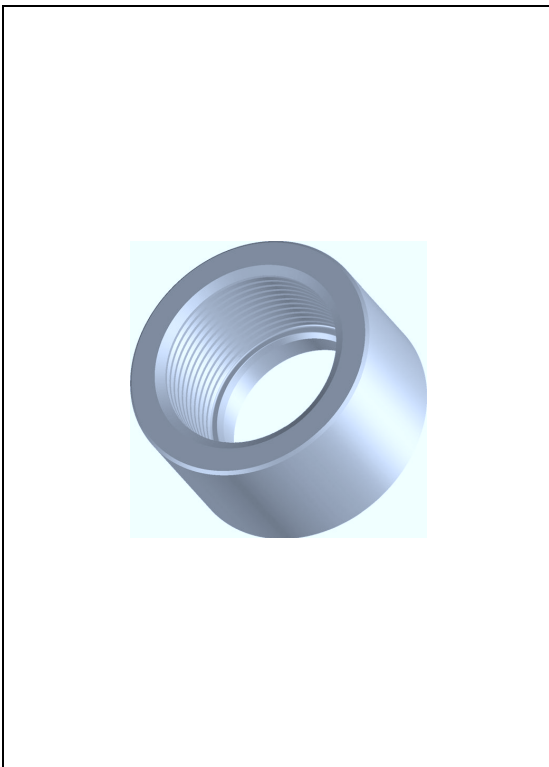


## Supplementary instructions

### Mounting bosses and adapters



Document ID:  
32036



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## 1 Product description

### **Welded socket**

Welded sockets are used for connection of level and pressure sensors to the process. Depending on the version, the process fitting is optional or belongs to the scope of delivery. Depending on the version, accessory parts such as welding dummies and blind stoppers are available.

### **Adapter**

Screwed adapters are used for adaptation of level and pressure sensors with connection G $\frac{3}{4}$  A or G1 $\frac{1}{2}$  A to existing welded sockets. Depending on the version, the seal is optional or belongs to the scope of delivery.

## 2 Welded socket - universal

### 2.1 Thread

#### Thread G $\frac{1}{2}$ A

#### Welded socket G $\frac{1}{2}$ A acc. to DIN 3852-X

Art. no. 2.36839

Material 316L

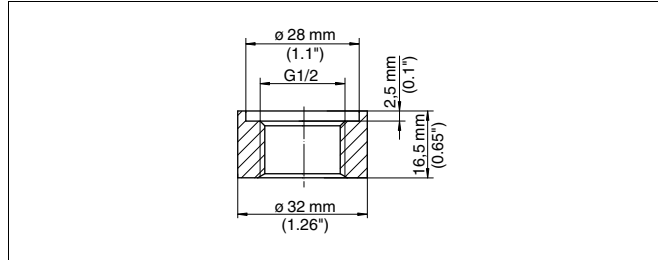


Fig. 1: Dimensions welded socket G $\frac{1}{2}$  A acc. to DIN 3852-X

#### Thread G $\frac{3}{4}$ A

#### Welded socket G $\frac{3}{4}$ A acc. to DIN 3852-X

Art. no. 2.36840

Material 316L

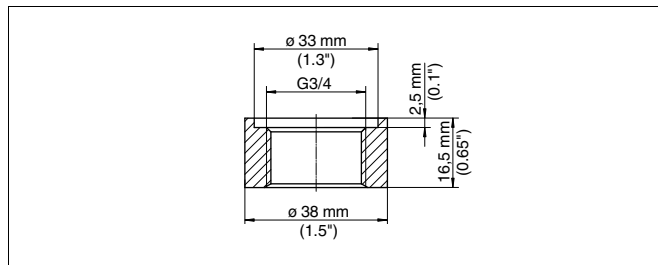


Fig. 2: Dimensions welded socket G $\frac{3}{4}$  A acc. to DIN 3852-X

#### Thread G1 A

#### Welded socket G1 A acc. to DIN 3852-X

Art. no. 2.36841

Material 316L

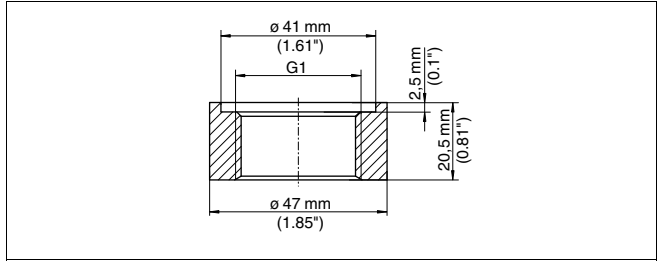


Fig. 3: Dimensions welded socket G1 A acc. to DIN 3852-X

**Thread G1½ A**

**Welded socket G1½ A acc. to DIN 3852-X**

Art. no. 36842

Material 316L

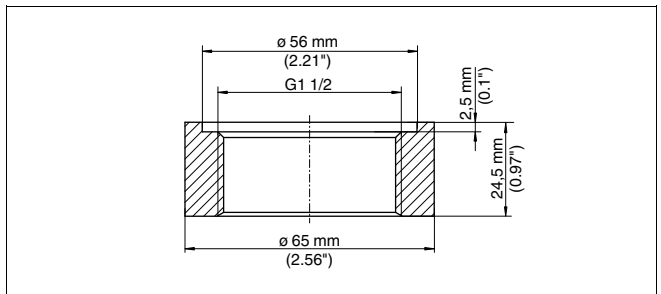


Fig. 4: Dimensions welded socket G1½ A acc. to DIN 3852-X

**2.2 Clamp according to DIN 32676, ISO 2852/316L**

**Clamp 1"**

**Welded socket Clamp 1" PN16 DIN 32676, ISO 2852/316L**

Product code ESTC.AXX

Material 316L

**Seal (optional)**

Material EPDM, FKM

**Tension ring**

Material 1.4301

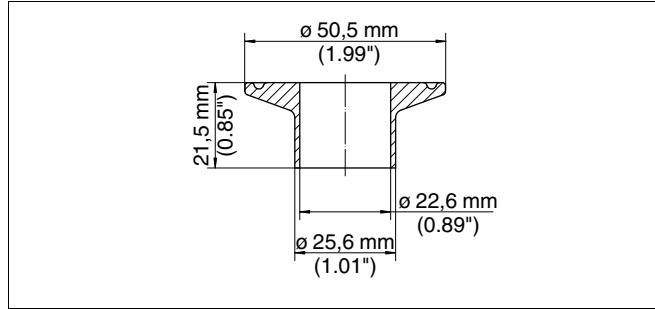


Fig. 5: Dimensions welded socket Clamp 1" PN16 DIN 32676, ISO 2852/316L

**Clamp 1½"**

**Welded socket Clamp 1½" PN16 DIN 32676, ISO 2852/316L**

Product code ESTC.BXX

Material 316L

**Seal (optional)**

Material EPDM, FKM

**Tension ring**

Material 1.4301

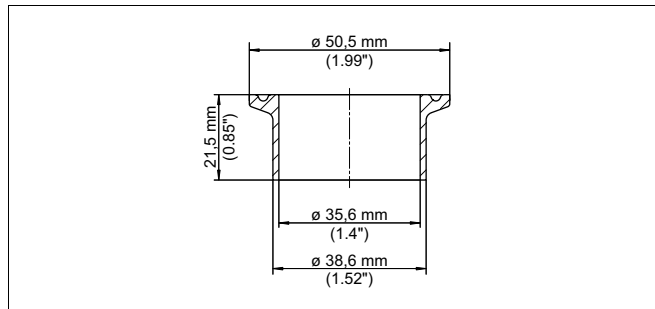


Fig. 6: Dimensions welded socket Clamp 1½" PN16 DIN 32676, ISO 2852/316L

**Clamp 2"**

**Welded socket Clamp 2" PN16 (ø 64 mm) DIN 32676, ISO 2852/316L**

Product code ESTC.CXX

Material 316L

**Seal (optional)**

Material EPDM, FKM

**Tension ring**

Material 1.4301

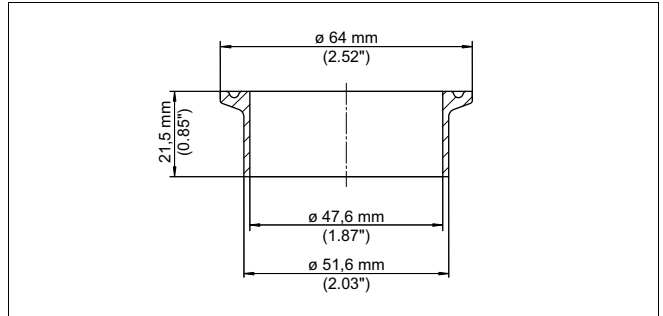


Fig. 7: Dimensions welded socket Clamp 2" PN16 (ø 64 mm) DIN 32676, ISO 2852/316L

