	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
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PART 1 - INTRODUCTION

- A. This standard refers to piping and welding requirements for both Building and Utility Systems. Refer to the Service Index matrix for other Standards applicable to pipe, and valve requirements.

PART 2 - PIPING SYSTEMS STEAM AND HYDRONIC


2.1 PIPING CODE COMPLIANCE

All piping systems (steam, condensate return, and chilled water) in all locations within the utility and building distribution system scope shall be designed, fabricated, erected, and tested in accordance with ASME B31.1.


2.2 DESIGN PARAMETERS

A. General

1. All piping systems and all components within the piping systems shall be designed for the "Maximum Design Pressure and Temperature" conditions listed below. These conditions are the maximum pressure and temperature that will be experienced in the piping system (exclusive of any type of water hammer). This includes thermal stress analyses and anchors for expansion joints where a pressure thrust force can be experienced. This is the "Design Pressure" per ASME B31.1. The steam maximum conditions are determined by safety relief valves in the steam generating equipment or pressure regulating valves in the CPP. The trap return maximum conditions are determined from the same values since isolation valves in the system can keep these pressures to the corresponding steam conditions. The pumped return maximum condition is an estimate of the highest conceivable dead head pressure of a condensate return pump.
2. The chilled water maximum pressure is the dead head point for the chilled water distribution pumps in the CPP and the cumulative static head pressure on the system. In instances where chilled water is decoupled from the plant with the use of a HX, the working pressure on the non-plant side of the HX shall be designed for a working pressure no less 150 psig, or greater where design conditions dictate.

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		


3. "Normal Operating" conditions are the system conditions where the utilities leave the CPP or downstream of distribution pressure regulating stations. Actual available steam or chilled water pressure at buildings will be lower due to the pressure drop through the distribution system. For the normal and minimum available pressures available at each building, request this data from Yale Utilities. Do not look at a pressure gage at a building and assume that pressure will always be available - pressures can drop significantly seasonally when demand peaks.
 4. This information is given as a general guide only. The Professional Consultant is responsible that pipe, fittings, etc. are suitable for service intended.
 5. All welding shall conform to workmanship, testing and general requirements of welding section ANSI B31.1 "Power Piping."
 6. Copper Piping
 - a. Do not allow T-drill fittings or similar products that extrude a branch from a main line.
 7. All workers shall be factory certified. This includes welding, soldering, Press-Connect, etc. Full factory warranty shall be specified for specialty piping such as Press-Connect.
 8. Underground piping shall be clean of debris/sediment and capped at each end from the time of arrival at the site to the time of install. If the piping is not protected and debris/sediment enter the pipe during installation, the contractor shall provide a credit for the cleaning process.
- B. Steam and steam condensate systems
1. General
 - a. Steam is distributed at various pressures. For new projects, discuss available pressures with Yale Utilities.
 - b. For thermal stress analyses, consider the install temperature to be no higher than 50 deg F. If work is to be installed outdoors, unprotected from the elements during the winter period, consider lowering the install temperature to something more appropriate.

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

2. High Pressure Steam: Designate this system as "HPS"
 - a. HPS - 250 PSIG (Primarily in Science Hill distribution from CPP)
 - 1) Maximum Design Pressure and Temperature: 300 PSIG at 410 deg. F
 - 2) Normal Operating Pressure and Temperature: 250 PSIG at 406 deg F (saturated)
 - b. HPS - 125 PSIG (Primarily in Central Campus distribution from CPP and all HPS of SPP)
 - 1) Maximum Design Pressure and Temperature: 150 PSIG at 366 deg F (saturated)
 - 2) Normal Operating Pressure and Temperature: 125 PSIG at 353 deg F (saturated)

3. Medium Pressure Steam: Designate this system as "MPS".
 - a. For each project, refer to Yale Utilities for possibly using "Maximum Design Pressure and Temperature" conditions for HPS system so that in the future, the piping system can be converted to HPS with no modifications except for replacing steam traps and re-insulating. This way, the new piping system will be designed for thermal expansion and pressure and temperature for the higher conditions.
 - b. MPS - 70 PSIG (Primarily in Science Hill distribution from CPP)
 - 1) Maximum Design Pressure and Temperature: 80 PSIG at 324 deg F (saturated)
 - 2) Normal Operating Pressure and Temperature: 70 PSIG at 316 deg F (saturated)
 - c. MPS - 30 PSIG (Primarily in Central Campus distribution from CPP)
 - 1) Maximum Design Pressure and Temperature: 40 PSIG at 287 deg F (saturated)
 - 2) Normal Operating Pressure and Temperature: 30 PSIG at 274 deg F (saturated)

4. Low Pressure Steam: Designate this system as "LPS" (Primarily in Central Campus distribution from CPP and all LPS of SPP).

