



U S S R S T A T E S T A N D A R D

FLANGES FOR FITTINGS AND PIPELINES

**for P_{nom} from 0.1 to 20.0 Mpa
(from 1 to 200 kgf/cm²)**

GOST 12815-80

**Official Edition
English Version Approved by Interstandard**

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**FLANGES FOR FITTINGS
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**GOST
12815-80**

Types. Connecting dimensions and dimensions
of sealing surfaces

**(CMEA STANDARD
3249-81,
CMEA STANDARD
3250-81,
CMEA STANDARD
3251-81)
In place of
GOST 1233-67 and
GOST 1234-67**

OKP (ALL-Union Product Classification Code) 37 9941

Date of introduction set by Decree No. 2238, dated 20.05.80, of the USSR State Committee for Standards

From 01.01.83

Restriction of validity is removed by Gosstandart Decree No. 402, dated 15.04.92

1. This Standard applies to flanges for pipelines and fittings, and also to connecting flanges for fittings, machines, devices, branch pipes of devices and pressure tanks designed for nominal pressure P_{nom} from 0.1 to 20.0 MPa (from 1 up to 200 kgf/cm²) and medium temperature from 20 to 873 K (from -253 to 600 °C), and also to flanges with liners made from fluoroplastic-4 designed for nominal pressure P_{nom} from 0.1 to 20.0 MPa (from 1 to 200 kgf/cm²) and medium temperature from 73 to 473 K (from -200 to 200 °C), and may be used for their certification.

This Standard does not apply to flanges for pipelines of transport machines if these flanges are not designed for connection of fittings or general-duty devices, and also to flanges standardized in accordance with GOST 1536-76 and GOST 4433-76.

Official Edition

Reprinting is prohibited

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*Revised Edition (December 1996) with Amendments Nos. 1, 2, 3, 4 and 5, approved in March 1983, December 1983, December 1987, September 1989 and April 1992.
(IUS {Standards Information Catalog} 6-83, 3-84, 4-88, 12-89, 7-92).*

Correction is inserted (IUS {Standards Information Catalog} No. 11, 2005)

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The requirements of clauses 1 to 3; 5; 6 and 10 to 12 of this Standard are obligatory, other requirements are recommended.

(Amended Wording, Amendment No. 5).

2. Flange types and key parameters shall comply with those specified in table 1, the connecting dimensions, the dimensions and modifications of sealing surfaces shall comply with those specified in figs. 1 to 6 and in tables 2 to 11, except for dimensions of tenon-mortise sealing surfaces for fluoroplastic liners, which shall comply with those specified in fig. 6 and in table 12.

Table 1

Flange type	Nominal pressure P_{nom} , MPa (kgf/cm ²)	Nominal bore D_{nom} , mm
Cast from grey iron in accordance with GOST 12817-80	0.1; 0.25 (1; 2.5)	15 to 3 000
	0.6 (6)	15 to 2 400
	1.0 (10)	15 to 2 000
	1.6 (16)	15 to 1 000
Cast from malleable cast iron in accordance with GOST 12818-80	1.6; 2.5; 4.0 (16; 25; 40)	15 to 80
Cast from steel in accordance with GOST 12819-80	1.6 (16)	15 to 1 600
	2.5 (25)	15 to 1 400
	4.0 (40)	15 to 800
	6.3 (63)	15 to 600
	10 (100)	15 to 400
	16 (160)	15 to 300
Steel, flat, welded in accordance with GOST 12820-80	0.1; 0.25 (1; 2.5)	10 to 2 400
	0.6 (6)	10 to 1 600
	1.0 (10)	10 to 1 600
	1.6 (16)	10 to 1 200
	2.5 (25)	10 to 800
Steel, butt welded in accordance with GOST 12821-80	0.1; 0.25; 0.6 (1; 2.5; 6)	10 to 1 600
	1.0; 1.6; 2.5; 4.0 (10; 16; 25; 40)	10 to 1 200
	6.3 (63)	10 to 400; 500 to 1 200
	10 (100)	10 to 400
	16 (160)	15 to 300
	20 (200)	15 to 250
Steel, loose, ring welded in accordance with GOST 12822-80	0,1; 0,25; 0,6; 1,0; 1,6; 2,5 (1; 2,5; 6; 10; 16; 25)	10 to 500