**Clamp 2½"**

**Welded socket Clamp 2½" PN16 (ø 77.5 mm) DIN 32676, ISO 2852/316L**

Product code ESTC.DXX

Material 316L

**Seal (optional)**

Material EPDM, FKM

**Tension ring**

Material 1.4301

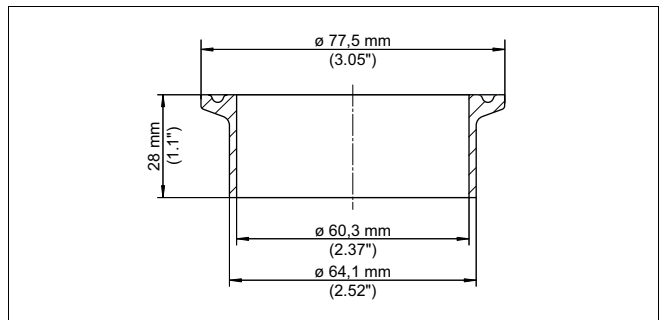


Fig. 8: Dimensions welded socket 2½" PN16 (ø 77.5 mm) DIN 32676, ISO 2852/316L

**Clamp 3"**

**Welded socket 3" PN16 (ø 91 mm) DIN 32676, ISO 2852/316L**

Product code ESTC.EXX

Material 316L

**Seal (optional)**

Material EPDM or FKM

**Tension ring**

Material 1.4301

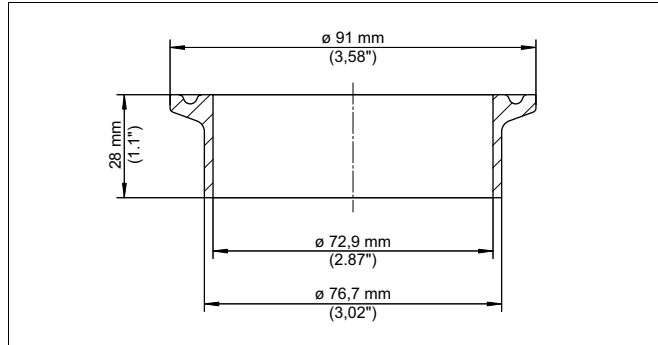


Fig. 9: Dimensions welded socket 3" PN16 ( $\varnothing 91 \text{ mm}$ ) DIN 32676, ISO 2852/316L