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		


- a. For each project, refer to Yale Utilities for possibly using "Maximum Design Pressure and Temperature" conditions for HPS or MPS system so that in the future, the piping system can be converted to HPS or MPS with no modifications except for replacing steam traps and re-insulating. This way, the new piping system will be designed for thermal expansion and pressure and temperature for the higher conditions.
 - 1) Maximum Design Pressure and Temperature: 20 PSIG at 259 deg F (saturated)
 - 2) Normal Operating Pressures and Temperature: 10 PSIG at 239 deg F (saturated)

5. Condensate Return

- a. General
 - 1) Condensate return consists of trap returns from the distribution system and pumped returns from the buildings and distribution steam condensate return packages. In some cases, trap condensate from the distribution system is connected directly to the pumped return line. This is no longer allowed, and all existing connections of this type are being retrofitted. If you discover this condition in an area where you are performing design, please ask Yale Utilities if it should be retrofitted. All high pressure and medium pressure distribution trap returns shall be flashed in tunnels to low pressure steam systems (complete with relief valve) and all low pressure traps shall be gravity returned. For thermal stress analyses, consider the install temperature to be no higher than 50 deg F.

6. Trap Returns

- a. All trap returns design and operating pressures and temperatures shall match the steam conditions, i.e., trap returns from an "HPS" steam trap shall have maximum design pressure and temperature of 300 PSIG at 410 deg. F.
- b. Trap return piping shall be labeled as follows:
 - 1) From "HPS" traps: "HPC" for high pressure condensate or "HPR" for high pressure return.
 - 2) From "MPS" traps: "MPC" or "MPR".

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

3) From "LPS" traps: "LPC" or "LPR".

c. Where trap returns from different pressure systems join together upstream of a flash tank to atmosphere where they can be valved off, all of the trap return piping shall be designed for the higher-pressure system.

7. Pumped Returns:

a. Shall be labeled as "PC". Refer to "Condensate Return Units" for design of pumps.

b. Maximum Design Pressure and Temperature: 75 PSIG at 212 deg F. Note that in cases where trap returns discharge into the pumped return line, consideration should be made to increase the maximum design pressure to the trap system conditions.

c. Normal Operating Pressure and Temperature: Determine from Yale Utilities per the "Condensate Return Units" paragraph.

C. Chilled, Hot Water, Potable, and Non-Potable Systems

1. General

a. Piping shall be as specified for each particular system. Refer to Service Matrix for applicable Pipe Class Specification.

b. Water Piping, Above Ground 2 inches and under see Service Index for requirements:


- 1) Copper Pipe: types K or L
- 2) Fittings: cast copper alloy, wrought copper or bronze
- 3) Joints: flared or solder
- 4) Pro-press mechanical joints and fittings

2.3 VELOCITY AND PRESSURE DROP LIMITS

A. General

1. Pipes shall be sized to satisfy the more restrictive condition of velocity or pressure drop. In areas where noise may be an issue (basements or mechanical rooms), size lines for slower velocities.

2. Steam

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

- a. HPS and MPS Systems
 - 1) For 4" piping and lower: Maximum velocity shall be 8,000 FT/MIN. Maximum pressure drop shall be 0.5 PSID / 100 FT.
 - 2) For piping larger than 4": Maximum velocity shall be 12,000 FT/MIN. Maximum pressure drop shall be 0.5 PSID / 100 FT.

- b. LPS System
 - 1) For 4" piping and lower: Maximum velocity shall be 4,000 FT/MIN. Maximum pressure drop shall be 0.5 PSID / 100 FT.
 - 2) For piping larger than 4": Maximum velocity shall be 8,000 FT/MIN. Maximum pressure drop shall be 0.5 PSID / 100 FT.

- c. Condensate Return
 - 1) Trap Returns: Maximum velocity shall be 4,000 FT/MIN in consideration of two phase flow. Maximum pressure drop shall be 1 PSID / 100 FT.
 - 2) Pumped Returns: Maximum velocity shall be 10 FT/SEC. Maximum pressure drop shall be 1 PSID / 100 FT.

- d. Chilled, Hot, and Glycol Fluid
 - 1) For 2" piping and lower: Maximum velocity shall be 4 FT/SEC.
 - 2) For 2-1/2" piping and larger: Maximum velocity shall be 8 FT/SEC.
 - 3) Maximum pressure drop shall be 4 FT HD / 100 FT.


