

**W1450 INTEGRALLY REINFORCED WELD BRANCHES**

QUANTITY: (6) COPIES

FORWARD DELIVERABLES HEREIN TO:  
NEWPORT NEWS SHIPBUILDING  
4101 WASHINGTON AVENUE  
NEWPORT NEWS, VA 23607  
ATTN: E45 SOFTWARE COORDINATOR  
BLDG. 635-6

THESE FITTINGS SHALL HAVE SUFFICIENT INTEGRAL REINFORCEMENT, INCLUDING ATTACHMENT WELD, TO ASSURE THAT THE STRENGTH OF THE PIPE TO WHICH THE FITTINGS ARE ATTACHED IS NOT REDUCED. CALCULATIONS USED IN DETERMINING THIS AND DRAWINGS SHOWING ALL PERTINENT DIMENSIONS AND WELD DETAILS ARE TO BE FURNISHED, TO NNS FOR OUR APPROVAL PRIOR TO PRODUCTION. CALCULATIONS SHALL BE SIMILAR TO THOSE FOR ANSI STD B31.1.0 WITH AN INTERNAL CORROSION ALLOWANCE OF 0.050 INCHES DEDUCTED FOR THE RUN AND FITTING WALL THICKNESS. UNLESS OTHERWISE SPECIFIED IN THIS ORDER ALL FITTINGS SHALL BE CHAMFERED ON THE INLET BORE TO REDUCE TURBULENCE IN THE BRANCH.