

CHAPTER 2

Pipefitting

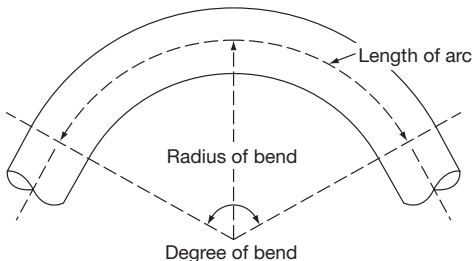
MEASURING LENGTH OF PIPE IN BENDS

The length of pipe (arc) in any bend depends on the following:

- (A) Number of degrees in angle of bend
- (B) Length of bending radius

The length of arc in a pipe bend is measured along the centerline of the pipe. The radius is also measured as extending to the centerline. Use the formula below to calculate arc length.

$$\text{Length of Arc} = \text{No. of Degrees} \times .0175 \times \text{Radius of Bend}$$



FINDING LENGTH OF PIPE IN STANDARD BENDS

If Angle in Degrees is	Multiply Radius by	If Angle in Degrees is	Multiply Radius by
22½	.393	150	2.618
30	.524	180	3.142
45	.785	210	3.665
60	1.047	240	4.189
90	1.571	270	4.712
112½	1.963	300	5.236
120	2.094	360	6.283
135	2.356	540	9.425