2.4 PIPING SYSTEM SPECIFICATIONS

A. General

1. Piping shall be as specified for each particular system. Victaulic, fiberglass, , and FRP piping are not acceptable. Refer to Service matrix for applicable Pipe Class Specification, at the end of this standard.

B. Country of Fabrication / ISO Registration

1. All piping, fittings, and specialties including expansion joints, strainers, etc. shall be


	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

manufactured, fabricated, and assembled in the United States or Canada, or they shall be by an ISO 9001 registered corporation. No piping, fittings, or specialties manufactured, fabricated, and/or assembled in China, Taiwan, or India are permitted on any project including those companies registered with ISO 9001.

2.5 TESTING

1. Copper Piping

- a. Specifications shall include language that allows the Owner to perform destructive testing of soldered or brazed joints at Owner's discretion and expense.
- b. When Owner elects to perform destructive testing, fabricated joints will be tested as follows:
 - 1) Test will ensure joints are minimum 80% penetrated around the full circumference of the joint and free of voids. Any joints exhibiting less than 80% penetration of the filler material will be considered to have failed the test.
 - 2) Owner shall pay for initial testing of the selected joints. The joint will be sliced and peeled apart (not heated) for inspection purposes.
 - 3) If the joint passes inspection, the Owner will pay for the reconstruction of the joint.
 - 4) If any of the joints fail, the contractor is responsible for the repair and subsequent destructive testing. The owner shall select two more joints at random (any size or location) to be tested at the contractor's expense for every failed joint.
 - 5) Owner or engineer reserves the right to test any additional joints they deem suspect at owner's expense. Reworking of any failed joints will be at contractor's expense.
- c. Domestic Water, Hydronic, and Air Piping Systems
 - 1) Piping underground and in chases and walls shall be tested before piping is concealed.
 - 2) Test piping before insulation is applied.
 - 3) If insulation is applied before pipe testing and a leak occurs which ruins the insulation, specify damaged insulation is replaced with new insulation by the Contractor at no cost to the Owner.
 - 4) Specify a test pressure of 150 psig water pressure.

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

- 5) Hold test pressure for minimum 4 hours.
 - 6) Specify the test is witnessed by the Owner's Representative.
 - 7) If more than 3 solder joints leak within the one year warranty, the contractor shall extend the original warranty to a period of 2 years from the date of substantial completion. Warranty shall cover material and labor on all solder joints within original scope of project along with all damages to the building that result from a leak.
- a. Refrigerant Systems
- 1) Test system with dry nitrogen at maximum working pressure for a minimum of four hours. Owner Representative to witness test.

PART 3 - WELDING


3.1 A. WELDING REQUIREMENTS

A. General

1. Weld pipe joints only when ambient temperature is above 0 degree F where possible.
2. Bevel pipe ends at a 37.5 degree angle where possible, smooth rough cuts, and clean to remove slag, metal particles, and dirt.
3. Use pipe clamps or tack-weld joints with 1 inch long welds; 4 welds for pipe sizes to 10 inches, 8 welds for pipe sizes 12 inches to 20 inches.
4. Build up welds with stringer-bead pass, followed by hot pass, followed by cover or filler pass. Eliminate valleys at center and edges of each weld. Weld by procedures which will ensure elimination of unsound or unfused metal, cracks, oxidation, blow-holes, and non-metallic inclusions.
5. Do not weld-out piping system imperfections by tack-welding procedures; refabricate to comply with requirements.
6. If piping component ends are bored, such boring shall not result in the finished wall thickness after welding less than the minimum design thickness.
7. The inside diameters of piping components to be butt-welded shall be aligned as accurately as is practicable within existing commercial tolerances on diameters, wall thickness and out of roundness. Alignment shall be preserved during welding. The internal misalignment of the ends to be joined shall not exceed 0.05 inch.


B. Welding Processes

1. All welding on metal piping systems shall be performed using qualified welding

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

procedures and qualified welders and welding operators in accordance with Section IX of the ASME Boiler and Pressure Vessel Code.

