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**PART 1 - GENERAL**

**1.01 RELATED DOCUMENTS**

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

**1.02 SUMMARY**

- A. Section Includes:
  - 1. Flexible-hose packless expansion joints.
  - 2. Metal-bellows packless expansion joints.
  - 3. Rubber packless expansion joints.
  - 4. Grooved-joint expansion joints.
  - 5. Pipe loops and swing connections.
  - 6. Alignment guides and anchors.

**1.03 PERFORMANCE REQUIREMENTS**

- A. Compatibility: Products shall be suitable for piping service fluids, materials, working pressures, and temperatures.
- B. Capability: Products to absorb 200 percent of maximum axial movement between anchors.

**1.04 SUBMITTALS**

- A. Product Data: For each type of product indicated.
- B. Delegated-Design Submittal: For each anchor and alignment guide indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.
  - 1. Design Calculations: Calculate requirements for thermal expansion of piping systems and for selecting and designing expansion joints, loops, and swing connections.
  - 2. Anchor Details: Detail fabrication of each anchor indicated. Show dimensions and methods of assembly and attachment to building structure.
  - 3. Alignment Guide Details: Detail field assembly and attachment to building structure.
  - 4. Schedule: Indicate type, manufacturer's number, size, material, pressure rating, end connections, and location for each expansion joint.
- C. Welding certificates.
- D. Product Certificates: For each type of expansion joint, from manufacturer.

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- E. Maintenance Data: For expansion joints to include in maintenance manuals.

**1.05 QUALITY ASSURANCE**

- A. Welding Qualifications: Qualify procedures and personnel according to the following:
1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
  2. ASME Boiler and Pressure Vessel Code: Section IX.

**PART 2 - PRODUCTS**

**2.01 PACKLESS EXPANSION JOINTS**

- A. Flexible-Hose Packless Expansion Joints:
1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
  2. Basis-of-Design Product: Subject to compliance with requirements, provide product indicated on Drawings or comparable product by one of the following:
    - a. Flex-Hose Co., Inc.
    - b. Flexicraft Industries.
    - c. Flex Pression Ltd.
    - d. Metraflex, Inc.
    - e. Unisource Manufacturing, Inc.
  3. Description: Manufactured assembly with inlet and outlet elbow fittings and two flexible-metal-hose legs joined by long-radius, 180-degree return bend or center section of flexible hose.
  4. Flexible Hose: Corrugated-metal inner hoses and braided outer sheaths.
  5. Expansion Joints for Copper Tubing NPS 2 (DN 50) and Smaller: Copper-alloy fittings with solder-joint end connections.
    - a. Bronze hoses and single-braid bronze sheaths with 450 psig at 70 deg F (3100 kPa at 21 deg C) and 340 psig at 450 deg F (2340 kPa at 232 deg C) ratings.
    - b. Bronze hoses and double-braid bronze sheaths with 700 psig at 70 deg F (4830 kPa at 21 deg C) and 500 psig at 450 deg F (3450 kPa at 232 deg C) ratings.
  6. Expansion Joints for Copper Tubing NPS 2-1/2 to NPS 4 (DN 65 to DN 100): Copper-alloy fittings with threaded end connections.
    - a. Stainless-steel hoses and single-braid, stainless-steel sheaths with 300 psig at 70 deg F (2070 kPa at 21 deg C) and 225 psig at 450 deg F (1550 kPa at 232 deg C) ratings.
    - b. Stainless-steel hoses and double-braid, stainless-steel sheaths with 420 psig at 70 deg F (2890 kPa at 21 deg C) and 315 psig at 450 deg F (2170 kPa at 232 deg C) ratings.

