

SECTION 23 2113
HYDRONIC PIPING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes pipe and fitting materials, joining methods, special-duty valves, and specialties for the following:
 - 1. Hot-water heating piping.
 - 2. Chilled-water piping.
 - 3. Condensate-drain piping.
- B. Related Sections include the following:
 - 1. Section 23 2123 "Hydronic Pumps" for pumps, motors, and accessories for hydronic piping.

1.3 DEFINITIONS

- A. PTFE: Polytetrafluoroethylene.
- B. RTRF: Reinforced thermosetting resin (fiberglass) fittings.
- C. RTRP: Reinforced thermosetting resin (fiberglass) pipe.

1.4 ACTION SUBMITTALS

- A. Product Data: For each type of the following:
 - 1. Pipe and Pipe Fittings.
 - 2. Air control devices.
 - 3. Chemical treatment.
 - 4. Hydronic specialties.
- B. Shop Drawings: Detail, at 1/4 scale, the piping layout, fabrication of pipe anchors, hangers, supports for multiple pipes, alignment guides, expansion joints and loops, and attachments of the same to the building structure. Detail location of anchors, alignment guides, and expansion joints and loops.

1.5 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For Installer.
- B. Welding certificates.
- C. Field quality-control test reports.

1.6 CLOSEOUT SUBMITTALS

- A. Operation and Maintenance Data: For air control devices, hydronic specialties, and special-duty valves to include in emergency, operation, and maintenance manuals.

1.7 MAINTENANCE MATERIAL SUBMITTALS

- A. Differential Pressure Meter: For each type of balancing valve and automatic flow control valve, include flowmeter, probes, hoses, flow charts, and carrying case.

1.8 QUALITY ASSURANCE

- A. Installer Qualifications:
- B. Steel Support Welding: Qualify processes and operators according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."
- C. Welding: Qualify processes and operators according to ASME Boiler and Pressure Vessel Code: Section IX.
 - 1. Comply with provisions in ASME B31 Series, "Code for Pressure Piping."
 - 2. Certify that each welder has passed AWS qualification tests for welding processes involved and that certification is current.
- D. ASME Compliance: Comply with ASME B31.9, "Building Services Piping," for materials, products, and installation. Safety valves and pressure vessels shall bear the appropriate ASME label. Fabricate and stamp air separators and expansion tanks to comply with ASME Boiler and Pressure Vessel Code: Section VIII, Division 1.

PART 2 - PRODUCTS

2.1 COPPER TUBE AND FITTINGS

- A. Drawn-Temper Copper Tubing: ASTM B 88, Type L .
- B. Annealed-Temper Copper Tubing: ASTM B 88, Type K.
- C. DWV Copper Tubing: ASTM B 306, Type DWV.
- D. Wrought-Copper Fittings: ASME B16.22.
- E. Wrought-Copper Unions: ASME B16.22.

2.2 STEEL PIPE AND FITTINGS

- A. Steel Pipe: ASTM A 53/A 53M, black steel with plain ends; type, grade, and wall thickness as indicated in Part 3 "Piping Applications" Article.
- B. Malleable-Iron Threaded Fittings: ASME B16.3, Classes 150 and 300 as indicated in Part 3 "Piping Applications" Article.
- C. Malleable-Iron Unions: ASME B16.39; Classes 150, 250, and 300 as indicated in Part 3 "Piping Applications" Article.
- D. Wrought-Steel Fittings: ASTM A 234/A 234M, wall thickness to match adjoining pipe.
- E. Wrought Cast- and Forged-Steel Flanges and Flanged Fittings: ASME B16.5, including bolts, nuts, and gaskets of the following material group, end connections, and facings:
 - 1. Material Group: 1.1.
 - 2. End Connections:
 - a. Butt welding.
 - b. Slip-on; welded on each side of flange face.
 - 3. Facings: Raised face.
- F. Steel Pipe Nipples: ASTM A 733, made of same materials and wall thicknesses as pipe in which they are installed.

2.3 JOINING MATERIALS

- A. Pipe-Flange Gasket Materials: Suitable for chemical and thermal conditions of piping system contents.