**2.3 Hygienic fittings****Hygienic fitting LA****Welded socket LA for compression nut**

Product code ESTA.LAXXX

Material 316L

**Seal (optional)**

Material EPDM

**Welding dummy**

Product code DMONT.A

Material 1.4305

**Blind stopper**

Product code DMONT.B1

Material 316Ti

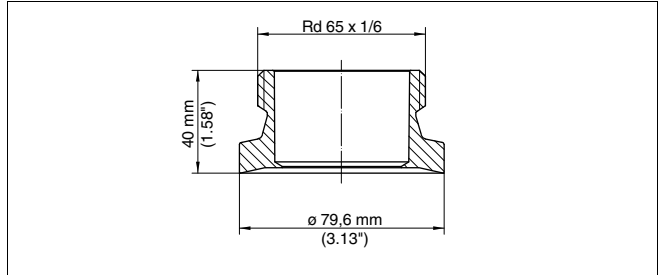


Fig. 10: Dimensions welded socket LA for compression nut

**Hygienic fitting LB**

**Welded socket LB for tension flange**

Product code ESTA.LBXXX

Material 316L

**Seal (optional)**

Material EPDM

**Welding dummy**

Product code DMONT.C

Material 1.4305

**Blind stopper**

Product code DMONT.D

Material 316Ti

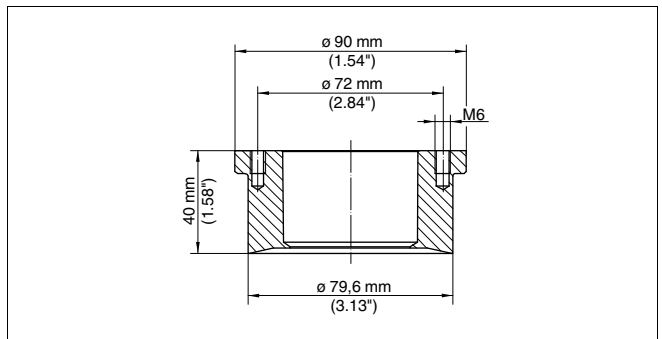


Fig. 11: Dimensions welded socket LB for tension flange

**DRD connection**

**Welded socket DRD**

Product code ESTD.AAXX

Material 316L

**Seal (optional)**

Material PTFE

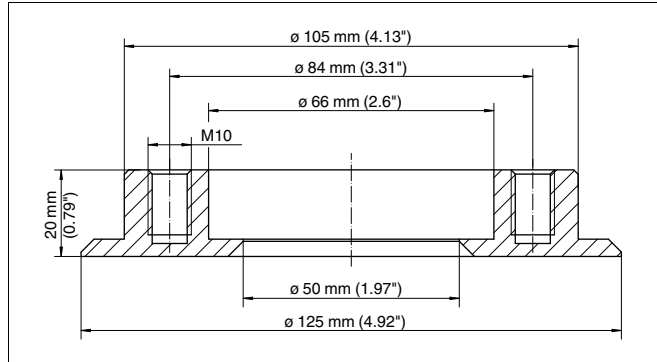


Fig. 12: Dimensions welded socket DRD

**Cone connection DN 25**

**Welded socket conus DN 25**

Product code ESTK.KAXX

Material 316L

**Seal (optional)**

Material EPDM

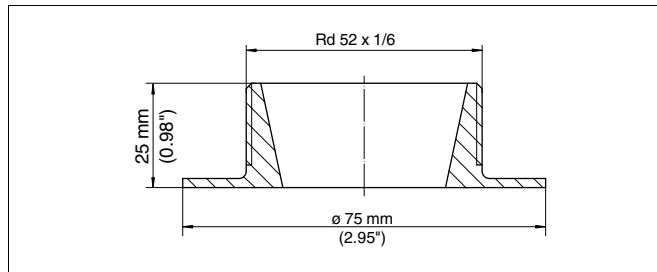


Fig. 13: Dimensions welded socket conus connection DN 25

**Cone connection M52 x 2**

**Welded socket conus M52 x 2**

Product code ESTK.KBXX

Material 316L

**Seal (optional)**

Material EPDM

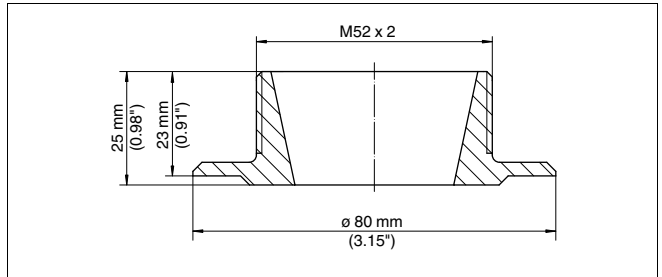


Fig. 14: Dimensions welded socket conus connection M52x2

## 2.4 Bolting acc. to DIN 11851

### Bolting DN 25

#### Welded socket, bolting DN 25 according to DIN 11851

Product code ESTR.DA1X

Material 316L

#### Seal (optional)

Material FKM, EPDM, NBR

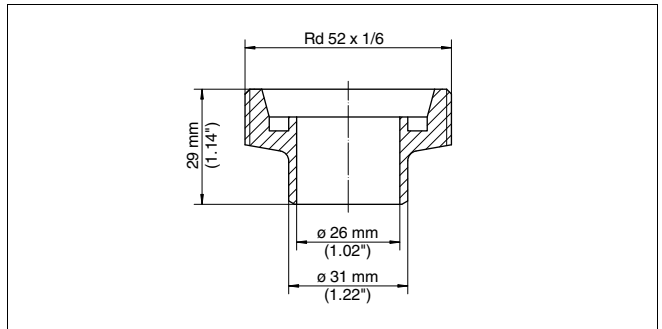


Fig. 15: Dimensions welded socket, bolting DN 25 according to DIN 11851

### Bolting DN 40

#### Welded socket, bolting DN 40 according to DIN 11851

Product code ESTR.FA1X

Material 316L

#### Seal (optional)

Material FKM, EPDM, NBR

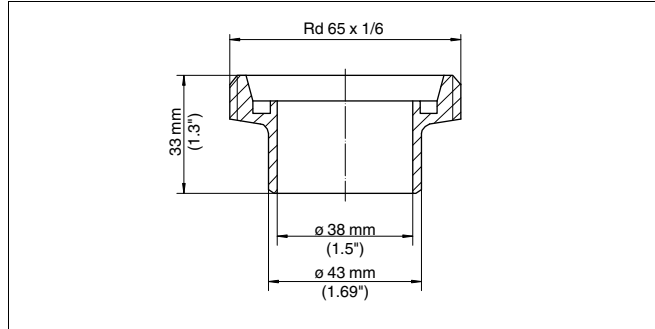


Fig. 16: Dimensions welded socket, bolting DN 40 according to DIN 11851

**Bolting DN 50**

**Welded socket, bolting DN 50 according to DIN 11851**

Product code ESTR.GA1X

Material 316L

**Seal (optional)**

Material FKM, EPDM, NBR

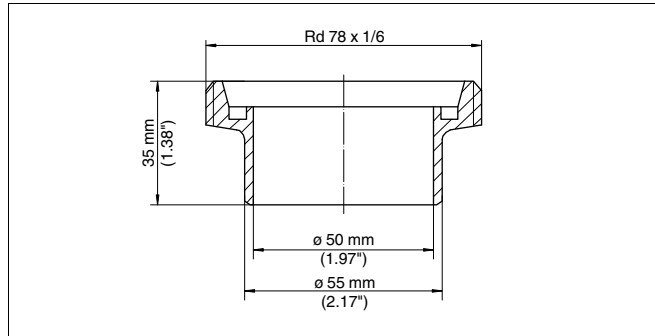


Fig. 17: Dimensions welded socket, bolting DN 50 according to DIN 11851

**Bolting DN 80**

**Welded socket, bolting DN 80 according to DIN 11851**

Product code ESTR.IA1X

Material 316L

**Seal (optional)**

Material EPDM, NBR

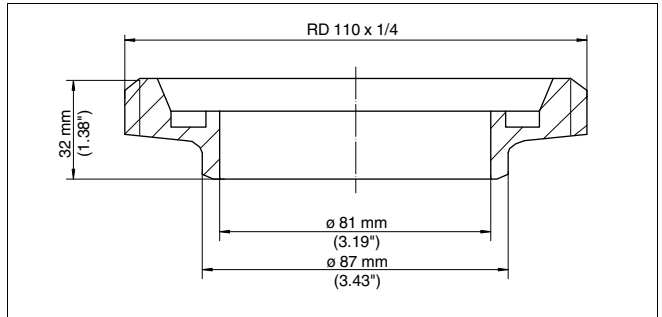


Fig. 18: Dimensions welded socket, bolting DN 80 according to DIN 11851

**Bolting DN 100**

**Welded socket, bolting DN 100 according to DIN 11851**

Product code ESTR.JA1X

Material 316L