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7. Expansion Joints for Steel Piping NPS 2 (DN 50) and Smaller: Stainless-steel fittings with threaded end connections.
    - a. Stainless-steel hoses and single-braid, stainless-steel sheaths with 450 psig at 70 deg F (3100 kPa at 21 deg C) and 325 psig at 600 deg F (2250 kPa at 315 deg C) ratings.
    - b. Stainless-steel hoses and double-braid, stainless-steel sheaths with 700 psig at 70 deg F (4830 kPa at 21 deg C) and 515 psig at 600 deg F (3550 kPa at 315 deg C) ratings.
  8. Expansion Joints for Steel Piping NPS 2-1/2 to NPS 6 (DN 65 to DN 150): Stainless-steel fittings with flanged end connections.
    - a. Stainless-steel hoses and single-braid, stainless-steel sheaths with 200 psig at 70 deg F (1380 kPa at 21 deg C) and 145 psig at 600 deg F (1000 kPa at 315 deg C) ratings.
    - b. Stainless-steel hoses and double-braid, stainless-steel sheaths with 275 psig at 70 deg F (1900 kPa at 21 deg C) and 200 psig at 600 deg F (1380 kPa at 315 deg C) ratings.
  9. Expansion Joints for Steel Piping NPS 8 to NPS 12 (DN 200 to DN 300): Stainless-steel fittings with flanged end connections.
    - a. Stainless-steel hoses and single-braid, stainless-steel sheaths with 125 psig at 70 deg F (860 kPa at 21 deg C) and 90 psig at 600 deg F (625 kPa at 315 deg C) ratings.
    - b. Stainless-steel hoses and double-braid, stainless-steel sheaths with 165 psig at 70 deg F (1130 kPa at 21 deg C) and 120 psig at 600 deg F (830 kPa at 315 deg C) ratings.
- B. Metal-Bellows Packless Expansion Joints:
1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
  2. Basis-of-Design Product: Subject to compliance with requirements, provide product indicated on Drawings or comparable product by one of the following:
    - a. AdSCO Manufacturing LLC.
    - b. American BOA, Inc.
    - c. Badger Industries, Inc.
    - d. Expansion Joint Systems, Inc.
    - e. Flex-Hose Co., Inc.
    - f. Flexicraft Industries.
    - g. Flex Pression Ltd.
    - h. Flex-Weld, Inc.
    - i. Flo Fab inc.
    - j. Hyspan Precision Products, Inc.
    - k. Metraflex, Inc.
    - l. Proco Products, Inc.
    - m. Senior Flexonics Pathway.
    - n. Tozen Corporation.
    - o. Unaflex.
    - p. Unisource Manufacturing, Inc.

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- q. Universal Metal Hose; a subsidiary of Hyspan Precision Products, Inc.
  - r. U.S. Bellows, Inc.
  - s. WahlcoMetroflex.
- 3. Standards: ASTM F 1120 and EJMA's "Standards of the Expansion Joint Manufacturers Association, Inc."
  - 4. Type: Circular, corrugated bellows with external tie rods.
  - 5. Minimum Pressure Rating: 175 psig (1200 kPa) unless otherwise indicated.
  - 6. Configuration: Single joint with base and double joint with base class(es) unless otherwise indicated.
  - 7. Expansion Joints for Copper Tubing: Single- or multi-ply phosphor-bronze bellows, copper pipe ends, and brass shrouds.
    - a. End Connections for Copper Tubing NPS 2 (DN 50) and Smaller: Solder joint or threaded.
    - b. End Connections for Copper Tubing NPS 2-1/2 to NPS 4 (DN 65 to DN 100): Solder joint or threaded.
    - c. End Connections for Copper Tubing NPS 5 (DN 125) and Larger: Flanged.
- C. Rubber Packless Expansion Joints:
- 1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
  - 2. Basis-of-Design Product: Subject to compliance with requirements, provide product indicated on Drawings or comparable product by one of the following:
    - a. Amber/Booth Company, Inc.; a div. of Vibration Isolation Products of Texas, Inc.
    - b. Flex-Hose Co., Inc.
    - c. Flexicraft Industries.
    - d. Flex-Weld, Inc.
    - e. Garlock Sealing Technologies.
    - f. General Rubber Corporation.
    - g. Mason Industries, Inc.; Mercer Rubber Co.
    - h. Metraflex, Inc.
    - i. Proco Products, Inc.
    - j. Red Valve Company, Inc.
    - k. Tozen Corporation.
    - l. Unaflex.
    - m. Unisource Manufacturing, Inc.
  - 3. Standards: ASTM F 1123 and FSA's "Technical Handbook: Non-Metallic Expansion Joints and Flexible Pipe Connectors."
  - 4. Material: Fabric-reinforced rubber complying with FSA-NMEJ-703.
  - 5. Arch Type: Single or multiple arches with external control rods.
  - 6. Spherical Type: Single or multiple spheres with external control rods.
  - 7. Minimum Pressure Rating for NPS 1-1/2 to NPS 4 (DN 40 to DN 100): 150 psig (1035 kPa) at 220 deg F (104 deg C).
  - 8. Minimum Pressure Rating for NPS 5 and NPS 6 (DN 125 and DN 150): 140 psig (966 kPa) at 200 deg F (93 deg C).
  - 9. Minimum Pressure Rating for NPS 8 to NPS 12 (DN 200 to DN 300): 140 psig (966 kPa) at 180 deg F (82 deg C).

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10. Material for Fluids Containing Acids, Alkalies, or Chemicals: BR, CSM or EPDM.
11. Material for Fluids Containing Gas, Hydrocarbons, or Oil: Buna-N or CR Material for Water: BR, Buna-N, CR, CSM, EPDM or NR.
12. End Connections: Full-faced, integral steel flanges with steel retaining rings.