1. ASME B16.21, nonmetallic, flat, asbestos free, Spiral wound 1/8-inch maximum thickness unless thickness or specific material is indicated.
 - a. Full-Face Type: For flat-face, Class 150, wrought steel and cast-bronze flanges.
- B. Flange Bolts and Nuts: ASME B18.2.1, carbon steel, unless otherwise indicated.
- C. Solder Filler Metals: ASTM B 32, lead-free alloys. Include water-flushable flux according to ASTM B 813.
- D. Brazing Filler Metals: AWS A5.8, BCuP Series, copper-phosphorus alloys for joining copper with copper; or BA9-1, silver alloy for joining copper with bronze or steel.
- E. Welding Filler Metals: Comply with AWS D10.12/D10.12M for welding materials appropriate for wall thickness and chemical analysis of steel pipe being welded.
- F. Gasket Material: Thickness, material, and type suitable for fluid to be handled and working temperatures and pressures.

2.4 DIELECTRIC FITTINGS

- A. General Requirements: Assembly of copper alloy and ferrous materials with separating nonconductive insulating material. Include end connections compatible with pipes to be joined.
- B. Dielectric Unions:
 1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Capitol Manufacturing Company.
 - b. Central Plastics Company.
 - c. Hart Industries International, Inc.
 - d. Jomar International Ltd.
 - e. Matco-Norca, Inc.
 - f. McDonald, A. Y. Mfg. Co.
 - g. Watts Regulator Co.; a division of Watts Water Technologies, Inc.
 - h. Wilkins; a Zurn company.
 - i. Or Approved Equal.
 2. Description:
 - a. Standard: ASSE 1079.
 - b. Pressure Rating: 150 psig.
 - c. End Connections: Solder-joint copper alloy and threaded ferrous.
- C. Dielectric Flanges:
 1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Capitol Manufacturing Company.
 - b. Central Plastics Company.

- c. Matco-Norca, Inc.
 - d. Watts Regulator Co.; a division of Watts Water Technologies, Inc.
 - e. Wilkins; a Zurn company.
 - f. Or Approved Equal.
2. Description:
- a. Standard: ASSE 1079.
 - b. Factory-fabricated, bolted, companion-flange assembly.
 - c. Pressure Rating: 150 psig.
 - d. End Connections: Solder-joint copper alloy and threaded ferrous; threaded solder-joint copper alloy and threaded ferrous.
- D. Dielectric-Flange Insulating Kits:
1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
- a. Advance Products & Systems, Inc.
 - b. Calpico, Inc.
 - c. Central Plastics Company.
 - d. Pipeline Seal and Insulator, Inc.
 - e. Or Approved Equal.
2. Description:
- a. Nonconducting materials for field assembly of companion flanges.
 - b. Pressure Rating: 150 psig.
 - c. Gasket: Neoprene or phenolic.
 - d. Bolt Sleeves: Phenolic or polyethylene.
 - e. Washers: Phenolic with steel backing washers.
- E. Dielectric Nipples:
1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
- a. Elster Perfection.
 - b. Grinnell Mechanical Products.
 - c. Matco-Norca, Inc.
 - d. Precision Plumbing Products, Inc.
 - e. Victaulic Company.
 - f. Or Approved Equal.
2. Description:
- a. Standard: IAPMO PS 66
 - b. Electroplated steel nipple. complying with ASTM F 1545.

- c. Pressure Rating: 300 psig at 225 deg F.
- d. End Connections: Male threaded or grooved.
- e. Lining: Inert and noncorrosive, propylene.

2.5 VALVES

- A. Gate, Globe, Check, Ball, and Butterfly Valves: Comply with requirements specified in Section 23 0523 "General-Duty Valves for HVAC Piping."
- B. Automatic Temperature-Control Valves, Actuators, and Sensors: Comply with requirements specified in Section 29 0000 "Automatic Temperature Controls (ATC)."
- C. Bronze, Calibrated-Orifice, Balancing Valves:
 - 1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - a. Flow Design Inc.
 - b. Griswold Controls.
 - c. Or Approved Equal.
 - 2. Body: Bronze, ball or plug type with calibrated orifice or venturi.
 - 3. Ball: Brass or stainless steel.
 - 4. Plug: Resin.
 - 5. Seat: PTFE.
 - 6. End Connections: Threaded or socket.
 - 7. Pressure Gage Connections: Integral seals for portable differential pressure meter.
 - 8. Handle Style: Lever, with memory stop to retain set position.
 - 9. CWP Rating: Minimum 125 psig.
 - 10. Maximum Operating Temperature: 250 deg F.
- D. Cast-Iron or Steel, Calibrated-Orifice, Balancing Valves:
 - 1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - a. Flow Design Inc.
 - b. Griswold Controls.
 - c. Or Approved Equal.
 - 2. Body: Cast-iron or steel body, ball, plug, or globe pattern with calibrated orifice or venturi.
 - 3. Ball: Brass or stainless steel.
 - 4. Stem Seals: EPDM O-rings.
 - 5. Disc: Glass and carbon-filled PTFE.
 - 6. Seat: PTFE.
 - 7. End Connections: Flanged.
 - 8. Pressure Gage Connections: Integral seals for portable differential pressure meter.

