

**SECTION 23 21 13
HYDRONIC PIPING**

PART 1 - GENERAL

1.1 DESCRIPTION

- A. Water piping to connect HVAC equipment, including the following:
 - 1. Heating hot 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 AND STEAM GENERATION: General mechanical requirements and items, which are common to more than one section of Division 23.
- D. Section 23 07 11, HVAC, PLUMBING, AND BOILER PLANT INSULATION: Piping insulation.
- E. Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC: Temperature and pressure sensors and valve operators.

1.3 QUALITY ASSURANCE

- A. Section 23 05 11, COMMON WORK RESULTS FOR HVAC AND STEAM GENERATION, 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. Submit calculations for variable spring and constant support hangers.
 - 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.

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. Coordination Drawings: Refer to Article, SUBMITTALS of Section 23 05 11, COMMON WORK RESULTS FOR HVAC AND STEAM GENERATION.

E. As-Built Piping Diagrams: Provide drawing as follows for heating hot water system and other piping systems and equipment. .

- 1. One wall-mounted stick file with complete set of prints. Mount stick file in the chiller plant or control room along with control diagram stick file.
- 2. One complete set of reproducible drawings.
- 3. One complete set of drawings in electronic format (Autocad, pdf, or other approved 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.....Pipe Threads, General Purpose (Inch)
- B16.1-98.....Cast Iron Pipe Flanges and Flanged Fittings
- B16.3-98.....Malleable Iron Threaded Fittings
- B16.4-98.....Gray Iron Threaded Fittings
- B16.5-03.....Pipe Flanges and Flanged Fittings
- B16.9-03.....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
- B16.24-01.....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
- B16.42-98.....Ductile Iron Pipe Flanges and Flanged Fittings:
Classes 150 and 300
- B31.1-01.....Power Piping
- B31.9-04.....Building Services Piping
- B40.100-05.....Pressure Gauges and Gauge Attachments
- C. American National Standards Institute, Inc. (ANSI):
 - B16.1 00.....Cast Iron Pipe Flanges and Flanged Fittings,
Class 25, 125 and 250
 - B16.3 00.....Malleable Iron Threaded Fittings Classes 150
and 300
 - B16.5 03.....Pipe Flanges and Flanged Fittings NPS ½ through
NPS 24
 - B16.9 03.....Factory Made Wrought Butt Welding Fittings
 - B16.11 01.....Forged Fittings, Socket Welding and Threaded
 - B16.14 91.....Ferrous Pipe Plugs, Bushings and Locknuts with
Pipe Threads
 - B16.18-01.....Cast Copper Alloy Solder joint Pressure
fittings
 - B16.22 00.....Wrought Copper and Bronze Solder Joint Pressure
Fittings
 - B16.24 01.....Cast Copper Alloy Pipe Fittings and Flanged
Fittings: Class 150, 300, 400, 600, 900, 1500
and 2500
 - B31.1 01.....Power Piping
- D. American Society for Testing and Materials (ASTM):
 - A47/A47M-99 (2004).....Ferritic Malleable Iron Castings
 - A53/A53M-06.....Standard Specification for Pipe, Steel, Black
and Hot-Dipped, Zinc-Coated, Welded and
Seamless

- C591-01 Unfaced Preformed Rigid Cellular Polyisocyanurate Thermal Insulation
- D1784 03 Rigid Poly (Vinyl Chloride) (PVC) Compounds and Chlorinated Poly (Vinyl Chloride) (CPVC) Compounds
- D1785 03 Poly (Vinyl Chloride) (PVC) Plastic Pipe, Schedules 40, 80 and 120
- D2241 04 Poly (Vinyl Chloride) (PVC) Pressure Rated Pipe (SDR Series)
- D2464 99 Threaded Poly (Vinyl Chloride) (PVC) Plastic Pipe Fittings, Schedule 80.
- D3139 98 Joints for Plastic Pressure Pipes Using Flexible Elastomeric Seals
- F439-06 Standard Specification for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80
- F441/F441M-02 Standard Specification for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe, Schedules 40 and 80
- F477-02 Elastomeric Seals Gaskets) for Joining Plastic Pipe
- E. American Water Works Association (AWWA):
 - C110/03.....Ductile Iron and Grey Iron Fittings for Water
 - C203 00.....Coal Tar Protective Coatings and Linings for Steel Water Pipe Lines Enamel and Tape Hot Applied
- F. American Welding Society (AWS):
 - A5.8/A5.8M-04.....Specification for Filler Metals for Brazing and Braze Welding
 - B2.1-02.....Standard Welding Procedure Specification
- G. Copper Development Association, Inc. (CDA):
 - CDA A4015-95.....Copper Tube Handbook
- H. Expansion Joint Manufacturer's Association, Inc. (EJMA):
 - EMJA-2003.....Expansion Joint Manufacturer's Association Standards, Eighth Edition
- I. Manufacturers Standardization Society (MSS) of the Valve and Fitting Industry, Inc.:
 - SP-67-02a.....Butterfly Valves

