SECTION 230516 - EXPANSION FITTINGS AND LOOPS FOR HVAC PIPING

PART 1 - GENERAL

- A. Section Includes:
 - 1. Flexible, ball-joint packed expansion joints.
 - 2. Slip-joint, packed expansion joints.
 - 3. Expansion-compensator packless expansion joints.
 - 4. Flexible-hose packless expansion joints.
 - 5. Metal-bellows packless expansion joints.
 - 6. Alignment guides and anchors.
 - 7. Pipe loops and swing connections.

1.2 ACTION SUBMITTALS

- A. Product Data: For each type of product.
- B. Delegated-Design Submittal: For each anchor and alignment guide, including analysis data, signed and sealed by the qualified professional engineer responsible for their preparation.
 - 1. Design Calculations: Calculate requirements for thermal expansion of piping systems and for selecting and designing expansion joints, loops, and swing connections.
 - 2. Anchor Details: Detail fabrication of each anchor indicated. Show dimensions and methods of assembly and attachment to building structure.
 - 3. Alignment Guide Details: Detail field assembly and attachment to building structure.
 - 4. Schedule: Indicate type, manufacturer's number, size, material, pressure rating, end connections, and location for each expansion joint.

1.3 INFORMATIONAL SUBMITTALS

A. Welding certificates.

1.4 CLOSEOUT SUBMITTALS

A. Maintenance Data: For expansion joints to include in maintenance manuals.

1.5 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code Steel."
- B. Pipe and Pressure-Vessel Welding Qualifications: Qualify procedures and operators according to ASME Boiler and Pressure Vessel Code.

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

- A. Compatibility: Products shall be suitable for piping service fluids, materials, working pressures, and temperatures.
- B. Capability: Products to absorb 200 percent of maximum axial movement between anchors.

2.2 PACKED EXPANSION JOINTS

- A. Flexible, Ball-Joint Packed Expansion Joints:
 - 1. Basis-of-Design Product:
 - a. Advanced Thermal Systems, Inc.
 - b. Hyspan Precision Products, Inc.
 - c. Approved equal.
 - 2. Standards: ASME Boiler and Pressure Vessel Code: Section II, "Materials"; ASME B31.9, "Building Services Piping," for materials and design of pressure-containing parts and bolting.
 - 3. Material: Carbon-steel assembly with asbestos-free composition packing.
 - 4. Design: Provide 360-degree rotation and angular deflection.
 - 5. Minimum Pressure Rating: 250 psig at 400 deg F.
 - 6. Angular Deflection for NPS 6 and Smaller: 30 degree minimum.
 - 7. Angular Deflection for NPS 8 and Larger: 15 degree minimum.
 - 8. Seal Type: Two carbon steel and graphite seals suitable for continuous operation at temperature up to 650 deg F.
 - 9. Internal Ball: Plated with minimum 1-mil chrome cover.
 - 10. Ball Socket: One- or two-piece design with integral socket/retainer.
 - a. Stuffing Box: Incorporates containment seals and compression seals for containment of injectable packing.
 - b. Packing Cylinders: Provides packing under full line pressure with check valves to prevent blowback.
 - 11. End Connections for NPS 2 and Smaller: Threaded.
 - 12. End Connections for NPS 2-1/2 and Larger: Flanged.
- B. Slip-Joint Packed Expansion Joints:
 - 1. Basis-of-Design Product:
 - a. Adsco Manufacturing LLC.
 - b. Advanced Thermal Systems, Inc.
 - c. Hyspan Precision Products, Inc.
 - d. Approved Equal.
 - 2. Standard: ASTM F 1007.

- 3. Material: Carbon steel with asbestos-free PTFE packing.
- 4. Design: With internal guide and injection ports for repacking under full system pressure. Housing shall be furnished with drain ports and lifting ring. Include drip connection if used for steam piping.
- 5. Configuration: Single joint class(es), unless otherwise indicated.
- 6. Slip Tube for sizes NPS 1-1/2 through NPS 16: Schedule 80.
- 7. Slip Tube for sizes NPS 18 through NPS 24: Schedule 60.
- 8. Sliding Surface: 2 mil thick chrome finish.
- 9. End Connections: Flanged or welded ends to match piping system.