9. Handle Style: Lever, with memory stop to retain set position.
 10. CWP Rating: Minimum 125 psig.
 11. Maximum Operating Temperature: 250 deg F.
- E. Diaphragm-Operated, Pressure-Reducing Valves:
1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - a. Amtrol, Inc.
 - b. Armstrong Pumps, Inc.
 - c. Bell & Gossett Domestic Pump; a division of ITT Industries.
 - d. Conbraco Industries, Inc.
 - e. Spence Engineering Company, Inc.
 - f. Watts Regulator Co.; a division of Watts Water Technologies, Inc.
 - g. Or Approved Equal.
 2. Body: Bronze or brass.
 3. Disc: Glass and carbon-filled PTFE.
 4. Seat: Brass.
 5. Stem Seals: EPDM O-rings.
 6. Diaphragm: EPT.
 7. Low inlet-pressure check valve.
 8. Inlet Strainer: Stainless Steel, removable without system shutdown.
 9. Valve Seat and Stem: Noncorrosive.
 10. Valve Size, Capacity, and Operating Pressure: Selected to suit system in which installed, with operating pressure and capacity factory set and field adjustable.
- F. Diaphragm-Operated Safety Valves:
1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - a. Amtrol, Inc.
 - b. Armstrong Pumps, Inc.
 - c. Bell & Gossett Domestic Pump; a division of ITT Industries.
 - d. Conbraco Industries, Inc.
 - e. Spence Engineering Company, Inc.
 - f. Watts Regulator Co.; a division of Watts Water Technologies, Inc.
 - g. Or Approved Equal.
 2. Body: Bronze or brass.
 3. Disc: Glass and carbon-filled PTFE.
 4. Seat: Brass.
 5. Stem Seals: EPDM O-rings.

6. Diaphragm: EPT.
 7. Wetted, Internal Work Parts: Brass and rubber.
 8. Inlet Strainer: Stainless Steel, removable without system shutdown.
 9. Valve Seat and Stem: Noncorrosive.
 10. Valve Size, Capacity, and Operating Pressure: Comply with ASME Boiler and Pressure Vessel Code: Section IV, and selected to suit system in which installed, with operating pressure and capacity factory set and field adjustable.
- G. Automatic Flow-Control Valves:
1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - a. Flow Design Inc.
 - b. Griswold Controls.
 - c. Or Approved Equal.
 2. Body: Brass or ferrous metal.
 3. Piston and Spring Assembly: Stainless steel, tamper proof, self cleaning, and removable.
 4. Combination Assemblies: Include bronze or brass-alloy ball valve.
 5. Identification Tag: Marked with zone identification, valve number, and flow rate.
 6. Size: Same as pipe in which installed.
 7. Performance: Maintain constant flow, plus or minus 5 percent over system pressure fluctuations.
 8. Minimum CWP Rating: 300 psig.
 9. Maximum Operating Temperature: 250 deg F.

2.6 AIR CONTROL DEVICES

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
1. Armstrong Pumps, Inc.
 2. Or Approved Equal.
- B. Manual Air Vents:
1. Body: Bronze.
 2. Internal Parts: Stainless Steel Ball.
 3. Operator: Lever.
 4. Inlet Connection: NPS 1/2.
 5. Discharge Connection: NPS 1/4.
 6. CWP Rating: 150 psig.
 7. Maximum Operating Temperature: 225 deg F.
- C. Automatic Air Vents:
1. Body: Bronze or cast iron.

