

*Machining pipe flanges and specialty machined products for over 50 years*

## **Flange Re-Machining**

*From 1 part to thousands of parts in almost any metal!*

- Raised Face (most common) to Flat Faced
- Reducing Slip-On from blinds: putting a straight hole in center of a blind flange so that a smaller pipe can use it as a slip-on. Example 6" X 2" 150# RF Reducing SO will bolt to a 6" 150# outlet but allow a 2" pipe to be welded to the center in a slip-on fashion.
- Reducing Threaded from blinds: putting a pipe thread in center of a blind flange for a smaller threaded pipe. Example 4" X 1/2" 150# RF Reducing THD will bolt to a 4" 150# outlet but allow a 1/2" pipe to be screwed to the center. These are often times used as outlets for pressure gages or other testing.
- Reducing Socket-Welds from blinds: Same as the reducing slip-on above but a socket-weld outlet. Not as common but we can make that.
- Changing the bore (center) of a weldneck (butt weld) or socket weld flange to match a thinner wall pipe. Seamless pipe always has the same outside diameter but the inside diameter varies with the wall thickness of the pipe. Weldnecks and socket welds must match this. An XH flange can be made into a STD, a S/40 can be made into a S/10, etc. See the Pipe Chart attached.





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Pipe Size	OD	ID	Schedules	Wall	Est Wt LBS per Ft
1/8"	.405	.307	10, 10S	.049	.1863
		.269	40, STD, 40S	.068	.2447
		.215	80, XS, 80S	.095	.3145
1/4"	.540	.410	10, 10S	.065	.3297
		.364	40, STD, 40S	.089	.4248
		.302	80, XS, 80S	.119	.5351
3/8"	.675	.545	10, 10S	.065	.4235
		.493	40, STD, 40S	.091	.5676
		.423	80, XS, 80S	.126	.7398
1/2"	.840	.674	10, 10S	.083	.6710
		.622	40, STD, 40S	.109	.8510
		.546	80, XS, 80S	.147	1.088
3/4"	1.050	.466	160	.187	1.304
		.252	XX	.294	1.714
		.894	10, 10S	.083	.8572
1"	1.315	.824	40, STD, 40S	.113	1.131
		.742	80, XS, 80S	.154	1.474
		.614	160	.218	1.937
1 1/4"	1.660	.434	XX	.308	2.441
		1.097	10, 10S	.109	1.404
		1.049	40, STD, 40S	.133	1.679
1 1/2"	1.900	.957	80, XS, 80S	.179	2.172
		.815	160	.250	2.844
		.599	XX	.359	3.659
2"	2.375	1.442	10, 10S	.109	1.806
		1.380	40, STD, 40S	.140	2.273
		1.278	80, XS, 80S	.191	2.997
2 1/2"	2.875	1.160	160	.250	3.765
		.896	XX	.382	5.214
		1.682	10, 10S	.109	2.085
3"	3.500	1.610	40, STD, 40S	.145	2.718
		1.500	80, XS, 80S	.200	3.631
		1.337	160	.281	4.859
3 1/2"	4.000	1.100	XX	.400	6.408
		2.157	10, 10S	.109	2.638
		2.067	40, STD, 40S	.154	3.853
4"	4.500	1.939	80, XS, 80S	.218	5.022
		1.689	160	.344	7.462
		1.503	XX	.436	9.029
4 1/2"	5.000	2.635	10, 10S	.120	3.531
		2.469	40, STD, 40S	.203	5.793
		2.323	80, XS, 80S	.276	7.651
5"	5.563	2.125	160	.375	10.01
		1.771	XX	.552	13.70
		3.260	10, 10S	.120	4.332
6"	6.625	3.068	40, STD, 40S	.216	7.576
		2.900	80, XS, 80S	.300	10.25
		2.624	160	.438	14.32
8"	8.625	2.300	XX	.600	18.58
		3.760	10, 10S	.120	4.937
		3.548	40, STD, 40S	.226	9.109
10"	10.750	3.364	80, XS, 80S	.318	12.51
		2.728	XX	.636	22.85
		4.260	10, 10S	.120	5.613
12"	12.750	4.026	40, STD, 40S	.237	10.790
		3.826	80, XS, 80S	.337	14.98
		3.624	120	.438	19
14"	14.000	3.438	160	.531	22.51
		3.152	XX	.674	27.54
		4.260	10, 10S	.120	5.613
16"	16.000	4.026	40, STD, 40S	.237	10.790
		3.826	80, XS, 80S	.337	14.98
		3.624	120	.438	19
18"	18.000	3.438	160	.531	22.51
		3.152	XX	.674	27.54
		4.260	10, 10S	.120	5.613
20"	20.000	4.026	40, STD, 40S	.237	10.790
		3.826	80, XS, 80S	.337	14.98
		3.624	120	.438	19
24"	24.000	3.438	160	.531	22.51
		3.152	XX	.674	27.54
		4.260	10, 10S	.120	5.613
30"	30.000	4.026	40, STD, 40S	.237	10.790
		3.826	80, XS, 80S	.337	14.98
		3.624	120	.438	19
36"	36.000	3.438	160	.531	22.51
		3.152	XX	.674	27.54
		4.260	10, 10S	.120	5.613
48"	48.000	4.026	40, STD, 40S	.237	10.790
		3.826	80, XS, 80S	.337	14.98
		3.624	120	.438	19

