (125 psig) water working pressure, for in-line installation.
- B. Tangential Air Separator: ASME Pressure Vessel Code construction for 861 kPa (125 psig) working pressure, flanged tangential inlet and outlet connection, internal perforated stainless steel air collector tube designed to direct released air into expansion tank, bottom blowdown connection. Provide Form No. U-1. If scheduled on the drawings, provide a removable stainless steel strainer element having 5 mm (3/16 inch) perforations and free area of not less than five times the cross-sectional area of connecting piping.
- C. Diaphragm Type Pre-Pressurized Expansion Tank: ASME Pressure Vessel Code construction for 861 kPa (125 psig) working pressure, welded steel shell, rust-proof coated, with a flexible elastomeric diaphragm suitable for a maximum operating temperature of 116 degrees C (240 degrees F). Provide Form No. U-1. Tank shall be equipped with system connection, drain connection, standard air fill valve and be factory pre-charged to a minimum of 83 kPa (12 psig).
- D. Pressure Reducing Valve (Water): Diaphragm or bellows operated, spring loaded type, with minimum adjustable range of 28 kPa (4 psig) above and below set point. Bronze, brass or iron body and bronze, brass or stainless steel trim, rated 861 kPa (125 psig) working pressure at 107 degrees C (225 degrees F).
- E. Pressure Relief Valve: Bronze or iron body and bronze or stainless steel trim, with testing lever. Comply with ASME Code for Pressure Vessels, Section 8, and bear ASME stamp.
- F. Automatic Air Vent Valves (where shown): Cast iron or semi-steel body, 1034 kPa (150 psig) working pressure, stainless steel float, valve, valve seat and mechanism, minimum 15 mm (1/2 inch) water connection and 6 mm (1/4 inch) air outlet. Pipe the air outlet to drain.

2.13 POT CHEMICAL FEEDERS

See section 23 25 00, HVAC WATER TREATMENT, Article 2.2, CHEMICAL TREATMENT FOR CLOSED LOOP SYSTEMS.

2.14 GAGES, PRESSURE AND COMPOUND

- A. ASME B40.100, Accuracy Grade 1A, (pressure, vacuum, or compound for air, oil or water), 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.
- C. Range of Gages: Provide range equal to at least 130 percent of normal operating range.
 - 1. For condenser water suction (compound): Minus 100 kPa (30 inches Hg) to plus 700 kPa (100 psig).

2.15 PRESSURE/TEMPERATURE TEST PROVISIONS

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.

2.16 THERMOMETERS

- A. Mercury or organic liquid filled type, red or blue column, clear plastic window, with 150 mm (6 inch) brass stem, straight, fixed or adjustable angle as required for each in reading.
- B. Case: Chrome plated brass or aluminum with enamel finish.
- C. Scale: Not less than 225 mm (9 inches), range as described below, two degree graduations.
- D. Separable Socket (Well): Brass, extension neck type to clear pipe insulation.
- E. Scale ranges may be slightly greater than shown to meet manufacturer's standard. Required ranges in degrees C (F): Chilled Water, Condenser Water and Glycol-Water 0 to 38 degrees C (32-100 degrees F)

2.17 FIRESTOPPING MATERIAL

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

2.18 ELECTRICAL HEAT TRACING FOR FREEZE PROTECTION

- A. Systems shall meet requirements of the National Electrical Code (NEC).
- B. Provide tracing for outdoor HVAC piping that does not contain glycol.

- C. Heating Cable: Flexible, parallel circuit construction consisting of a continuous self-limiting resistance, conductive inner core material between two parallel copper bus wires, designed for cut-to-length at the job site and for wrapping around valves and complex fittings. Self-regulation shall prevent overheating and burnouts even where the cable overlaps itself.
1. Provide end seals at ends of circuits. Wire at the ends of the circuits are not to be tied together.
 2. Provide sufficient cable, as recommended by the manufacturer, to keep the pipe surface at 2.2 degrees C (36 degrees F) minimum during winter outdoor design temperature, but not less than the following:
 - a. 75 mm (3 inch) pipe and smaller with 25 mm (1 inch) thick insulation: 4 watts per foot of pipe.
- D. Electrical Heating Tracing Accessories:
1. Power supply connection fitting and stainless steel mounting brackets. Provide stainless steel worm gear clamp to fasten bracket to pipe.
 2. 13 mm (1/2 inch) wide fiberglass reinforced pressure sensitive cloth tape to fasten cable to pipe at 300 mm (12 inch) intervals.
 3. Pipe surface temperature control thermostat: Cast aluminum, NEMA 4 (watertight) enclosure, 15 mm (1/2 inch) NPT conduit hub, SPST switch rated 20 amps at 480 volts AC, with capillary and copper bulb sensor. Set thermostat to maintain pipe surface temperature at not less than 1.1 degrees C (34 degrees F).
 4. Signs: Manufacturer's standard (NEC Code), stamped "ELECTRIC TRACED" located on the insulation jacket at 3000 mm (10 feet) intervals along the pipe on alternating sides.