2. Internal Parts: Stainless Steel.
3. Operator: Stainless Steel metal float.
4. Inlet Connection: NPS 1/2.
5. Discharge Connection: NPS 1/4.
6. CWP Rating: 150 psig.
7. Maximum Operating Temperature: 240 deg F.

2.7 HYDRONIC PIPING SPECIALTIES

A. Y-Pattern Strainers:

1. Body 2" and Smaller: ASTM A 126, Class B CWP of 400 psig, cast iron with bolted cover and bottom drain connection.
2. Body 2 1/2" and Larger: ASTM 216 Grade WCB Cast Steel, bolted cap CWP of 300 psig, bottom drain connection.
3. End Connections: Threaded ends for NPS 2 and smaller; flanged ends for NPS 2-1/2 and larger.
4. Screen: Stainless Steel.
5. Strainer Screen: 40 -mesh startup strainer. Liquid service 3" and smaller, 20 mesh screen; 4" and larger, 3/64" diameter.
6. CWP Rating: 125 psig.

B. Stainless-Steel Bellow, Flexible Connectors:

1. Body: Stainless-steel bellows with woven, flexible, bronze, wire-reinforcing protective jacket.
2. End Connections: Threaded or flanged to match equipment connected.
3. Performance: Capable of 3/4-inch misalignment.
4. CWP Rating: 150 psig.
5. Maximum Operating Temperature: 250 deg F.

C. Spherical, Rubber, Flexible Connectors:

1. Body: Fiber-reinforced rubber body.
2. End Connections: Steel flanges drilled to align with Classes 150 and 300 steel flanges.
3. Performance: Capable of misalignment.
4. CWP Rating: 150 psig.
5. Maximum Operating Temperature: 250 deg F.

PART 3 - EXECUTION

3.1 PIPING APPLICATIONS

- #### **A. Hot-water heating piping, aboveground, NPS 2 1/2 and smaller, shall be any of the following:**
1. Type L, drawn-temper copper tubing, wrought-copper fittings, and soldered joints.
 2. Schedule 40 steel pipe; Class 150, malleable-iron fittings; wrought-steel flanges

and flange fittings; and threaded joints.

- B. Hot-water heating piping, aboveground, NPS 3 and larger, shall be the following:
 - 1. Schedule 40 steel pipe, wrought-steel fittings and 150 lb. Carbon-steel flanges and flange fittings, and welded joints; flanged joints at valves, piping specialties and equipment connections.
- C. Chilled-water piping, aboveground, NPS 2 1/2 and smaller, shall be any of the following:
 - 1. Type L, drawn-temper copper tubing, wrought-copper fittings, and soldered joints.
 - 2. Schedule 40 steel pipe; Class 150, malleable-iron fittings and threaded joints.
- D. Chilled-water piping, aboveground, NPS 3 and larger, shall be the following:
 - 1. Schedule 40 steel pipe, wrought-steel fittings and 150 lb. carbon-steel flanges and flange fittings, and welded joints; flanged joints at valves, piping specialties and equipment connections.
- E. Condensate-Drain Piping: Type DWV, drawn-temper copper tubing, wrought-copper fittings, and soldered joints.
- F. Air-Vent Piping:
 - 1. Inlet: Same as service where installed.
 - 2. Outlet: Type K, annealed-temper copper tubing with soldered joints.
- G. Safety-Valve-Inlet and -Outlet Piping for Hot-Water Piping: Same materials and joining methods as for piping specified for the service in which safety valve is installed.

3.2 VALVE APPLICATIONS

- A. Install shutoff-duty valves at each branch connection to supply mains, and at supply connection to each piece of equipment and elsewhere as indicated.
- B. Install check valves at each pump discharge and elsewhere as required to control flow direction.

3.3 PIPING INSTALLATIONS

- A. Drawing plans, schematics, and diagrams indicate general location and arrangement of piping systems. Indicate piping locations and arrangements if such were used to size pipe and calculate friction loss, expansion, pump sizing, and other design considerations. Install piping as indicated unless deviations to layout are approved on Coordination Drawings.
- B. Install piping in concealed locations, unless otherwise indicated and except in equipment rooms and service areas.
- C. Install piping indicated to be exposed and piping in equipment rooms and service areas at right angles or parallel to building walls. Diagonal runs are prohibited unless specifically indicated otherwise.
- D. Install piping above accessible ceilings to allow sufficient space for ceiling panel removal.
- E. Install piping to permit valve servicing.
- F. Install piping at indicated slopes.
- G. Install piping free of sags and bends.
- H. Install fittings for changes in direction and branch connections.
- I. Install piping to allow application of insulation.