2.3 PACKLESS EXPANSION JOINTS

- A. Metal, Expansion-Compensator Packless Expansion Joints
 - 1. Basis-of-Design Product:
 - a. Adsco Manufacturing LLC.
 - b. Flexicraft Industries.
 - c. Flex Pression Ltd.
 - d. Flex-Weld, Inc.
 - e. Hyspan Precision Products, Inc.
 - f. Metraflex, Inc.
 - g. Senior Flexonics Pathway.
 - h. Unaflex.
 - i. Unisource Manufacturing, Inc.
 - 2. Minimum Pressure Rating: 150 psig, unless otherwise indicated.
 - 3. Configuration for Copper Tubing: Multi-ply, phosphor-bronze bellows with copper pipe ends.
 - a. End Connections for Copper Tubing NPS 2 and Smaller: Solder joint.
 - b. End Connections for Copper Tubing NPS 2-1/2 to NPS 4: Threaded.
 - 4. Configuration for Steel Piping: Multi-ply, stainless-steel bellows; steel-pipe end connections; and carbon-steel shroud.
 - a. End Connections for Steel Pipe NPS 2 and Smaller: Threaded.
 - b. End Connections for Steel Pipe NPS 2-1/2 to NPS 4: Flanged.
- B. Rubber, Expansion-Compensator Packless Expansion Joints:
 - 1. Basis-of-Design Product:
 - a. Amber/Booth Company, Inc.; a div. of Vibration Isolation Products of Texas, Inc.
 - b. Flex-Hose Co., Inc.
 - c. Flexicraft Industries.
 - d. General Rubber Corporation.
 - e. Mason Industries, Inc.; Mercer Rubber Co.
 - f. Proco Products, Inc.
 - g. Tozen Corporation.

- h. Unaflex.
- i. Unisource Manufacturing, Inc.
- 2. Material: Twin reinforced-rubber spheres with external restraining cables.
- 3. Minimum Pressure Rating: 150 psig at 170 deg F, unless otherwise indicated.
- 4. End Connections for NPS 2 and Smaller: Threaded.
- 5. End Connections for Steel Pipe NPS 2-1/2 to NPS 4: Flanged.
- C. Flexible-Hose Packless Expansion Joints:
 - 1. Basis-of-Design Product:
 - a. Flex-Hose Co., Inc.
 - b. Flexicraft Industries.
 - c. Flex Pression Ltd.
 - d. Metraflex, Inc.
 - e. Unisource Manufacturing, Inc.
 - 2. Description: Manufactured assembly with inlet and outlet elbow fittings and two flexiblemetal-hose legs joined by long-radius, 180-degree return bend or center section of flexible hose.
 - 3. Flexible Hose: Corrugated-metal inner hoses and braided outer sheaths.
 - 4. Expansion Joints for Copper Tubing NPS 2 and Smaller: Copper-alloy fittings with solder-joint end connections.
 - a. Bronze hoses and single-braid bronze sheaths with 450 psig at 70 deg F and 340 psig at 450 deg F ratings.
 - 5. Expansion Joints for Copper Tubing NPS 2-1/2 to NPS 4: Copper-alloy fittings with threaded end connections.
 - a. Stainless-steel hoses and single-braid, stainless-steel sheaths with 300 psig at 70 deg F and 225 psig at 450 deg F ratings.
 - 6. Expansion Joints for Steel Piping NPS 2 and Smaller: Carbon-steel fittings with threaded end connections.
 - a. Stainless-steel hoses and single-braid, stainless-steel sheaths with 450 psig at 70 deg F and 325 psig at 600 deg F ratings.
 - 7. Expansion Joints for Steel Piping NPS 2-1/2 to NPS 6: Carbon-steel fittings with welded end connections.
 - a. Stainless-steel hoses and single-braid, stainless-steel sheaths with 200 psig at 70 deg F and 145 psig at 600 deg F ratings.
 - 8. Expansion Joints for Steel Piping NPS 8 to NPS 12: Carbon-steel fittings with flanged end connections.

- a. Stainless-steel hoses and single-braid, stainless-steel sheaths with 125 psig at 70 deg F and 90 psig at 600 deg F ratings.
- 9. Expansion Joints for Steel Piping NPS 14 and Larger: Carbon-steel fittings with flanged end connections.
 - a. Stainless-steel hoses and double-braid, stainless-steel sheaths with 165 psig at 70 deg F and 120 psig at 600 deg F ratings.
- D. Metal-Bellows Packless Expansion Joints:
 - 1. Basis-of-Design Product:
 - a. Adsco Manufacturing LLC.
 - b. American BOA, Inc.
 - c. Badger Industries, Inc.
 - d. Expansion Joint Systems, Inc.
 - e. Flex-Hose Co., Inc.
 - f. Flexicraft Industries.
 - g. Flex Pression Ltd.
 - h. Flex-Weld, Inc.
 - i. Flo Fab inc.
 - j. Hyspan Precision Products, Inc.
 - k. Metraflex, Inc.
 - 1. Proco Products, Inc.
 - m. Senior Flexonics Pathway.
 - n. Tozen Corporation.
 - o. Unaflex.
 - p. Unisource Manufacturing, Inc.
 - q. Universal Metal Hose; a subsidiary of Hyspan Precision Products, Inc.
 - r. U.S. Bellows, Inc.
 - s. WahlcoMetroflex.
 - 2. Standards: ASTM F 1120 and EJMA's "Standards of the Expansion Joint Manufacturers Association, Inc."
 - 3. Type: Circular, corrugated bellows with external tie rods.
 - 4. Minimum Pressure Rating: 150 psig, unless otherwise indicated.
 - 5. Configuration: Single joint class(es), unless otherwise indicated.
 - 6. Expansion Joints for Copper Tubing: Single-ply phosphor-bronze bellows, copper pipe ends, and brass shrouds.
 - a. End Connections for Copper Tubing NPS 2 and Smaller: Solder joint.
 - b. End Connections for Copper Tubing NPS 2-1/2 to NPS 4: Solder joint
 - c. End Connections for Copper Tubing NPS 5 and Larger: Flanged.
 - 7. Expansion Joints for Steel Piping: Single-ply stainless-steel bellows, steel pipe ends, and carbon-steel shroud.
 - a. End Connections for Steel Pipe NPS 2 and Smaller: Threaded.
 - b. End Connections for Steel Pipe NPS 2-1/2 and Larger: Flanged.