2. All welding shall be performed by a process that is compatible with the work being welded and the working conditions. Shielded metal-arc welding (SMAW) shall not be used on work less than 3/16 inch thick.
 3. Work thicker than 3/16 inch shall have a root pass by the GTAW process with the back purged with argon and the balance of the weld may be completed by the SMAW process or other process as stated below.
 4. Welding shall be performed by using only one of the following processes:
 - a. Shielded Metal Arc Welding (SMAW), also known as "Stick" Welding
 - b. Gas Turgsten Arc Welding (GTAW), also known as TIG and Heliarc Welding
 - c. Submerged Arc Welding (SAW)
 - d. Metal Inert Gas Welding (MIG)
 5. Spray Rustoleum on welds after welding to prevent rust.
- C. Welding Grooves
1. The ends of steel pipe and fittings to be erected with butt welded joints shall be beveled to form welding grooves in accordance with ASME B16.25.
 2. Welding grooves for butt welded joints in pipe of unequal wall thickness shall be beveled in accordance with ASME Code for Pressure Piping B31.1.
- D. Backing Rings
1. Backing rings shall not be used.
- E. Cleaning of Welding
1. All slag or flux remaining on the bead of welding shall be completely removed before laying down the next successive bead and at the completion of the weld.
- F. Weld Quality
1. All welds shall have full penetration and complete fusion with a minimum of weld metal protruding on the inside of the pipe.
 2. The finished weld contour shall be uniform, with the toe or edge of the weld merging smoothly into the base material. Butt welds shall have a slight reinforcement build-up gradually from the toe or edge toward the center of the weld. The limitation on butt weld reinforcement shall be in accordance with ASME B31.1, Table 127.4.2 and

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

shall apply separately to both inside and outside surfaces of the joint. Fillet welds may be slightly concave on the furnished surface.

G. Socket Welding Joints

1. Where socket welding valves or fittings are used, the pipe shall be spaced with a minimum of 1/16 inch clearance between the end of the pipe and the socket so that no stresses will be imparted to the weld due to "bottoming" of the pipe in the socket. The fit between the socket and the pipe shall conform to applicable standards for socket weld fittings and in no case shall the inside diameter of the socket exceed the outside diameter of the pipe by more than 0.075 inches.


3.2 WELDER QUALIFICATIONS

A. Welding Procedures

1. In the form of a submittal, the Contractor shall record in detail and shall qualify the Welding Procedure Specifications for every welding procedure that he proposes. Procedures shall be developed for all metals included in the work. The procedures for making transition welds between different materials or between plates or pipes of different wall thickness shall be qualified. Qualification for each welding procedure shall conform to the requirements of ASME B31.1, and to this specification. The method for each system shall be fully described including the number of beads, the volts, the amperes, and the welding rod for various pipe thicknesses and materials. The welding procedures shall specify end preparation for butt welds including cleaning, alignment, and root openings. Preheat, interpass temperature control, and postheat treatment of welds shall be as required by approved welding procedures, unless otherwise indicated or specified. Approval of any procedure does not relieve the Contractor of the sole responsibility for producing acceptable welds. Welding procedures shall be identified individually and shall be clearly referenced to the type of welding required for this project. These procedures shall be the same as those used for all pipe welder qualification tests, all shop welds, and all field welds. The Contractor shall provide Procedure Qualification Records for all proposed Welding Procedure Specifications (WPS).

B. Welding Procedure Submittals

1. Submit the following:
 - a. Welding Procedure Specifications: Provide for each weld type. It is highly

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

- recommended that the Contractor use ASME Form E00006, QW-482 "Suggested Format for Welding Procedure Specification (WPS)".
- b. Procedure Qualification Records: Provide for each weld type. It is highly recommended that the Contractor use ASME Form E00007, QW-483 "Suggested Format for Procedure Qualification Record (PQR)".


C. Welder Qualification

1. WPQs: Provide welder qualifications for each welder for each weld type. It is highly recommended that the Contractor use ASME Form E00008, QW-484 "Suggested Format for Manufacturer's Record of Welder or Welding Operation Qualification Tests (WPQ)." The WPQs shall be performed under the witness of an independent agency. The witness shall be a representative of an independent testing agency, Authorized Inspector, or consultant, any of which must be approved by the National Certified Pipe Welding Bureau. The qualifying test segment must be a 2 inch nominal pipe size with wall thickness within range of the WPS. Tests position shall be "6G" per ASME Section IX.
2. Evidence of Continuity: Welder qualifications must be current. If the qualification test is more than 6 months old, provide record of welding continuity for each welder. Record of welding continuity shall show that the welder in question has performed welding to the procedure in question without a 6 month continuous span of inactivity since the date that the welder qualification test was passed for the submitted welding procedure. Record of welding continuity shall include, at a minimum, the welder's employer name and address, the date the welder qualification test was passed, and the dates indicating welding continuity including welding procedure for each date.
3. In lieu of providing WPQs and Evidence of Continuity, the Contractor may elect to have all welders qualified on-site by an Independent Testing Agency prior to beginning work. This may be required by Yale Utilities, especially on larger projects.

