

Coded Note Number: **W3080**

Revision: **C001**

Date: **December 19, 2019**

Title: **WELD REINFORCEMENT, MSS-SP-119 SUPPLEMENTAL REQUIREMENTS FOR CUNI FITTINGS**

1. Fittings fabricated from tube

1.1. Belled End Fittings.

1.1.1. The weld crown on the OD shall be in accordance with MIL-T-16420.

1.1.2. The tangent portion of street ends shall have any weld crown on the OD removed flush and smooth with the OD of the fitting.

1.1.3. Weld reinforcement on the ID of 0.015 inch maximum is permissible in the socket and transition portion of belled ends and the tangent portion of street ends. A weld reinforcement of 1/16 inch maximum on the ID applies in all other portions of the fitting.

1.2. Couplings.

1.2.1. The weld crown on the OD shall be in accordance with MIL-T-16420.

1.2.2. Weld reinforcement on the ID shall be removed flush and smooth from the entire length of the longitudinal weld.

2. Fittings fabricated from plate

2.1. Belled End Fittings.

2.1.1. A weld crown of 1/16 inch maximum on the longitudinal weld(s) is permissible on the OD.

2.1.2. The tangent portion of street ends shall have any weld crown on the OD removed flush and smooth with the OD of the fitting.

2.1.3. The weld reinforcement on the ID shall be removed flush and smooth from the socket and transition portion of belled ends prior to the beelling operation. Otherwise, a weld reinforcement of 1/16 inch maximum on the ID applies.

2.2. Couplings.

2.2.1. A weld crown of 0.015 inch maximum on the OD is permissible on the entire length of the longitudinal weld(s).

2.2.2. The weld reinforcement on the ID shall be removed flush and smooth for the entire length of the longitudinal weld(s).

3. All weld crowns and weld reinforcements shall be reasonably uniform.

4. Where welds are flush with adjacent surfaces, there shall be no crevice visible to the unaided eye.

Revision History Table		
Rev	Description	Revision Date
C001	Initial Issue	12/19/2019