2.4 ALIGNMENT GUIDES AND ANCHORS

- A. Alignment Guides:
 - 1. Basis-of-Design Product:
 - a. Adsco Manufacturing LLC.
 - b. Advanced Thermal Systems, Inc.
 - c. Flex-Hose Co., Inc.
 - d. Flexicraft Industries.
 - e. Flex-Weld, Inc.
 - f. Hyspan Precision Products, Inc.
 - g. Metraflex, Inc.
 - h. Senior Flexonics Pathway.
 - i. Unisource Manufacturing, Inc.
 - j. U.S. Bellows, Inc.
 - 2. Description: Steel, factory-fabricated alignment guide, with bolted two-section outer cylinder and base for attaching to structure; with two-section guiding slider for bolting to pipe.
- B. Anchor Materials:
 - 1. Steel Shapes and Plates: ASTM A 36/A 36M.
 - 2. Bolts and Nuts: ASME B18.10 or ASTM A 183, steel hex head.
 - 3. Washers: ASTM F 844, steel, plain, flat washers.
 - 4. Mechanical Fasteners: Insert-wedge-type stud with expansion plug anchor for use in hardened portland cement concrete, with tension and shear capacities appropriate for application.
 - a. Stud: Threaded, zinc-coated carbon steel.
 - b. Expansion Plug: Zinc-coated steel.
 - c. Washer and Nut: Zinc-coated steel.
 - 5. Chemical Fasteners: Insert-type stud, bonding-system anchor for use with hardened portland cement concrete, with tension and shear capacities appropriate for application.
 - a. Bonding Material: ASTM C 881/C 881M, Type IV, Grade 3, two-component epoxy resin suitable for surface temperature of hardened concrete where fastener is to be installed.
 - b. Stud: ASTM A 307, zinc-coated carbon steel with continuous thread on stud, unless otherwise indicated.
 - c. Washer and Nut: Zinc-coated steel.

PART 3 - EXECUTION

3.1 EXPANSION JOINT INSTALLATION

A. Install expansion joints of sizes matching sizes of piping in which they are installed.

- B. Install packed-type expansion joints with packing suitable for fluid service.
- C. Install metal-bellows expansion joints according to EJMA's "Standards of the Expansion Joint Manufacturers Association, Inc."
- D. Install rubber packless expansion joints according to FSA-PSJ-703.
- E. Install grooved-joint expansion joints to grooved-end steel piping.

3.2 PIPE LOOP AND SWING CONNECTION INSTALLATION

- A. Install pipe loops cold-sprung in tension or compression as required to partly absorb tension or compression produced during anticipated change in temperature.
- B. Connect risers and branch connections to mains with at least five pipe fittings, including tee in main.
- C. Connect risers and branch connections to terminal units with at least four pipe fittings, including tee in riser.
- D. Connect mains and branch connections to terminal units with at least four pipe fittings, including tee in main.

3.3 ALIGNMENT-GUIDE AND ANCHOR INSTALLATION

- A. Install alignment guides to guide expansion and to avoid end-loading and torsional stress.
- B. Install one guide(s) on each side of pipe expansion fittings and loops. Install guides nearest to expansion joint not more than four pipe diameters from expansion joint.
- C. Attach guides to pipe, and secure guides to building structure.
- D. Install anchors at locations to prevent stresses from exceeding those permitted by ASME B31.9 and to prevent transfer of loading and stresses to connected equipment.
- E. Anchor Attachments:
 - 1. Anchor Attachment to Steel Pipe: Attach by welding. Comply with ASME B31.9 and ASME Boiler and Pressure Vessel Code: Section IX, "Welding and Brazing Qualifications."
 - 2. Anchor Attachment to Copper Tubing: Attach with pipe hangers. Use MSS SP-69, Type 24; U bolts bolted to anchor.
- F. Fabricate and install steel anchors by welding steel shapes, plates, and bars. Comply with ASME B31.9 and AWS D1.1/D1.1M.
 - 1. Anchor Attachment to Steel Structural Members: Attach by welding.
 - 2. Anchor Attachment to Concrete Structural Members: Attach by fasteners. Follow fastener manufacturer's written instructions.

G. Use grout to form flat bearing surfaces for guides and anchors attached to concrete.

END OF SECTION 230516