3.3 WELD RECORDS

A. General


1. For all welding within the scope of ASME B31.1, the Contractor shall submit for approval an administrative procedure for recording, locating, monitoring, and maintaining the quality of all welds to be performed on the project. This quality control document record shall include but not be limited to drawings and schedules

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

identifying location of each weld by individual number, identification of welder who performed each weld by individual welder's name, stamp number, date and WPS used.

2. After achieving qualification, but before being assigned work, each qualified person shall be assigned an identifying number by the Contractor that shall be used to identify all of his welds. A list of qualified persons with their respective numbers shall be submitted by the Contractor and shall be maintained accurately with deletions and additions reported promptly.
3. Upon completing a joint, the welder shall mark the pipe not more than 6 inches from the weld with the identifying number and the last two digits of the year in which the work was performed. Identification marks shall be made by using a rubber stamp or felt-tipped marker with permanent, weatherproof ink or other methods approved by the Engineer that do not deform the metal. For seam welds, identification marks shall be placed adjacent to the welds at 3-foot intervals. Identification by die stamps or electric etchers will not be allowed. The markers are to be provided by the Contractor. Substituting a map of welds with welders' names shall not be acceptable.

“See Following Page for Continuation”

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

PIPE CLASS SPECIFICATION SHEET

Pipe class: CT-01

Typical Services: Compressed Air, Condenser Water, CT Overflow, Diesel Generator Cooling, Domestic Hot Water Recirculation, Hot Non-potable Water, Indirect Drain, Instrument Air, Nitrogen, Non-potable Water, Potable Water, Process Vacuum, Sanitary Waste, Chilled Water, Heating Hot Water, and Tempered Water.

Rating: Pressure 150 psig at 200 degrees F

Codes: ANSI B31.1 (except systems falling under plumbing jurisdiction)

Pipe: Above ground: Copper, seamless, Type L, hard drawn, ASTM B88
Below ground: Copper, seamless, Type K, hard drawn, ASTM B88

Fittings: 2 Inches and Under: Wrought copper, ANSI B16.22 socket joint, B75,
2 1/2 Inches and Above: Wrought copper, ANSI B16.22 socket joint, B75

Flanges: Copper, socket joint, Class 125 FF

Unions: Copper, socket joint, Brass or bronze ring nut

Solder: 95-5 tin-antimony


Brazing: Brazing, ASTM B260; melting range, 1,185 Deg F to 1,300 Deg F; Aircosil 15 or Silphos

Notes:

1. For copper pipe 2 inches and below, use solder.
2. For copper pipe 2-1/2 inches and above, use brazing.
3. Piping and material for potable water systems shall be NSF 61 Annex G no-lead compliant. Solder joints shall be with approved no-lead solder.

END OF CT-01 SECTION

PIPE CLASS SPECIFICATION SHEET

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

Pipe class: CT-02

Typical Services:

SERVICE	MATERIAL
Domestic Hot and Cold Water - Aboveground	Copper, Type L - SPEC. NO. 1
Heating Water - Aboveground	Copper, Type L (2" and under) - SPEC. NO. 1
Chilled Water - Aboveground	Copper, Type L (2" and under) - SPEC. NO. 1
Condensate Drain	Copper, Type L - SPEC. NO. 1

NUMBER	ITEM	SPEC
SPEC. NO. 1	PIPE:	COPPER, TYPE L HARD TEMPER, ASTM B88
	JOINTS:	LEAD FREE NSF COMPLIANT PROGRESS TYPE
	FITTINGS:	LEAD FREE PROGRESS TYPE


Rating: Pressure 150 psig at 200 degrees F

Codes: ANSI B31.1 (except systems falling under plumbing jurisdiction)

Notes:

1. Piping and material for potable water systems shall be NSF 61 Annex G no-lead compliant.
2. Press-Connect fittings shall be Viega, with EPDM seals.
3. The installation for fittings shall adhere to the Viega Engineering Specifications.

END OF CT-02 SECTION

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

PIPE CLASS SPECIFICATION SHEET

Pipe class: CS-01

Typical Services: (Refer to Service Matrix)
 Chilled Water, Condenser Water, Condenser Water Equalization, Diesel Generator Cooling, HVAC Heating, Natural Gas, Fuel Oil.