- J. Select system components with pressure rating equal to or greater than system operating pressure.
- K. Install groups of pipes parallel to each other, spaced to permit applying insulation and servicing of valves.
- L. Install drains, consisting of a tee fitting, NPS 3/4 ball valve, and short NPS 3/4 threaded nipple with cap, at low points in piping system mains and elsewhere as required for system drainage.
- M. Install piping at a uniform grade of 0.2 percent upward in direction of flow.
- N. Reduce pipe sizes using eccentric reducer fitting installed with level side up.
- O. Install branch connections to mains using mechanically formed tee fittings in main pipe, with the branch connected to the bottom of the main pipe. For up-feed risers, connect the branch to the top of the main pipe.
- P. Install valves according to Section 23 0523 "General-Duty Valves for HVAC Piping."
- Q. Install unions in piping, NPS 2 and smaller, adjacent to valves, at final connections of equipment, and elsewhere as indicated.
- R. Install flanges in piping, NPS 2-1/2 and larger, at final connections of equipment and elsewhere as indicated.
- S. Install strainers on inlet side of each control valve, pressure-reducing valve, solenoid valve, in-line pump, and elsewhere as indicated. Install NPS 3/4 nipple and ball valve in blowdown connection of strainers NPS 2 and larger. Match size of strainer blowoff connection for strainers smaller than NPS 2.
- T. Identify piping as specified in Section 23 0553 "Identification for HVAC Piping and Equipment."
- U. Install sleeves for piping penetrations of walls, ceilings, and floors. Comply with requirements for sleeves specified in Section 23 0517 "Sleeves and Sleeve Seals for HVAC Piping."
- V. Install sleeve seals for piping penetrations of concrete walls and slabs. Comply with requirements for sleeve seals specified in Section 23 0517 "Sleeves and Sleeve Seals for HVAC Piping."
- W. Install escutcheons for piping penetrations of walls, ceilings, and floors. Comply with requirements for escutcheons specified in Section 23 0518 "Escutcheons for HVAC Piping."

3.4 HANGERS AND SUPPORTS

- A. Hanger, support, and anchor devices are specified in Section 23 0529 "Hangers and Supports for HVAC Piping and Equipment." Comply with the following requirements for maximum spacing of supports.
- B. Vibration controls are specified in Section 23 0548 "Vibration and Seismic Controls for HVAC Piping and Equipment."
- C. Install the following pipe attachments:
 - 1. Adjustable steel clevis hangers for individual horizontal piping less than 20 feet long.
 - 2. Adjustable roller hangers and spring hangers for individual horizontal piping 20 feet or longer.
 - 3. Pipe Roller: MSS SP-58, Type 44 for multiple horizontal piping 20 feet or longer, supported on a trapeze.

4. Spring hangers to support vertical runs.
 5. Provide copper-clad hangers and supports for hangers and supports in direct contact with copper pipe.
- D. Install hangers for steel piping with the following maximum spacing and minimum rod sizes:
1. NPS 3: Maximum span, 12 feet; minimum rod size, 3/8 inch.
 2. NPS 4: Maximum span, 12 feet; minimum rod size, 1/2 inch.
 3. NPS 6: Maximum span, 12 feet; minimum rod size, 1/2 inch.
 4. NPS 8: Maximum span, 12 feet; minimum rod size, 5/8 inch.
- E. Install hangers for drawn-temper copper piping with the following maximum spacing and minimum rod sizes:
1. NPS 3/4: Maximum span, 5 feet; minimum rod size, 1/4 inch.
 2. NPS 1: Maximum span, 6 feet; minimum rod size, 1/4 inch.
 3. NPS 1-1/2: Maximum span, 8 feet; minimum rod size, 3/8 inch.
 4. NPS 2: Maximum span, 8 feet; minimum rod size, 3/8 inch.
 5. NPS 2-1/2: Maximum span, 9 feet; minimum rod size, 3/8 inch.
- F. Support vertical runs at roof, at each floor, and at 10-foot intervals between floors.