**Seal (optional)**

Material EPDM

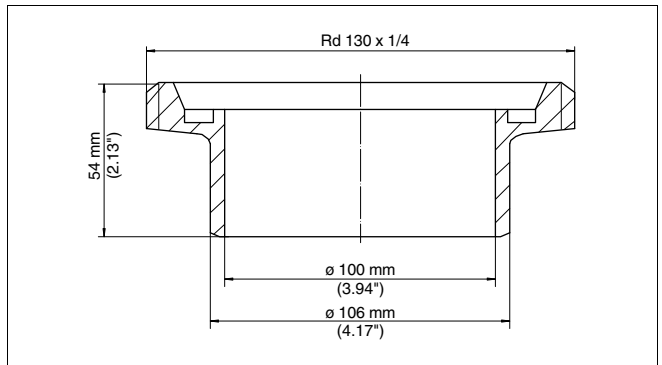


Fig. 19: Dimensions welded socket, bolting DN 100 according to DIN 11851

**2.5 Bolting acc. to DIN 11864-1**

**Bolting DN 40**

**Welded socket DN 40 acc. to DIN 11864-1**

Product code ESTR.FBXX

Material 316L

**Seal (optional)**

Material FKM, EPDM or NBR

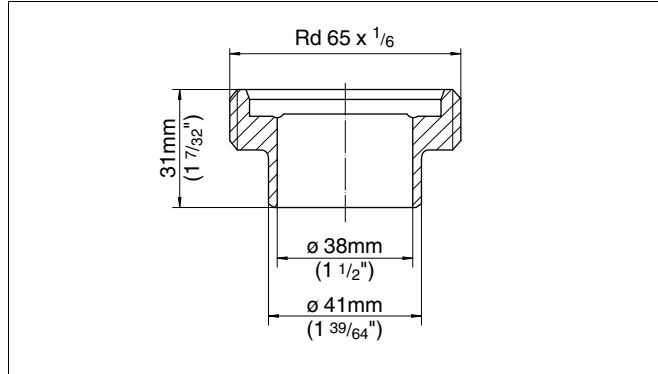


Fig. 20: Dimensions welded socket DN 40 acc. to DIN 11864-1

**Bolting DN 50**

**Welded socket DN 50 acc. to DIN 11864-1**

Product code ESTR.GBXX

Material 316L

**Seal (optional)**

Material FKM, EPDM or NBR

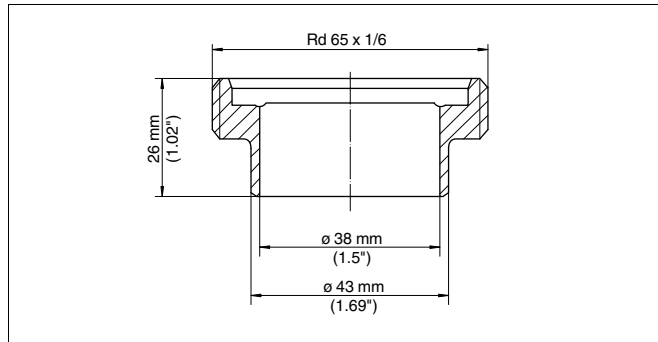


Fig. 21: Dimensions welded socket DN 50 acc. to DIN 11864-1

### 3 Welded socket - VEGABAR

#### 3.1 VEGABAR 17

**Thread G $\frac{1}{2}$  B**

**Welded socket G $\frac{1}{2}$  B acc. to ISO 228-1 - vessel**

Product code ESMBR17.86\*IXTX

Material 316Ti

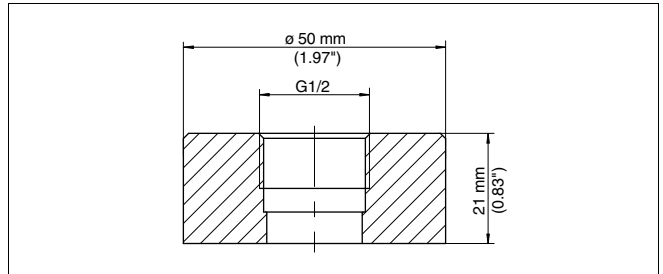


Fig. 22: Dimensions welded socket G $\frac{1}{2}$  B acc. to ISO 228-1 - vessel

**Welded socket G $\frac{1}{2}$  B acc. to ISO 228-1 - pipeline**

Product code ESMBR17.86\*AXVX

Material 316Ti

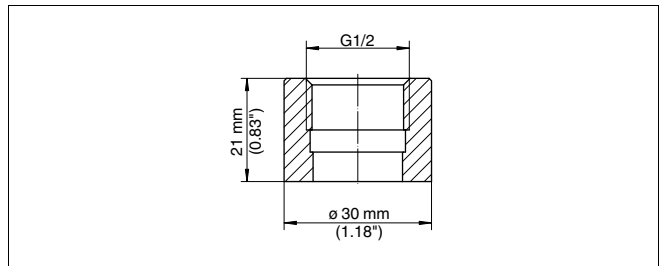


Fig. 23: Dimensions welded socket thread G $\frac{1}{2}$  B acc. to ISO 228-1 - pipeline

**Thread G1 B**

**Welded socket G1 B acc. to ISO 228-1**

Product code ESMBR17.85\*IXTX

Material 316Ti

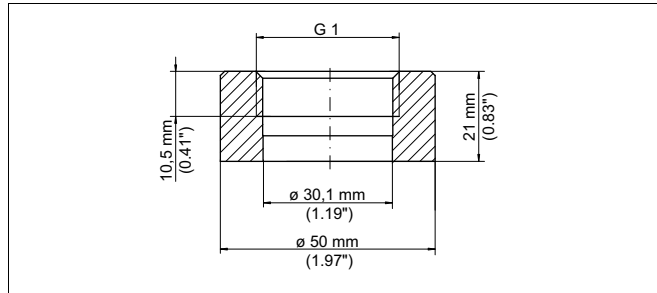


Fig. 24: Dimensions welded socket G1 B acc. to ISO 228-1

### Thread G1 hygienic

### Welded socket G1 aseptic

Product code ESMBR17.84\*JXVX

Material 316L

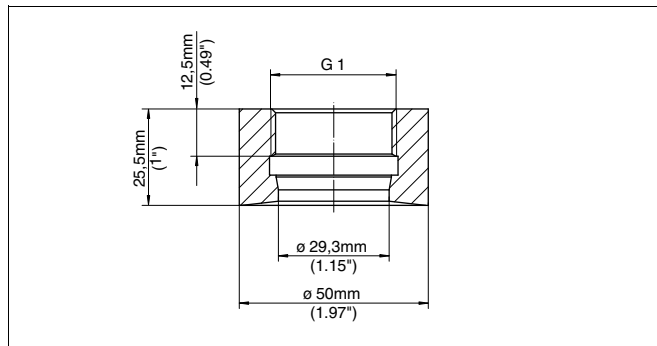


Fig. 25: Dimensions welded socket G1 aseptic

## 3.2 VEGABAR 52

### Thread G $\frac{1}{2}$ A

### Welded socket thread G $\frac{1}{2}$ A acc. to EN 837

Product code ESMBR52.GVBKVX

Material 316L

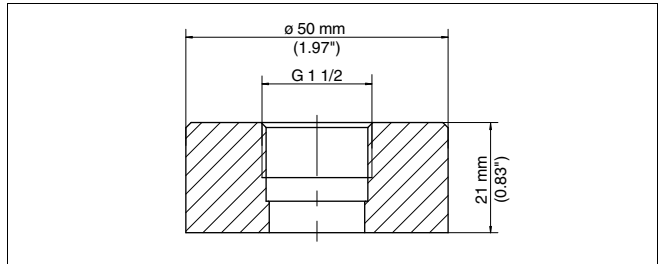


Fig. 26: Dimensions welded socket thread G 1/2 A acc. to EN 837

**Thread G1 A**

**Welded socket thread G1 A according to DIN ISO 228-1**

Product code ESMBR52.GCBKVX

Material 316Ti

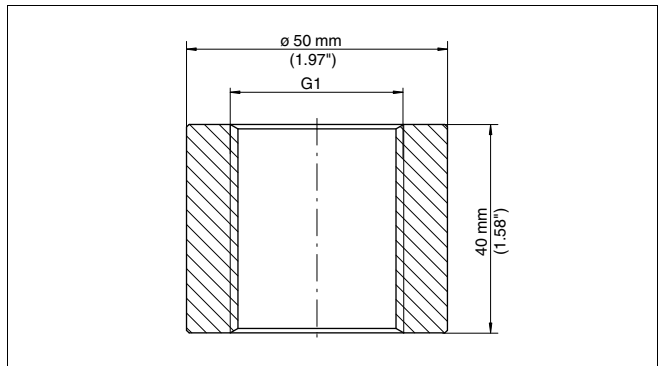


Fig. 27: Dimensions welded socket thread G1 A according to DIN ISO 228-1

**3.3 VEGABAR 53**

**Thread G 1/2 B**

**Welded socket G 1/2 B acc. to ISO 228-1 - vessel**

Product code ESMBR53.GFIXTX

Material 316Ti

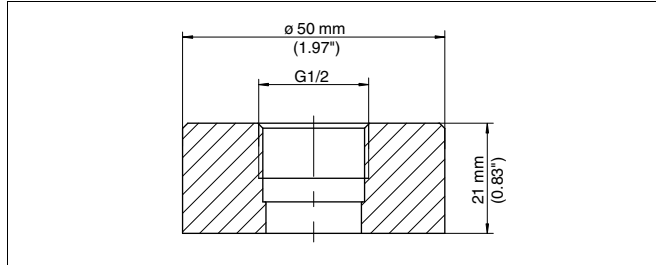


Fig. 28: Dimensions welded socket G $\frac{1}{2}$  B acc. to ISO 228-1 - vessel

### Welded socket G $\frac{1}{2}$ B acc. to ISO 228-1 - pipeline

Product code ESMBR53.GFAXVX

Material 316Ti

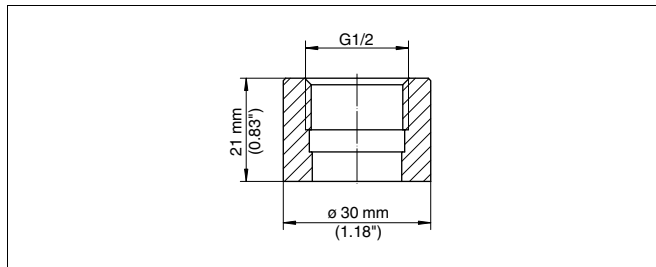


Fig. 29: Dimensions welded socket G $\frac{1}{2}$  B acc. to ISO 228-1 - pipeline

