International Standard 6761

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION•МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ•ORGANISATION INTERNATIONALE DE NORMALISATION

Steel tubes — Preparation of ends of tubes and fittings for welding

Tubes en acier — Façonnage des extrémités de tubes et d'accessoires tubulaires à souder

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Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 6761 was developed by Technical Committee ISO/TC 5, *Ferrous metal pipes and metallic fittings*, and was circulated to the member bodies in December 1980.

It has been approved by the member bodies of the following countries :

Austria	Iraq	Poland
Brazil	Ireland	Romania
Czechoslovakia	Israel	South Africa, Rep. of
Egypt, Arab Rep. of	Italy	Spain
Finland	Japan	Sweden
France	Korea, Dem. P. Rep. of	Switzerland
Germany, F. R.	Korea, Rep. of	United Kingdom
Hungary	Netherlands	USA
India	Norway	USSR

The member body of the following country expressed disapproval of the document on technical grounds :

Australia

Printed in Switzerland

Steel tubes — Preparation of ends of tubes and fittings for welding

1 Scope and field of application

This International Standard specifies the most usual preparation of ends of tubes and of ends of fittings for welding.

2 Symbols

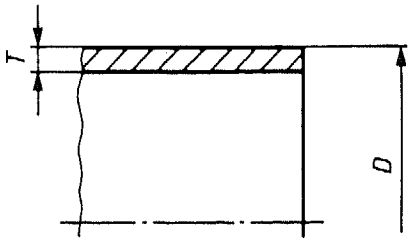
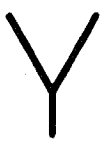
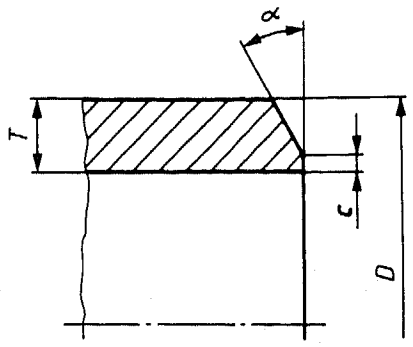
T = Thickness in millimetres

α = Angle of chamfer in degrees

c = Root face width in millimetres

D = Tube outside diameter in millimetres

3 Preparation of ends

Thickness T mm	Designation	Symbols	Forms of ends	Dimensions	
				α degrees	Root face width c mm
$T < 3,2$	end cut perpendicularly			—	—
$3,2 < T < 22,2$	V-chamfer with flat			$30\ ^{+5}_{0}$ $37,5 \pm 2,5$	$1,6 \pm 0,8$