3.5 PIPE JOINT CONSTRUCTION

- A. Ream ends of pipes and tubes and remove burrs. Bevel plain ends of steel pipe.
- B. Remove scale, slag, dirt, and debris from inside and outside of pipe and fittings before assembly.
- C. Soldered Joints: Apply ASTM B 813, water-flushable flux, unless otherwise indicated, to tube end. Construct joints according to ASTM B 828 or CDA's "Copper Tube Handbook," using lead-free solder alloy complying with ASTM B 32.
- D. Threaded Joints: Thread pipe with tapered pipe threads according to ASME B1.20.1. Cut threads full and clean using sharp dies. Ream threaded pipe ends to remove burrs and restore full ID. Join pipe fittings and valves as follows:
 1. Apply appropriate tape or thread compound to external pipe threads unless dry seal threading is specified.
 2. Damaged Threads: Do not use pipe or pipe fittings with threads that are corroded or damaged. Do not use pipe sections that have cracked or open welds.
- E. Welded Joints: Construct joints according to AWS D10.12/D10.12M, using qualified processes and welding operators according to Part 1 "Quality Assurance" Article.
- F. Flanged Joints: Select appropriate gasket material, size, type, and thickness for service application. Install gasket concentrically positioned. Use suitable lubricants on bolt threads.

3.6 HYDRONIC SPECIALTIES INSTALLATION

- A. Install manual air vents at all high points in piping, at heat-transfer coils, and elsewhere as required for system air venting.
- B. Install automatic air vents at high points of system piping in mechanical equipment rooms only. Manual vents at heat-transfer coils and elsewhere as required for air venting.

3.7 TERMINAL EQUIPMENT CONNECTIONS

- A. Sizes for supply and return piping connections shall be the same as or larger than equipment connections.
- B. Install control valves in accessible locations close to connected equipment.
- C. Install ports for pressure gages and thermometers at coil inlet and outlet connections according to Section 23 0519 "Meters and Gages for HVAC Piping."

3.8 FIELD QUALITY CONTROL

- A. Prepare hydronic piping according to ASME B31.9 and as follows:
 - 1. Leave joints, including welds, uninsulated and exposed for examination during test.
 - 2. Provide temporary restraints for expansion joints that cannot sustain reactions due to test pressure. If temporary restraints are impractical, isolate expansion joints from testing.
 - 3. Flush hydronic piping systems with clean water; then remove and clean or replace strainer screens.
 - 4. Isolate equipment from piping. If a valve is used to isolate equipment, its closure shall be capable of sealing against test pressure without damage to valve. Install blinds in flanged joints to isolate equipment.
 - 5. Install safety valve, set at a pressure no more than one-third higher than test pressure, to protect against damage by expanding liquid or other source of overpressure during test.
- B. Perform the following tests on hydronic piping:
 - 1. Use ambient temperature water as a testing medium unless there is risk of damage due to freezing. Another liquid that is safe for workers and compatible with piping may be used.
 - 2. While filling system, use vents installed at high points of system to release air. Use drains installed at low points for complete draining of test liquid.
 - 3. Determine that hydronic system is full of water.
 - 4. Subject piping system to hydrostatic test pressure that is not less than 1.5 times the system's working pressure. Test pressure shall not exceed maximum pressure for any vessel, pump, valve, or other component in system under test. Verify that stress due to pressure at bottom of vertical runs does not exceed 90 percent of specified minimum yield strength or 1.7 times "SE" value in Appendix A in ASME B31.9, "Building Services Piping."
 - 5. After hydrostatic test pressure has been applied for at least 10 minutes, examine piping, joints, and connections for leakage. Eliminate leaks by tightening, repairing, or replacing components, and repeat hydrostatic test until there are no leaks.
 - 6. Prepare written report of testing.
- C. Perform the following before operating the system:
 - 1. Open manual valves fully.
 - 2. Inspect pumps for proper rotation.
 - 3. Set makeup pressure-reducing valves for required system pressure.
 - 4. Inspect air vents at high points of system and determine if all are installed and

operating freely (automatic type), or bleed air completely (manual type).

5. Set temperature controls so all coils are calling for full flow.
6. Verify lubrication of motors and bearings.

END OF SECTION