- SP-70-06.....Gray Iron Gate Valves, Flanged and Threaded Ends
- SP-71-05.....Gray Iron Swing Check Valves, Flanged and Threaded Ends
- SP-72-99.....Ball Valves with Flanged or Butt-Welding Ends for General Service
- SP-78-05.....Cast Iron Plug Valves, Flanged and Threaded Ends
- SP-80-03.....Bronze Gate, Globe, Angle and Check Valves
- SP-85-02.....Cast Iron Globe and Angle Valves, Flanged and Threaded Ends

J. National Sanitation Foundation (NSF):

- 14 03.....Plastic Piping System Components and Related Materials

K. Tubular Exchanger Manufacturers Association: TEMA 8th Edition, 2000

L. Sheet Metal and Air Conditioning Contractors National Association (SMACNA):

- HVAC Duct Construction Standards, 2nd Edition 1997

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. Heating Hot 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. Soft drawn tubing, 20 mm (3/4 inch) and larger, may be used for runouts to floor mounted fan coil units.

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

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

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: Convolute, 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 FITTINGS FOR PLASTIC PIPING

- A. Schedule 80, socket type for solvent welding.
- B. Polypropylene drain piping: Flame retardant, drainage pattern.
- C. Chemical feed piping for condenser water treatment: Chlorinated polyvinyl chloride (CPVC), Schedule 80, ASTM F439.

2.6 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).

2.7 SCREWED JOINTS

- A. Pipe Thread: ANSI B1.20.
- B. Lubricant or Sealant: Oil and graphite or other compound approved for the intended service.

2.8 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. All valves must be by "Apollo" or "Conbraco" per VA request.
- 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.

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4. Provide a readout kit including flow meter, probes, hoses, flow charts and carrying case.

- L. Manual Radiator/Convactor Valves: Brass, packless, with position indicator.

2.9 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. Venturi Type: Bronze, steel, or cast iron with bronze throat, with valved pressure sensing taps upstream and at the throat.
- C. Wafer Type Circuit Sensor: Cast iron wafer-type flow meter equipped with readout valves to facilitate the connecting of a differential pressure meter. Each readout valve shall be fitted with an integral check valve designed to minimize system fluid loss during the monitoring process.
- D. Self-Averaging Annular Sensor Type: Brass or stainless steel metering tube, shutoff valves and quick-coupling pressure connections. Metering tube shall be rotatable so all sensing ports may be pointed down-stream when unit is not in use.
- E. 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.
 2. A butterfly balancing valve as specified herein, with memory stop and quick connect valve for pressure/temperature readout.
- F. Insertion Turbine Type Sensor: Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC.
- G. 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).

H. Permanently Mounted Water Flow Indicating Meters: Minimum 150 mm (6 inch) diameter, or 450 mm (18 inch) long scale, for 120 percent of design flow rate, direct reading in lps (gpm), with three valve manifold and two shut-off valves.

2.10 STRAINERS

A. Basket or Y Type. Tee type is acceptable for water service.

B. 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.

2.11 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 (165psig) 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.

2.12 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. 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.
- D. 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.

2.13 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.

2.14 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 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, , --100 kPa (30 inches) Hg to 700 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.

2.15 THERMOMETERS

- A. 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 and Glycol-Water 0 to 38 degrees C (32-100 degrees F)	Hot Water and Glycol-Water -1 to 116 degrees C (30 to 240 degrees F).
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2.16 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 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 and condenser water treatment systems.
 - 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, PLUMBING, AND BOILER PLANT INSULATION.
- L. Where copper piping is connected to steel piping, provide dielectric connections.
- M. Seal all other penetrations.

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 Resident Engineer. Tests may be either of those below, or a combination, as approved by the Resident Engineer.
- 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 Resident Engineer.
2. Cleaning: Using products supplied in Section 23 25 00, HVAC WATER TREATMENT, circulate systems 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 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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