Rating: Pressure 150 psi


Code: ASME B31.1

Pipe Sealant: Use of pipe sealant shall be rated for service and comply with applicable manufacture and Code requirements.

Pipe:


2 inches and under:	Carbon steel, black, ASTM A53, Type B, CW, Schedule 40, threaded and coupled. Schedule "STD".
2-1/2 inches through 24 inches	All pipe 2 -1/2 inches through 24 inches shall be electric resistance weld carbon steel conforming to ASTM A 53, Grade B. Pipe wall thickness shall be Schedule "STD" for all pipe sizes.
Pipe Nipples	All threaded carbon steel pipe nipples shall be Schedule "XS" conforming to ASTM A 106, Grade B.

Pipe class: CS-01 (Continued on following page)

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

CS-01 (Continued from previous page)

Pipe class: CS-01 (Continued)	<u>2 Inches and Under</u>	<u>2-1/2 through 24 Inches</u>	<u>Notes</u>
Joints	Joints 2 inches and smaller shall be threaded for carbon steel.	Joints 2-1/2 inches and larger shall be butt welded.	1,3
Flanges	Forged steel, threaded, Class 150 RF	Slip-on and weld neck, Class 150 RF, ASTM A105	
Gaskets	Gaskets shall be spirally wound, Type 316L stainless steel with non-asbestos filler material and carbon steel outer ring. Gaskets shall be 1/8 inch thick and conform to the flange face on which they are used. Acceptable products from acceptable manufacturers include: Flexitallic Style CG with Flexite Super Filler, manufactured by Flexitallic Inc., 6915 Hwy. 225, Deer Park, TX 77536; Phone Number (281) 479- 3491; or approved equal.		
Fittings	Fittings 2 inches and smaller shall be 150 pound screwed banded malleable iron threaded in accordance with ASME B16.3. Material shall conform to ASTM A 197.	Fittings 2-1/2 inches and larger shall be steel butt-welding type in accordance with ASME B16.9 and with the same wall thickness as the attached pipe. Material shall conform to ASTM A 234, Grade WPB.	2,3
Bolting	<p>Bolting materials shall be continuous threaded alloy steel studs threaded in accordance with ASME B18.2.1. Material shall conform to ASTM A 193, Grade B7. Nuts shall be heat-treated, heavy, hexagonal nuts, semi-finished and in accordance with ASME B18.2.2. Material shall conform to ASTM A 194, Grade 2H.</p> <p>Bolting materials shall be mild steel, hexagonal head bolts with heavy hexagonal nuts conforming to ASTM A 307, Grade B.</p>		
Unions	MI, black, 150 psi, ASTM A197, bronze to iron seats	Use flanges	
Sockolets	Forged steel, 3,000 psi, ASTM A105	None	
Weldolets	None	Standard weight, ASTM A105	


	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

Pipe class: CS-01 (Continued from previous page)

Notes:

1. All sizes shall be flanged where required to connect to flanged valves, fittings, or equipment.
2. Mitered branches may be used when reinforced according to ASME B31.1. Reinforcing shall consist of increased header thickness, increased outlet pipe thickness, strap or weld type reinforcement, welding type reinforcing saddles, or a combination of these methods.
3. Where Joints and fittings are connected to valves and or appurtenances the mechanical connection shall be threaded or flange type and rated for service. Exception, manhole valves and appurtenances shall be welded

Pipe class: CS-01 (End of Section)


	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

PIPE CLASS SPECIFICATION SHEET

Pipe class: CS-02
 Typical Services: (Refer to Service Matrix)
 Low, Medium, & High Pressure Steam
 Rating: Pressure 300 psi
 Code: ASME B31.1
 Pipe:

2 inches and under:	All pipe 2 inches and smaller shall be seamless carbon steel conforming to ASTM A 106, Grade B.
2-1/2 inches through 24 inches	All pipe 2-1/2 inches through 24 inches shall be seamless carbon steel conforming to ASTM A 106, Grade B. Pipe wall thickness shall be Schedule "XS" for 1/8" through 2" NPS pipe size and Schedule "STD" for 2-1/2" through 24".
Pipe Nipples	All threaded pipe nipples shall be Schedule "XS" conforming to ASTM A 106, Grade B.