Pipe Size	OD	ID	Schedules	Wall	Est Wt LBS per Ft
4 1/2"	5.000	4.506	STD, 40S	.247	12.54
		4.290	XS, 80S	.355	17.61
5"	5.563	5.295	10, 10S	.134	7.770
		5.047	40, STD, 40S	.258	14.62
		4.813	80, XS, 80S	.375	20.78
		4.563	120	.500	27.04
		4.313	160	.625	32.96
		4.063	XX	.750	38.55
6"	6.625	6.357	10, 10S	.134	9.290
		6.065	40, STD, 40S	.280	18.97
		5.761	80, XS, 80S	.432	28.57
		5.501	120	.562	35.39
		5.189	160	.719	43.35
		4.897	XX	.864	53.16
8"	8.625	8.329	10, 10S	.148	13.40
		8.125	20	.250	22.36
		8.071	30	.277	24.70
		7.981	40, STD, 40S	.322	28.55
		7.813	60	.406	35.64
		7.625	80, XS, 80S	.500	43.39
		7.439	100	.594	50.95
		7.189	120	.719	61.71
		7.001	140	.812	67.76
		6.813	160	.906	74.79
		6.875	XX	.875	72.42
		10"	10.750	10.420	10, 10S
10.250	20			.250	28.04
10.136	30			.307	34.24
10.020	40, STD, 40S			.365	40.48
9.750	60, XS, 80S			.500	54.74
9.564	80			.594	64.43
9.314	100			.719	77.03
9.064	120			.844	82.29
12"	12.750	8.750	140, XX	1.000	104.1
		8.500	160	1.125	115.6
12"	12.750	12.390	10, 10S	.180	24.16
		12.250	20	.250	33.38
		12.090	30	.330	43.77
		12.000	STD, 40S	.375	49.56
		11.938	40	.406	53.52
		11.750	XS, 80S	.500	65.42
		11.626	60	.562	73.15
		11.376	80	.688	88.63
		11.064	100	.844	107.9
		10.750	120, XX	1.000	125.5
		10.500	140	1.125	136.7
		10.126	160	1.312	150.3
14"	14.000	13.624	10S	.188	27.73
		13.500	10	.250	36.71
		13.375	20	.312	45.61
		13.250	30, STD, 40S	.375	54.57
		13.124	40	.438	63.44
		13.000	XS, 80S	.500	72.09
		12.814	60	.594	85.05
		12.500	80	.750	106.1
		12.124	100	.938	130.9
		11.814	120	1.09	150.8
		11.500	140	1.250	170.2
		11.188	160	1.406	189.1