

4. CALCULATION OF THE TIGHTENING TORQUES

Table 1A valid for High Strength Bolting imperial size:

- o ASTM A 193 B7
- o ASTM A320 L7
- o INCOLOY / INCONEL

using SW gasket (min seating pressure 10100psi – ASME VIII div. 2), RJ iron or soft steel gasket (18000psi – ASME VIII div.2) and RJ Stainless Steels and nickel alloy (26000psi – ASME VIII div.2)

TABLE 1A

Nominal bolt size [inch]	Non-coated bolts (f=0.16) [Nm]	Coated bolts (f=0.12) [Nm]	Lubricated bolt (f=0.10) [Nm]
½	80	60	50
¾	180	130	100
1	280	230	170
1 ¼	450	370	280
1 ½	650	540	400
1 ¾	1000	830	620
2	1300	1000	810
2 ¼	1500	1200	900
2 ½	2000	1600	1200
2 ¾	2600	2100	1600
3	4000	3300	2500
3 ½	4900	4000	3000
4	6400	5300	4000
4 ½	9000	7500	5800
5	12000	10000	7500
5 ½	16000	13300	10000
6	25000	20800	15600

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REVISION
6

SIZE
6

LANGUAGE
A

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SHEET
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