Pipe class: CS-02 (Continued on following page)


	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

Pipe class: CS-02 (Continued from previous page)

	<u>2 Inches and Under</u>	<u>2-1/2 through 24 Inches</u>	<u>Notes</u>
Joints	Joints 2 inches and smaller shall be socket welded or Threaded per project drawings	Joints 2-1/2 inches and larger shall be butt welded.	1,3
Flanges	Flanges 24 inches and smaller shall be Class 300 welding neck type in accordance with ASME B16.5 and raised faced or as required to match the mating flange.	Material shall conform to ASTM A 105. Welding neck flanges shall be bored to match the same ID as the attached pipe.	
Gaskets	Gaskets shall be spirally wound, Type 316L stainless steel with non-asbestos filler material and carbon steel outer ring. Gaskets shall be 1/8 inch thick and conform to the flange face on which they are used. Acceptable products from acceptable manufacturers include: Flexitallic Style CG with Flexite Super Filler, manufactured by Flexitallic Inc., 6915 Hwy. 225, Deer Park, TX 77536; Phone Number (281) 479- 3491; or approved equal.		
Fittings	Fittings 2 inches and smaller shall be 3000 pound socket-weld in accordance with ASME B16.11 or ANSI Class (threaded) Material shall conform to ASTM A 105.	Fittings 2-1/2 inches and larger shall be steel butt-welding type in accordance with ASME B16.9 and with the same wall thickness as the attached pipe. Material shall conform to ASTM A 234, Grade WPB.	2,3
Bolting	Bolting materials shall be continuous threaded alloy steel studs threaded in accordance with ASME B1.1, Class 2A. Material shall conform to ASTM A 193, Grade B7. Nuts shall be heat-treated, heavy, hexagonal nuts, semi-finished and in accordance with ASME B18.2.2 and B1.1, Class 2B. Material shall conform to ASTM A 914, Grade 2H.		
Unions	Unions 2 inches and smaller shall be 3000 pound forged steel socket weld with steel to steel seats. Material shall conform to ASTM A 105.	Use flanges	
Sockolets	Forged steel, 3,000 psi, ASTM A105	None	
Weldolets	None	Standard weight, ASTM A105	


Notes:

- 1.) All sizes shall be flanged where required to connect to flanged valves, fittings, or equipment.
- 2.) Mitered branches may be used when reinforced according to ASME B31.1. Reinforcing shall consist of increased header thickness, increased outlet pipe thickness, strap or weld type reinforcement, welding type reinforcing saddles, or a combination of these methods.

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

- 3.) Where Joints and fittings are connected to valves and or appurtenances the mechanical connection shall be threaded or flange type and rated for service. Exception, manhole valves and appurtenances shall be welded.

Pipe class: CS-02 (End of Section)

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

PIPE CLASS SPECIFICATION SHEET

Pipe Class: CS-03

Typical Services: (Refer to Service Matrix)
 Condensate steam systems (Gravity, LP, MP, HP, and Pumped HPC, MPC, LPC)


Rating: Pressure 150 psi

Code: ASME B31.1

Pipe:

2 inches and under:	All pipe shall be electric resistance welded carbon steel conforming to ASTM A 53, Grade B. Pipe wall thickness shall be Schedule "XS" for 3/4" through 24".
2-1/2 inches through 24 inches	All pipe shall be electric resistance welded carbon steel conforming to ASTM A 53, Grade B. Pipe wall thickness shall be Schedule "XS" for 3/4" through 24".
Nipples (Threaded)	All threaded pipe nipples shall be Schedule "XS" conforming to ASTM A 106, Grade B.


Pipe class: CS-03 (Continued on following page)

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

Pipe class: CS-03 (Continued from previous page)


	<u>2 Inches and Under</u>	<u>2-1/2 through 24 Inches</u>	<u>Notes</u>
Joints	Joints 2 inches and smaller shall be socket welded or threaded.	Joints 2-1/2 inches and larger shall be butt welded.	1,3
Flanges	Flanges 24 inches and smaller shall be Class 150 welding neck type in accordance with ASME B16.5 and raised or flat faced as required to match the mating flange. Material shall conform to ASTM A 105. Welding neck flanges shall be bored to match the same ID as the attached pipe.		
Gaskets	Gaskets shall be spirally wound, Type 316L stainless steel with non-asbestos filler material and carbon steel outer ring. Gaskets shall be 1/8 inch thick and conform to the flange face on which they are used. Acceptable products from acceptable manufacturers include: Flexitallic Style CG with Flexite Super Filler, manufactured by Flexitallic Inc., 6915 Hwy. 225, Deer Park, TX 77536; Phone Number (281) 479- 3491; or approved equal.		
Fittings	Fittings 2 inches and smaller shall be 3000 pound socket-weld in accordance with ASME B16.11 or ANSI Class 2000 Threaded. Material shall conform to ASTM A 105.	Fittings 2-1/2 inches and larger shall be steel butt-welding type in accordance with ASME B16.9 and with the same wall thickness as the attached pipe. Material shall conform to ASTM A 234, Grade WPB.	2,3
Bolting	Bolting materials shall be continuous threaded alloy steel studs threaded in accordance with ASME B18.2.1. Material shall conform to ASTM A 193, Grade B7. Nuts shall be heat-treated, heavy, hexagonal nuts, semi-finished and in accordance with ASME B18.2.2. Material shall conform to ASTM A 194, Grade 2H.		
Unions	a. Unions 2 inches and smaller shall be 3000 pound forged steel socket weld with steel to steel seats. Material shall conform to ASTM A 105. b.	Use flanges	
Sockolets	Forged steel, 3,000 psi, ASTM A105	None	
Weldolets	None	Standard weight, ASTM A105	