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 unitary equipment, 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. 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.
- 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 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. Provide manual air vent at all piping system high points and drain valves at all low points.
- I. Connect piping to equipment as shown on the drawings. Install components furnished by others such as:
 - 1. Water treatment pot feeders.
 - 2. Flow elements (orifice unions), control valve bodies, flow switches, pressure taps with valve, and wells for sensors.
- J. Thermometer Wells: In pipes 65 mm (2-1/2 inches) and smaller increase the pipe size to provide free area equal to the upstream pipe area.
- K. 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 AND PLUMBING INSULATION.

- L. 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. Mechanical Joint: Pipe grooving shall be in accordance with joint manufacturer's specifications. Lubricate gasket exterior including lips, pipe ends and housing interiors to prevent pinching the gasket during installation. Lubricant shall be as recommended by coupling manufacturer.
- D. 125 Pound Cast Iron Flange (Plain Face): Mating flange shall have raised face, if any, removed to avoid overstressing the cast iron flange.
- E. Solvent Welded Joints: As recommended by the manufacturer.

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 LEAK TESTING ABOVEGROUND PIPING

- A. Inspect all joints and connections for leaks and workmanship and make corrections as necessary, to the satisfaction of the RE/COTR. Tests may be either of those below, or a combination, as approved by the RE/COTR.
- 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. Isolate equipment where necessary to avoid excessive pressure on mechanical seals and safety devices.

3.5 FLUSHING AND CLEANING PIPING SYSTEMS

- A. Water Piping: Clean systems as recommended by the suppliers of chemicals specified in Section 23 25 00, HVAC WATER TREATMENT.

1. Initial flushing: Remove loose dirt, mill scale, metal chips, weld beads, rust, and like deleterious substances without damage to any system component. Provide temporary piping or hose to bypass coils, control valves, exchangers and other factory cleaned equipment unless acceptable means of protection are provided and subsequent inspection of hide-out areas takes place. Isolate or protect clean system components, including pumps and pressure vessels, and remove any component which may be damaged. Open all valves, drains, vents and strainers at all system levels. Remove plugs, caps, spool pieces, and components to facilitate early debris discharge from system. Sectionalize system to obtain debris carrying velocity of 1.8 m/S (6 feet per second), if possible. Connect dead-end supply and return headers as necessary. Flush bottoms of risers. Install temporary strainers where necessary to protect down-stream equipment. Supply and remove flushing water and drainage by various type hose, temporary and permanent piping and Contractor's booster pumps. Flush until clean as approved by the RE/COTR.
2. Cleaning: Using products supplied in Section 23 25 00, HVAC WATER TREATMENT, circulatesystems at normal temperature to remove adherent organic soil, hydrocarbons, flux, pipe mill varnish, pipe joint compounds, iron oxide, and like deleterious substances not removed by flushing, without chemical or mechanical damage to any system component. Removal of tightly adherent mill scale is not required. Keep isolated equipment which is "clean" and where dead-end debris accumulation cannot occur. Sectionalize system if possible, to circulate at velocities not less than 1.8 m/S (6 feet per second). Circulate each section for not less than four hours. Blow-down all strainers, or remove and clean as frequently as necessary. Drain and prepare for final flushing.

3. Final Flushing: Return systems to conditions required by initial flushing after all cleaning solution has been displaced by clean make-up. Flush all dead ends and isolated clean equipment. Gently operate all valves to dislodge any debris in valve body by throttling velocity. Flush for not less than one hour.

3.6 ELECTRIC HEAT TRACING

- A. Install tracing as recommended by the manufacturer.
- B. Coordinate electrical connections.

3.7 OPERATING AND PERFORMANCE TEST AND INSTRUCTION

- A. Refer to PART 3, Section 23 05 11, COMMON WORK RESULTS FOR HVAC.
- B. Adjust red set hand on pressure gages to normal working pressure.

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