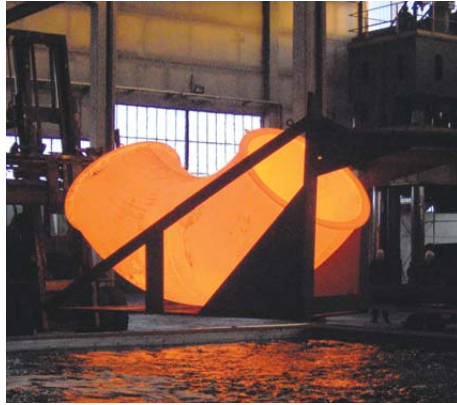
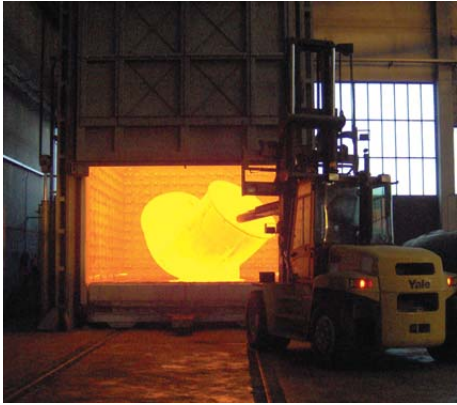


A Long Experience in Energy Equipment and one Goal:

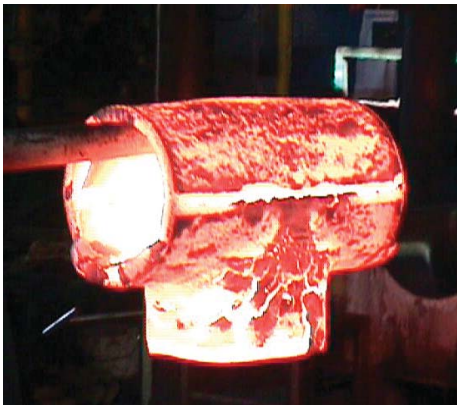
The Customer's satisfaction.



Butt Welding Fittings
in Stainless Steel and Exotic Alloys
for Severe Service.



Carbide Solution Annealing of a 72" Stainless Steel Elbow



Heavy Wall Duplex S.S. Tee under forging



20" sch. 140 Elbow according to UNS S31254 (SMO)



Typical Fittings in Stainless Steel and Exotic Alloys



Large Size Stainless Steel Fittings



Fittings after Pickling and Passivation

MATERIAL GRADE AND CHEMICAL COMPOSITION

AUSTENITIC STAINLESS STEEL TO ASTM A 403													
TRADE DESIGNATION	UNS	C MAX	Mn MAX	Si MAX	P MAX	S MAX	Cr MAX	Ni MAX	Mo MAX	Ti MAX	Nb MAX	Cu MAX	N MAX
304	UNS S30400	.080	2.00	1.00	.045	.030	18-20	8-11					
304L	UNS S30403	.035	2.00	1.00	.045	.030	18-20	8-13					
304H	UNS S30409	.04-10	2.00	1.00	.045	.030	18-20	8-11					
316	UNS S31600	.080	2.00	1.00	.045	.030	16-18	10-14	2.0-3.0				
316L	UNS S31603	.035	2.00	1.00	.045	.030	16-18	10-15	2.0-3.0				
316H	UNS S31609	.04-10	2.00	1.00	.045	.030	16-18	10-14	2.0-3.0				
316Ti		.070	2.00	1.00	.045	.030	16-18	10-14	2.0-3.0	.10-.70			
316 urea		.030	2.00	1.00	.045	.030	16-18	13 min	2.0-3.0				.20
321	UNS S32100	.080	2.00	1.00	.045	.030	17-20	9-13		.10-.70			
321H	UNS S32109	.04-10	2.00	1.00	.045	.030	17-20	9-13		.10-.70			
347	UNS S34700	.080	2.00	1.00	.045	.030	17-20	9-13			.10-.70		
347H	UNS S34709	.04-10	2.00	1.00	.045	.030	17-20	9-13			.10-.70		
SMO ®	UNS S31254	.020	1.00	.80	.030	.010	19.5-20.5	17.5-18.5	6.0-6.5			.50-1.0	.18-.22

DUPLEX & SUPER DUPLEX TO ASTM A 815													
TRADE DESIGNATION	UNS	C MAX	Mn MAX	Si MAX	P MAX	S MAX	Cr MAX	Ni MAX	Mo MAX	N MAX	Nb MAX	Cu MAX	W MAX
DUPLEX	UNS S31803	.030	2.00	1.00	.030	.020	21-23	4.5-6.5	2.5-3.5	.08-.20		0.30	
S.DUPLEX	UNS S32550	.040	1.50	1.00	.040	.030	24-27	4.5-6.5	2.9-3.9	.10-.25		1.5-2.5	
S.DUPLEX	UNS S32750	.030	1.20	.80	.035	.020	24-26	6-8	3-5	.24-.32		.50	
ZERON 100 ®	UNS S32760	.030	1.00	1.00	.030	.010	24-26	6-8	3-4	.20-.30		.50-1.0	.50-1.0

NICKEL ALLOYS TO ASTM B 366													
TRADE DESIGNATION	UNS	C MAX	Mn MAX	Si MAX	P MAX	S MAX	Cr MAX	Ni MAX	Mo MAX	Ti MAX	Fe MAX	Cu MAX	Nb MAX
MONEL 400 ®	UNS N04400	.30	2.00	.50		.024		63min			2.5	28 min	
ALLOY 20 ®	UNS N08020	.070	2.00	1.00	.045	.035	19-21	32-38	2.0-3.0		bal	3.0-4.0	
INCOLOY 800 ®	UNS N08800	.10	1.50	1.00		.015	19-23	30-35		.15-.60	39 min	.75	
INCOLOY 825 ®	UNS N08825	.050	1.00	.50		.030	19.5-23.5	38-46	2.5-3.5	.6-1.2	22.0	1.5-3.0	
INCONEL 600 ®	UNS N06600	.15	1.00	.50			14-17	72min			6-10	.50	
INCONEL 625 ®	UNS N06625	.10	.50	.50	.015	.015	20-23	58min	8-10	.40	5.00		3-5

TITANIUM TO ASTM B 363													
TRADE DESIGNATION	UNS	C MAX	Mn MAX	Si MAX	P MAX	S MAX	Cr MAX	Ni MAX	Mo MAX	Ti MAX	Nb MAX	Cu MAX	W MAX
WPT2		0.10								bal			
WPT12		0.08						0.6-0.9	0.2-0.4	bal			

MANUFACTURING PROGRAM

- Butt Welding Fittings

- Forged Long Radius Elbows up to 84"
- Forged Short Radius Elbows up to 56"
- Straight Tee pieces up to 84"
- Reducing Tee pieces up to 84"
- Concentric and Eccentric Reducers up to 100"
- Crosses up to 60"
- Caps up to 100"

- Special Fittings

- Bends 3D & 5D radius
- Special radius Elbows
- Barred Tees
- Flow Tees
- Split Tees
- Equal and Reducing Laterals

- Special Products

- Inlet & Outlet Headers
- Y type pieces
- Strainers
- Special Fittings as per Customer's drawing

All schedules in accordance with ASME B 36.19 / B 36.10 and up to 200 mm

Tecnoforge Castelsangiovanni Plant



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