### Thread G1 B

### Welded socket G1 B acc. to ISO 228-1

Product code ESMBR53.GCIXTX

Material 316Ti

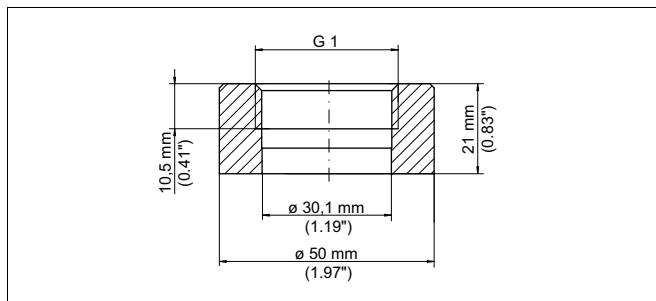


Fig. 30: Dimensions welded socket G1 B acc. to ISO 228-1

**Thread G1 B hygienic**

**Welded socket G1 B aseptic**

Product code ESMBR53.GEJXVX

Material 316L

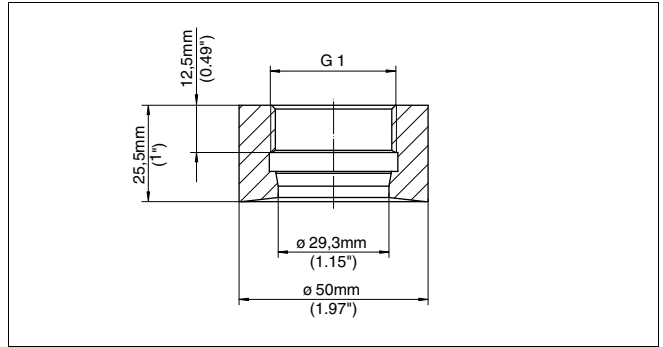


Fig. 31: Dimensions welded socket G1 B aseptic

**3.4 VEGABAR 54**

**Thread G½ A**

**Welded socket G½ A acc. to ISO 228-1**

Product code ESMBR54.GBAXVX

Material 316L

**Seal (optional)**

Material Kalrez

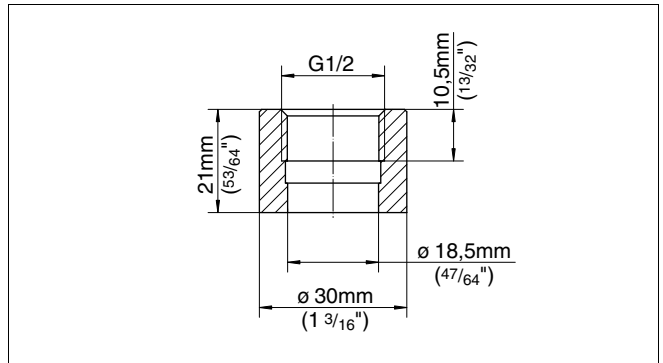


Fig. 32: Dimensions welded socket G½ A acc. to ISO 228-1

**Thread G¾ A**

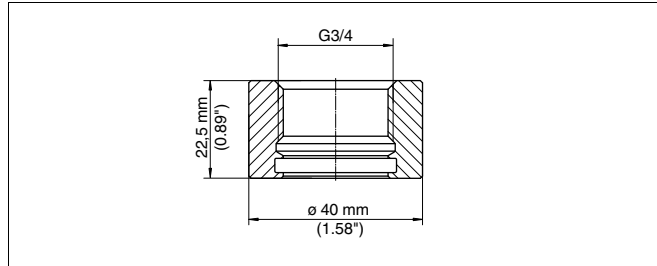
**Welded socket G¾ A acc. to DIN 3852-X**

Product code ESMBR54.GAEXVX

Material 316L

**Seal (optional)**

Material Viton, EPDM, Kalrez

Fig. 33: Dimensions welded socket G $\frac{3}{4}$  A acc. to DIN 3852-X**Thread G1 A****Welded socket G1 A acc. to ISO 228-1**

