

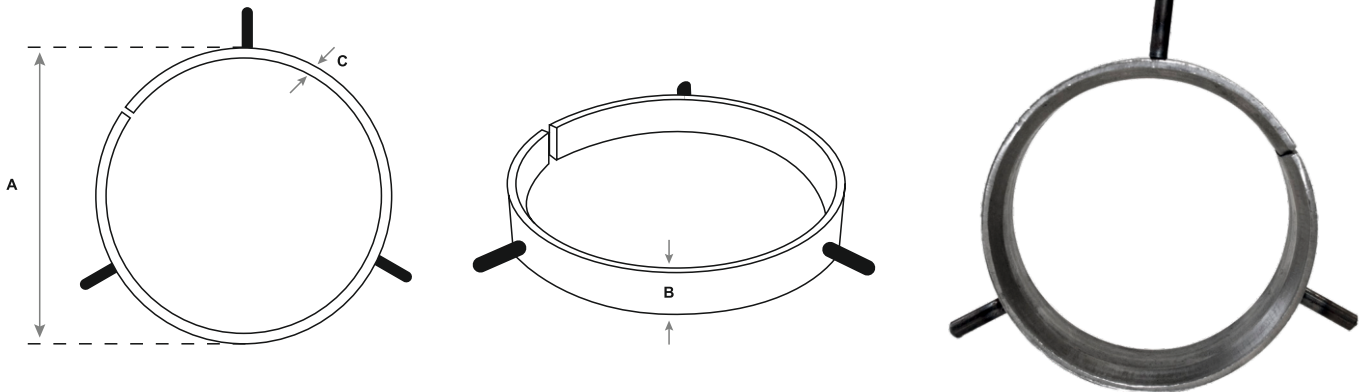


CUNIMET[®]
ALLOYS PVT. LTD.

CUNIMET ALLOYS PVT. LTD.
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BACKING (CHILL) RING

Specification: MIL-STD-22D
FIGURE 63



NOMINAL PIPE SIZE	P/N	A	B	C
1/4"	CHXY-040	0.205	3/4" (+/- 1/32")	1/8" (+/- 1/32")
3/8"	CHXY-060	0.330	3/4" (+/- 1/32")	1/8" (+/- 1/32")
1/2"	CHXY-100	0.455	3/4" (+/- 1/32")	1/8" (+/- 1/32")
3/4"	CHXY-150	0.705	3/4" (+/- 1/32")	1/8" (+/- 1/32")
1"	CHXY-200	0.955	3/4" (+/- 1/32")	1/8" (+/- 1/32")
1 1/4"	CHXY-250	1.205	3/4" (+/- 1/32")	1/8" (+/- 1/32")
1 1/2"	CHXY-300	1.455	3/4" (+/- 1/32")	1/8" (+/- 1/32")
2"	CHXY-400	1.955	3/4" (+/- 1/32")	1/8" (+/- 1/32")
2 1/2"	CHXY-450	2.435	1" (+/- 1/32")	3/16" MAX
3"	CHXY-500	2.935	1" (+/- 1/32")	3/16" MAX
3 1/2"	CHXY-550	3.435	1" (+/- 1/32")	3/16" MAX
4"	CHXY-600	3.935	1" (+/- 1/32")	3/16" MAX
5"	CHXY-700	4.935	1" (+/- 1/32")	3/16" MAX
6"	CHXY-800	5.935	1" (+/- 1/32")	3/16" MAX
8"	CHXY-900	7.935	1" (+/- 1/32")	3/16" MAX
10"	CHXY-1000	9.935	1" (+/- 1/32")	3/16" MAX
12"	CHXY-1100	11.935	1" (+/- 1/32")	3/16" MAX

AVAILABLE ALLOYS:

(FERROUS) CARBON STEEL (A105) &
STAINLESS STEEL (GRADES 304 / 316 / 321 / 347)

(NON-FERROUS)

CUNI (90/10 & 70/30), NICU (MONEL), ALUMINUM

NOTES: For P/N's:

Replace **X** with the following codes for Material:

Stainless Steel 304 - **304** Nicu (Monel) - **M**
Stainless Steel 316 - **316** Aluminum - **A**
Stainless Steel 321 - **321** Cuni 70/30 - **7**
Stainless Steel 347 - **347** Cuni 90/10 - **9**
Carbon Steel - **CS**

Replace **Y** with the following codes for Pressure:

Class 200 - **200** Schedule 40 - **40**
Class 700 - **700** Schedule 80 - **80**
Schedule 160 - **160**

Backing Rings are designed for quick, easy alignment of pipe, tube, fittings, valves and assure precise, close tolerance fit-up. They allow complete penetration and fusion of the weld and radiograph perfect certified welds. The 3/4" long spacer nubs automatically set the weld gap for the root-pass. The internal bevel and flat inner lands assure non-restricted fluid flow. Backing Rings are manufactured with the 3/32" ring gap on sizes 4" and smaller and 1/8" on sizes 5" and larger.



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