#### 2.02 GROOVED-JOINT EXPANSION JOINTS

- A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
- B. Basis-of-Design Product: Subject to compliance with requirements, provide product indicated on Drawings or comparable product by one of the following:
  1. Anvil International, Inc.
  2. Shurjoint Piping Products.
  3. Victaulic Company.
- C. Description: Factory-assembled expansion joint made of several grooved-end pipe nipples, couplings, and grooved joints.
- D. Standard: AWWA C606, for grooved joints.
- E. Nipples: Galvanized, ASTM A 53/A 53M, Schedule 40, Type E or S, steel pipe with grooved ends.
- F. Couplings: Five, seven, 10 or 12, flexible type for steel-pipe dimensions. Include ferrous housing sections, Buna-N gasket suitable for diluted acid, alkaline fluids, and cold and hot water EPDM gasket suitable for cold and hot water, and bolts and nuts.

#### 2.03 ALIGNMENT GUIDES AND ANCHORS

- A. Alignment Guides:
  1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
  2. Basis-of-Design Product: Subject to compliance with requirements, provide product indicated on Drawings or comparable product by one of the following:
    - a. Adesco Manufacturing LLC.
    - b. Advanced Thermal Systems, Inc.
    - c. Flex-Hose Co., Inc.
    - d. Flexicraft Industries.
    - e. Flex-Weld, Inc.
    - f. Hyspan Precision Products, Inc.
    - g. Metraflex, Inc.
    - h. Senior Flexonics Pathway.
    - i. Unisource Manufacturing, Inc.
    - j. U.S. Bellows, Inc.

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3. Description: Steel, factory-fabricated alignment guide, with bolted two-section outer cylinder and base for attaching to structure; with two-section guiding spider for bolting to pipe.
- B. Anchor Materials:
1. Steel Shapes and Plates: ASTM A 36/A 36M.
  2. Bolts and Nuts: ASME B18.10 or ASTM A 183, steel hex head.
  3. Washers: ASTM F 844, steel, plain, flat washers.
  4. Mechanical Fasteners: Insert-wedge-type stud with expansion plug anchor for use in hardened portland cement concrete, with tension and shear capacities appropriate for application.
    - a. Stud: Threaded, zinc-coated carbon steel.
    - b. Expansion Plug: Zinc-coated steel.
    - c. Washer and Nut: Zinc-coated steel.
  5. Chemical Fasteners: Insert-type-stud, bonding-system anchor for use with hardened portland cement concrete, with tension and shear capacities appropriate for application.
    - a. Bonding Material: ASTM C 881/C 881M, Type IV, Grade 3, two-component epoxy resin suitable for surface temperature of hardened concrete where fastener is to be installed.
    - b. Stud: ASTM A 307, zinc-coated carbon steel with continuous thread on stud unless otherwise indicated.
    - c. Washer and Nut: Zinc-coated steel.

**PART 3 - EXECUTION**

**3.01 EXPANSION-JOINT INSTALLATION**

- A. Install expansion joints of sizes matching sizes of piping in which they are installed.
- B. Install metal-bellows expansion joints according to EJMA's "Standards of the Expansion Joint Manufacturers Association, Inc."
- C. Install rubber packless expansion joints according to FSA-NMEJ-702.
- D. Install grooved-joint expansion joints to grooved-end steel piping

**3.02 PIPE LOOP AND SWING CONNECTION INSTALLATION**

- A. Install pipe loops cold-sprung in tension or compression as required to partly absorb tension or compression produced during anticipated change in temperature.
- B. Connect risers and branch connections to mains with at least five pipe fittings including tee in main.
- C. Connect risers and branch connections to terminal units with at least four pipe fittings including tee in riser.

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- D. Connect mains and branch connections to terminal units with at least four pipe fittings including tee in main.

**3.03 ALIGNMENT-GUIDE AND ANCHOR INSTALLATION**

- A. Install alignment guides to guide expansion and to avoid end-loading and torsional stress.
- B. Install two guide(s) on each side of pipe expansion fittings and loops. Install guides nearest to expansion joint not more than four pipe diameters from expansion joint.
- C. Attach guides to pipe and secure guides to building structure.
- D. Install anchors at locations to prevent stresses from exceeding those permitted by ASME B31.9 and to prevent transfer of loading and stresses to connected equipment.
- E. Anchor Attachments:
  - 1. Anchor Attachment to Black-Steel Pipe: Attach by welding. Comply with ASME B31.9 and ASME Boiler and Pressure Vessel Code: Section IX, "Welding and Brazing Qualifications."
  - 2. Anchor Attachment to Galvanized-Steel Pipe: Attach with pipe hangers. Use MSS SP-69, Type 42, riser clamp welded to anchor.
  - 3. Anchor Attachment to Copper Tubing: Attach with pipe hangers. Use MSS SP-69, Type 24, U-bolts bolted to anchor.
- F. Fabricate and install steel anchors by welding steel shapes, plates, and bars. Comply with ASME B31.9 and AWS D1.1/D1.1M.
  - 1. Anchor Attachment to Steel Structural Members: Attach by welding.
  - 2. Anchor Attachment to Concrete Structural Members: Attach by fasteners. Follow fastener manufacturer's written instructions.
- G. Use grout to form flat bearing surfaces for guides and anchors attached to concrete.

**\*\* END OF SECTION \*\***