Product code ESMBR54.GCIXTX

Material 316Ti

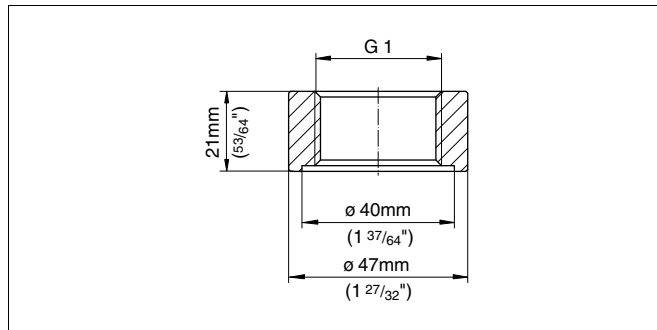


Fig. 34: Dimensions welded socket G1 A acc. to ISO 228-1

**3.5 VEGABAR 52, 54 - Paper industry****M30 x 1.5****Welded socket M30 x 1.5**

Product code ESMBR54.BFGXVX

Material 316L

**Seal (optional, mounting on pressure transmitter)**

Material Viton

**Welding dummy**

Product code DMONT.G

Material brass

**Blind stopper**

Material 316Ti

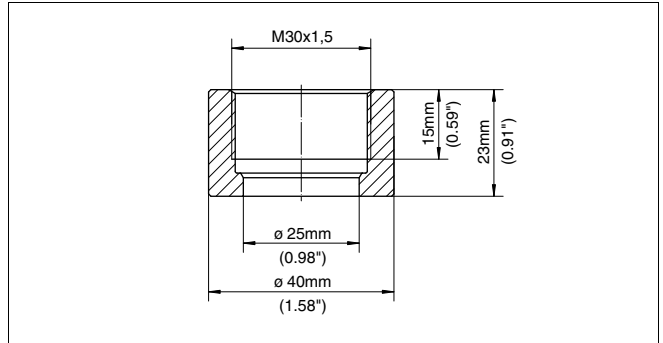


Fig. 35: Dimensions welded socket M30 x 1.5

**M30 x 1.5 for headbox**

**Welded socket M30 x 1.5**

Product code ESMBR54.BSGXVX

Material 316L

**Seal (optional)**

Material Viton

**Welding dummy**

Product code DMONT.G

Material brass

**Blind stopper**

Material 316Ti

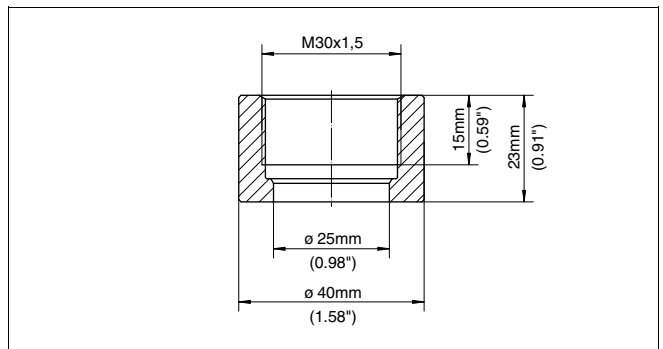


Fig. 36: Dimensions welded socket M30 x 1.5 for headbox

**M44 x 1.25**

**Welded socket M44 x 1.25**

Product code ESMBR\*\*.B\*MXVX

Material 316L

**Welding dummy**

Product code DMON T.F

Material brass

**Blind stopper**

Product code DMONT.H

Material 316Ti

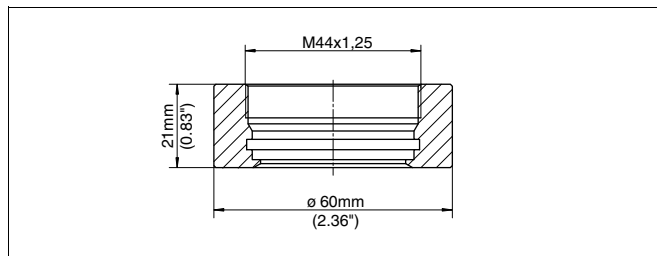


Fig. 37: Dimensions welded socket M30 x 1.25

**M48 x 1.5**

**Welded socket M48 x 1.5**

Product code ESMBR52.DGSXVX

Material 316L

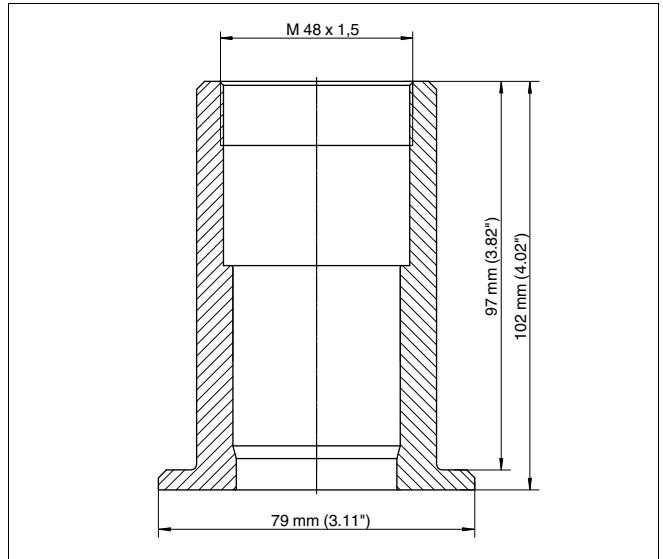


Fig. 38: Dimensions welded socket M48 x 1.5

**G1" suitable for PASVE**

**Welded socket G1" suitable for PASVE**

Product code ESMBR54.VPHXVX

Material 316L

**Dummy**

Product code DMONT.S

Material brass

**Blind stopper**

Product code DMONT.P

Material 316Ti

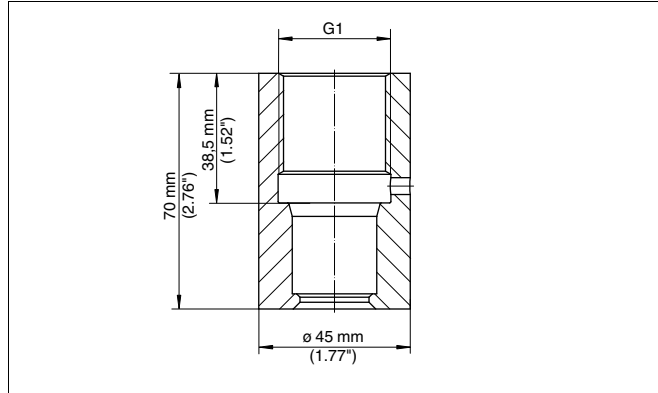


Fig. 39: Dimensions welded socket G1" suitable for PASVE

### PMC 1"

#### Welded socket PMC 1"

Product code ESMBR54.PCDXVX

Material 316L

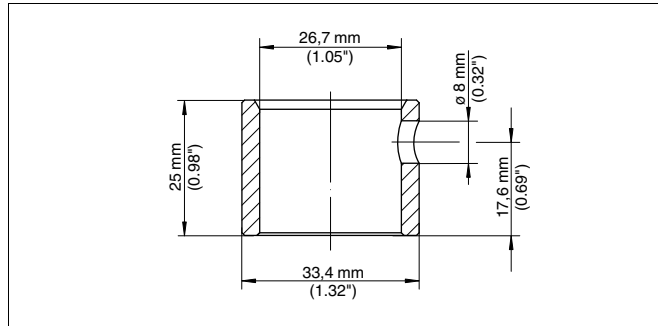


Fig. 40: Dimensions welded socket PMC 1"

## 4 Welded socket - Level switch

### 4.1 VEGASWING 51, 61, 63

**Thread G $\frac{3}{4}$  A**

**Welded socket G $\frac{3}{4}$  A acc. to DIN 3852-X**

Product code ESTSG.1GBX1

Material 316L

**Seal**

Material FKM, EPDM

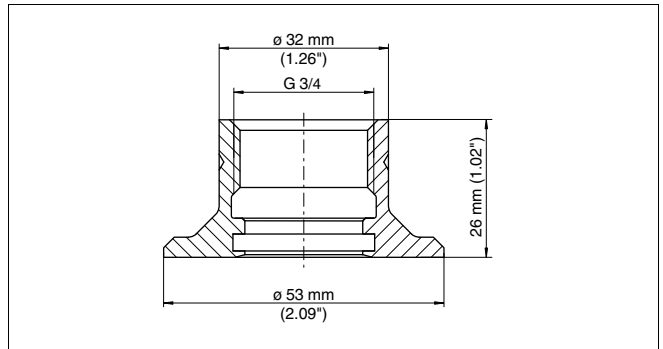


Fig. 41: Dimensions welded socket G $\frac{3}{4}$  A acc. to DIN 3852-X

**Thread G1 A**

**Welded socket G1 A acc. to DIN 3852-X**

Product code ESTSG.1GAX1

Material 316L

**Seal**

Material FKM, EPDM

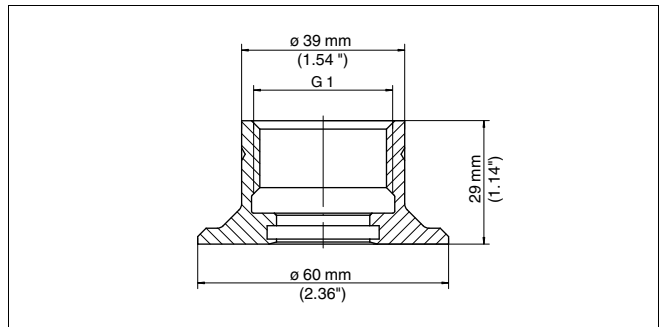


Fig. 42: Dimensions welded socket G1 A acc. to DIN 3852-X

## 4.2 VEGAKON

### Thread G1 A

### Welded socket G1 A acc. to DIN 3852-X

Product code ESTKN.1GA

Material 316Ti

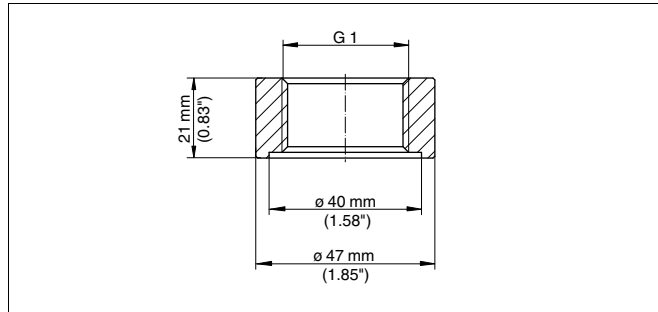


Fig. 43: Dimensions welded socket G1 A acc. to DIN 3852-X

## 5 Adapter

### 5.1 G $\frac{3}{4}$ A on Clamp according to DIN 32676, ISO 2852

**Clamp 1 $\frac{1}{2}$ "**

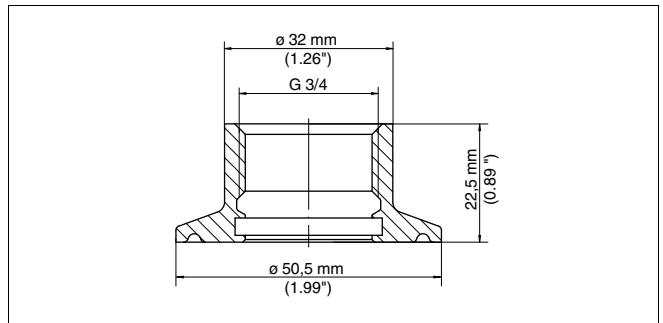
**Adapter G $\frac{3}{4}$  A according to DIN 3852-X on Clamp 1 $\frac{1}{2}$ " PN16  
DIN 32676, ISO 2852/316L**

Product code GEWADA-A.CG1

Material 316L

**Seal (optional)**

Material FKM, EPDM



*Fig. 44: Dimensions adapter G $\frac{3}{4}$  A according to DIN 3852-X on Clamp 1 $\frac{1}{2}$ " PN16 DIN 32676, ISO 2852/316L*

**Clamp 2"**

**Adapter G $\frac{3}{4}$  A according to DIN 3852-X on Clamp 2" PN16 ( $\varnothing$  64 mm) DIN 32676, ISO 2852/316L**

Product code GEWADA-A.CA1

Material 316L

**Seal (optional)**

Material FKM, EPDM

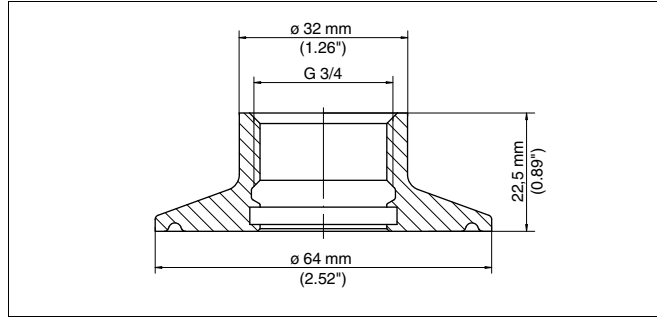


Fig. 45: Dimensions adapter G $\frac{3}{4}$  A according to DIN 3852-X on Clamp 2" PN16 ( $\varnothing$  64 mm) DIN 32676, ISO 2852/316L