Notes:

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
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- 1.) All sizes shall be flanged where required to connect to flanged valves, fittings, or equipment.
- 2.) Mitered branches may be used when reinforced according to ASME B31.1. Reinforcing shall consist of increased header thickness, increased outlet pipe thickness, strap or weld type reinforcement, welding type reinforcing saddles, or a combination of these methods.
- 3.) Where Joints and fittings are connected to valves and or appurtenances the mechanical connection shall be threaded or flange type and rated for service. Exception, manhole valves and appurtenances shall be welded

Pipe class: CS-03 (End of Section)

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

PIPE CLASS SPECIFICATION SHEET

Pipe class: CS-04

Typical Services: (Refer to Service Index)
Pumped Sanitary Waste Above Ground, Pumped Storm Drain

Rating: Pressure 125 psi at minus 20/350 degrees F

Pipe:


4 inches and under	ASTM A53B, Type F, CW, Schedule 40, galvanized, threaded and coupled
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Nipples Schedule 40

Miscellaneous:

Fittings	Galvanized, standard, threaded
Flanges	Forged steel, Class 150, galvanized, threaded
Unions	Galvanized, bronze-to-iron seat

Pipe class: CS-04 (End of Section)

	Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards	Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements
		Date: 08/01/21
		Author: Office of Facilities
CC: Project Folder		

PIPE CLASS SPECIFICATION SHEET

Pipe class: CI-01

Typical Services: (Refer to Service Index), Sanitary, Drain, and Vent


Rating: -

Codes: -

SANITARY, DRAIN and VENT PIPING

	<u>ABOVE GRADE</u>	<u>BELOW GRADE</u>
Pipe	Service weight No-hub Cast Iron – ASTM A74, ASTM A888, CISPI 301 and be marked with the collective material trade mark of the Cast Iron Soil and Pipe Institute	Service weight hub and spigot Cast Iron – ASTM A74, ASTM A888, CISPI 301 and be marked with the collective material trade mark of the Cast Iron Soil and Pipe Institute.
Couplings	CISPI 310, ASTM C 1277 or ASTM C 1540. Elastomeric sealing sleeve shall conform to ASTM C 564 and shall be provided with center stop.	-
Joints	4 inches and smaller – cast iron neoprene gasket with heavy duty stainless steel coupling and four stainless steel bands 5 inches to 10 inches – Cast Iron neoprene gasket with heavy duty stainless steel coupling and six stainless steel bands	Hub and spigot with compression gaskets conforming to ASTM C 564 and shall be tested to ASTM C 1563. Gaskets shall be compressed when piping is fully inserted.
Pipe Manufacturer	Charlotte Pipe	Charlotte Pipe
Coupling Manufacturer	Husky SD 4000	-
Remarks:	Provide in accordance with manufacturers requirements.	Minimum 2 inch pipe size permitted below grade. Provide in accordance with manufacturers requirements.

Pipe class: CI-01 (End of Section)

	<p>Title: YALE OFFICE OF FACILITIES PROCEDURE MANUAL Chapter: 01 - Yale Design Standard Division: HVAC Standards</p>	<p>Section: 23 21 13 Piping: Plumbing, Hydronic, Steam, Steam Condensate and Welding Requirements</p>
		<p>Date: 08/01/21</p>
		<p>Author: Office of Facilities</p>
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Date	Description of Change	Pages / Sections Modified	ID
6/15/16	Entire document	-	mlamore
08/01/21	Pipe material updated, CI-01. Viega Pro-Press for copper pipe 2 inches and smaller.	-	mlamore