### Clamp 2 $\frac{1}{2}$ "

#### Adapter G $\frac{3}{4}$ A according to DIN 3852-X on Clamp 2 $\frac{1}{2}$ " PN16 ( $\varnothing$ 77.5 mm) DIN 32676, ISO 2852/316L

Product code GEWADA-A.CD1

Material 316L

#### Seal

Material FKM, EPDM

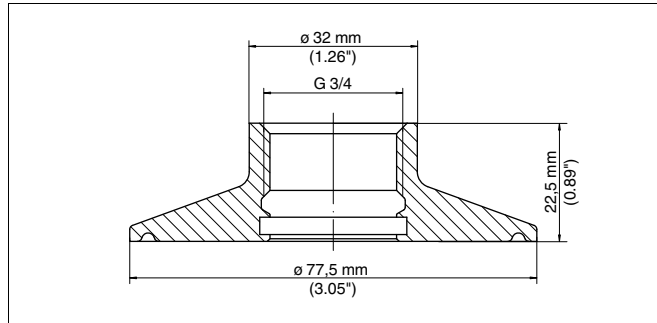


Fig. 46: Dimensions adapter G $\frac{3}{4}$  A according to DIN 3852-X on Clamp 2 $\frac{1}{2}$ " PN16 ( $\varnothing$  77.5 mm) DIN 32676, ISO 2852/316L

### Clamp 3"

#### Adapter G $\frac{3}{4}$ A according to DIN 3852-X on Clamp 3" PN16 ( $\varnothing$ 77.5 mm) DIN 32676, ISO 2852/316L

Product code GEWADA-A.CE1

Material 316L

#### Seal

Material FKM, EPDM

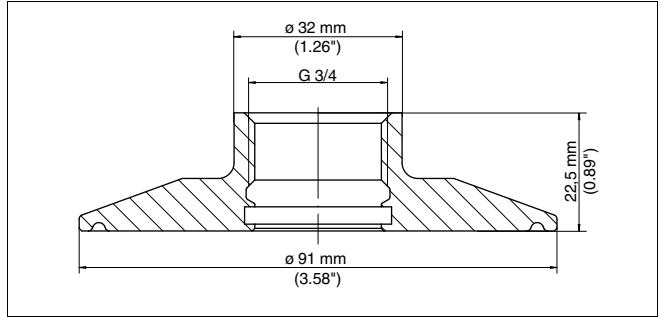


Fig. 47: Dimensions adapter G $\frac{3}{4}$  A according to DIN 3852-X on Clamp 32" PN16 ( $\phi$  91 mm) DIN 32676, ISO 2852/316L

**Clamp 4"**

**Adapter G $\frac{3}{4}$  A according to DIN 3852-X on Clamp 4" PN16 ( $\phi$  119 mm) DIN 32676, ISO 2852/316L**

Product code GEWADA-A.CC1

Material 316L

**Seal**

Material FKM, EPDM

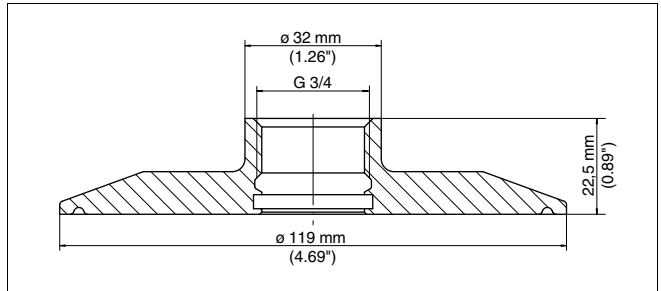


Fig. 48: Dimensions adapter G $\frac{3}{4}$  A according to DIN 3852-X on Clamp 4" PN16 ( $\phi$  119 mm) DIN 32676, ISO 2852/316L

**5.2 G1 $\frac{1}{2}$  A on Clamp according to DIN 32676, ISO 2852**

**Clamp 3"**

**Adapter G1 $\frac{1}{2}$  A according to DIN 3852-X on Clamp 3" PN16 ( $\phi$  77.5 mm) DIN 32676, ISO 2852/316L**

Product code GEWADA-B.CE1

Material 316L

**Seal**

Material FKM, EPDM

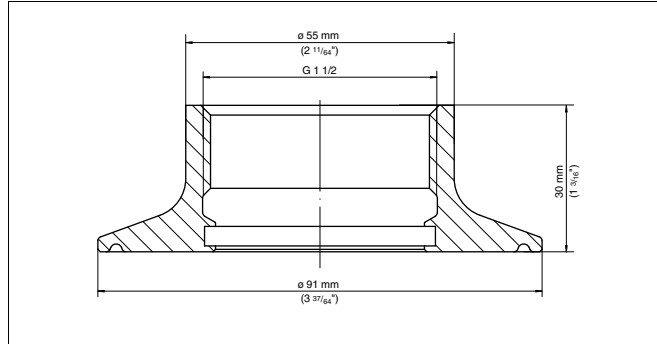


Fig. 49: Dimensions adapter G1½ A according to DIN 3852-X on Clamp 3" PN16 (ø 77.5 mm) DIN 32676, ISO 2852/316L

### 5.3 G1½ A on bolting acc. to DIN 11851

#### Bolting DN 40

#### Adapter G1½ A acc. to DIN 3852-X on bolting DN 40 acc. to DIN 11851

Product code GEWADA-A.RA1

Material 316L

#### Seal

Material FKM, EPDM

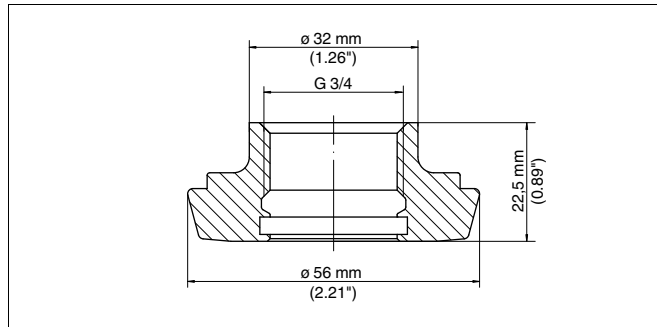


Fig. 50: Dimensions adapter G1½ A acc. to DIN 3852-X on bolting DN 40 acc. to DIN 11851

#### Bolting DN 50

#### Adapter G1½ A acc. to DIN 3852-X on bolting DN 50 acc. to DIN 11851

Product code GEWADA-A.RB1

Material 316L

**Seal**

Material FKM, EPDM

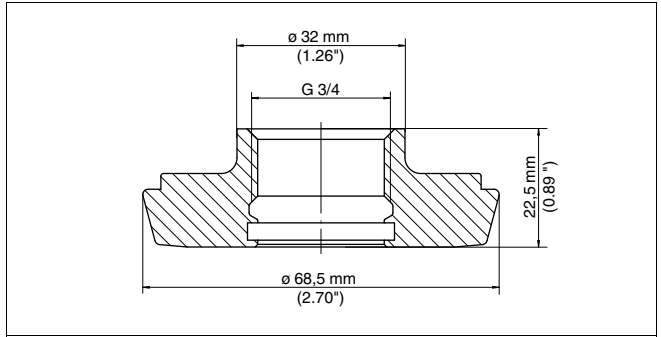


Fig. 51: Dimensions adapter G1½A acc. to DIN 3852-X on bolting DN 50 acc. to DIN 11851

**Bolting DN 65**

**Adapter G1½ A acc. to DIN 3852-X on bolting DN 65 acc. to DIN 11851**

Product code GEWADA-A.RC1

Material 316L

**Seal**

Material FKM, EPDM

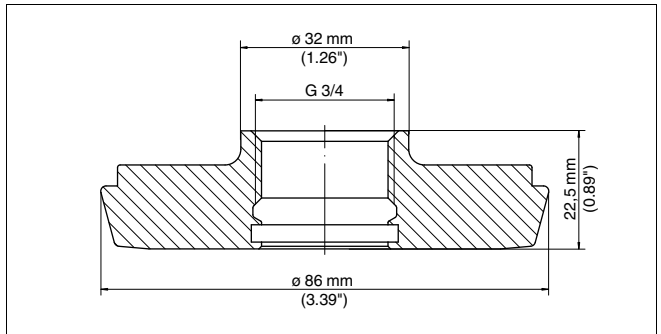


Fig. 52: Dimensions adapter G1½ A acc. to DIN 3852-X on bolting DN 65 acc. to DIN 11851

**Bolting DN 100**

**Adapter G1½ A acc. to DIN 3852-X on bolting DN 100 acc. to DIN 11851**

Product code GEWADA-A.RD1

Material 316L

**Seal**

Material FKM, EPDM

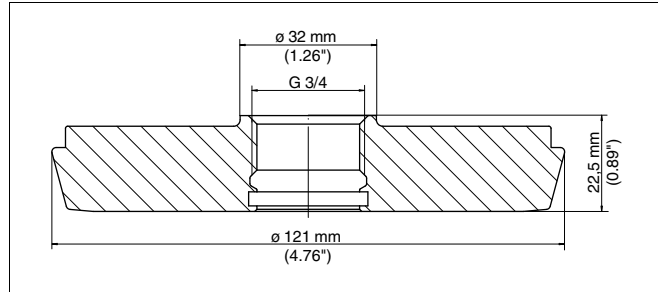


Fig. 53: Dimensions adapter G1½ A acc. to DIN 3852-X on bolting DN 100 acc. to DIN 11851

**5.4 G1½ A on further hygienic fittings****DRD connection****Adapter G1½ A acc. to DIN 3852-X on DRD connection**

Product code GEWADA-A.AA1

Material 316L

**Seal**

Material FKM, EPDM

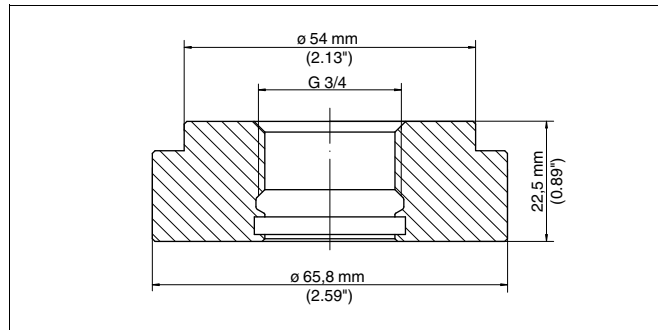


Fig. 54: Dimensions adapter G1½ A acc. to DIN 3852-X to DRD

**Tuchenhagen DN 32****Adapter G1½ A acc. to DIN 3852-X on Tuchenhagen DN 32**

Product code GEWADA-A.TA3

Material 316L

**Seal**

Material EPDM

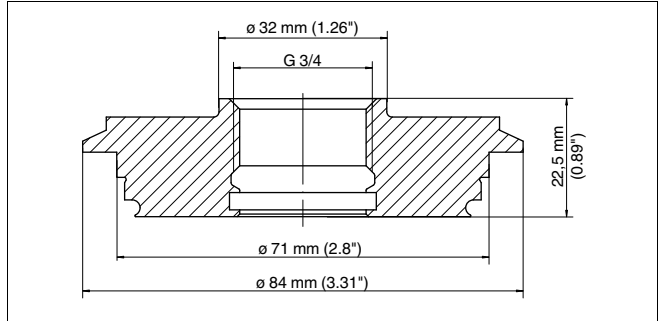


Fig. 55: Dimensions adapter  $G1\frac{1}{2} A$  acc. to DIN 3852-X on Tuchenhagen DN 32

## 6 Welding instructions



### Information:

The following welding instructions are for information only. In general, the relevant welding regulations must be noted. The AD leaflets must also be noted when welding on pressure vessels.

### Preparations

When welding stainless steel, utmost cleanness is necessary. E.g. it is not allowed to use rusty tools or screwed parts. Also make sure that no mild steel is processed in the closer environment.

Use enough inert gas for tack-welding. Make sure that you use tack-welding and not spot-welding. For tack-welding and welding, the protective gas pure argon must be used.

### Welding dummy

The suitable welding dummy must be used to avoid the distortion of the welded socket.

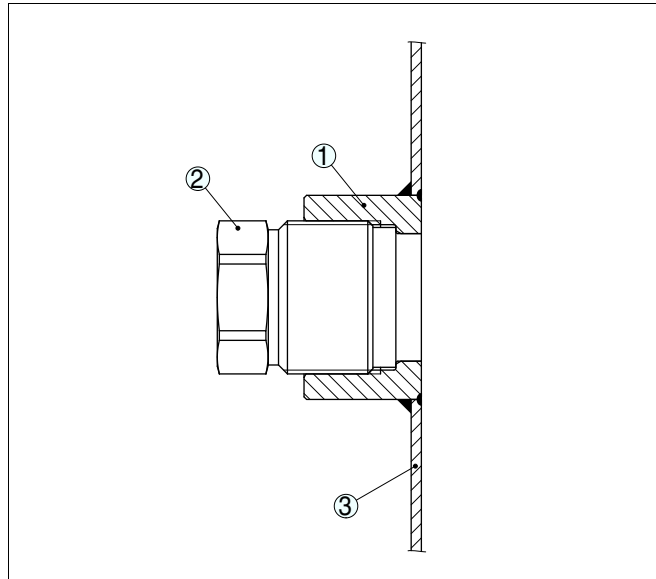
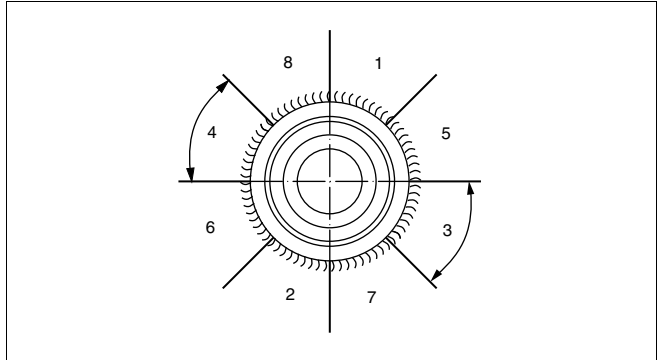


Fig. 56: Welding dummy

- 1 Welded socket
- 2 Dummy
- 3 Pipeline or vessel wall

### Welding procedure

It is generally recommended to divide the weld joint into several segments.



*Fig. 57: Segmental welding*

After welding a segment, weld immediately the segment that lies exactly opposite. Interrupt the welding process after welding two segments until the weld joint cools or carefully cool the weld joint yourself before you start welding again.

### **Pressure bearing**

The pressure loading capacity depends on the quality of the welding as well as the material of the welded socket. With threaded sockets, the thread length must be used completely bearing.

## 7 Supplement

### 7.1 Technical data

#### General data

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Material 316L corresponds to 1.4404 or 1.4435, 316Ti corresponds to 1.4571.

Max. process temperature on the welded socket, depending on the seal

- FKM	-20 ... +120 °C (-4 ... +248 °F)
- FFKM	-20 ... +120 °C (-4 ... +248 °F)
- EPDM	-40 ... +120 °C (-40 ... +248 °F)
- EPDM cleaning temperature max. 1 h	-40 ... +140 °C (-40 ... +284 °F)
- NBR	-20 ... +105 °C (-4 ... +221 °F)









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