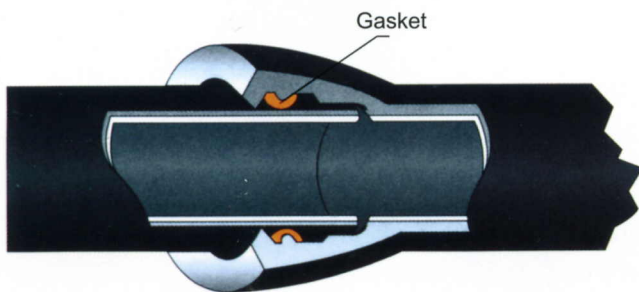


## DUCTILE IRON PIPE



Sealing rubber gaskets for joint type  
 Adopt quality natural rubber, synthetic rubber and many kinds rubber additive to produce gaskets  
 Surface dimensions of product in accordance with standard GB13295  
 Product material in accordance with ISO4633  
 Product type: T type, K type

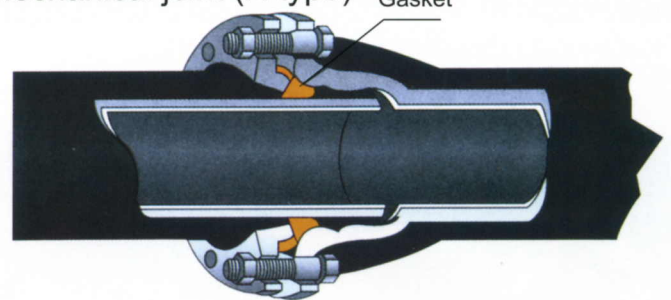
### Push-on joint(T-type)

### Weight of Ductile Iron Pipes with TYTON Joint(class K9)

| Nominal Diameter<br>DN<br>(mm) | Straight pipe (Barrel) |                             |                            | Socket Weight<br>kg | Total Weight<br>kg |      |
|--------------------------------|------------------------|-----------------------------|----------------------------|---------------------|--------------------|------|
|                                | O.D.<br>DE<br>(mm)     | Wall thickness<br>e<br>(mm) | Weight per meter<br>(kg/m) |                     | 6m                 | 8m   |
| 100                            | 118                    | 6.1                         | 15.1                       | 4.3                 | 95                 | -    |
| 150                            | 170                    | 6.3                         | 22.8                       | 7.1                 | 144                | -    |
| 200                            | 222                    | 6.4                         | 30.6                       | 10.3                | 194                | -    |
| 250                            | 274                    | 6.8                         | 40.2                       | 14.2                | 255                | -    |
| 300                            | 326                    | 7.2                         | 50.8                       | 18.9                | 323                | -    |
| 350                            | 378                    | 7.7                         | 63.2                       | 23.7                | 403                | -    |
| 400                            | 429                    | 8.1                         | 75.5                       | 29.5                | 482                | -    |
| 450                            | 480                    | 8.6                         | 89.7                       | 38.3                | 577                | -    |
| 500                            | 532                    | 9                           | 104.3                      | 42.8                | 669                | -    |
| 600                            | 635                    | 9.9                         | 137.3                      | 59.3                | 883                | -    |
| 700                            | 738                    | 10.8                        | 173.9                      | 79.1                | 1123               | -    |
| 800                            | 842                    | 11.7                        | 215.2                      | 102.6               | 1394               | -    |
| 900                            | 945                    | 12.6                        | 260.2                      | 129.0               | 1691               | -    |
| 1000                           | 1048                   | 13.5                        | 309.3                      | 161.3               | 2017               | 2636 |
| 1100                           | 1152                   | 14.4                        | 362.8                      | 194.7               | 2372               | 3097 |
| 1200                           | 1255                   | 15.3                        | 420.1                      | 237.7               | 2758               | 3598 |
| 1400                           | 1462                   | 17.1                        | 547.2                      | 279.3               | 3563               | 4657 |
| 1600                           | 1668                   | 18.9                        | 690.3                      | 375.4               | 4517               | 5898 |

Note: K10, K12 ductile iron pipes can be produced to ISO2531 according to demand of users.

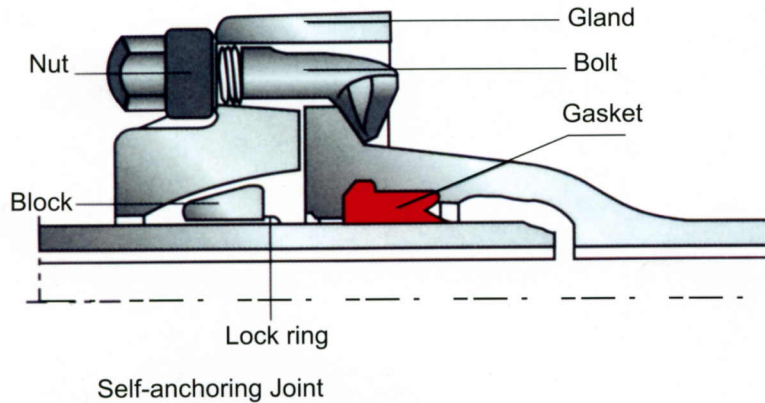
### Mechanical joint (K-type)



### Weight of "K" Type Joint Ductile Iron Pipes(class K9)

| Nominal Diameter<br>DN<br>(mm) | Straight pipe (Barrel) |                             |                            | Socket Weight<br>kg | Total Weight<br>kg |       |
|--------------------------------|------------------------|-----------------------------|----------------------------|---------------------|--------------------|-------|
|                                | O.D.<br>DE<br>(mm)     | Wall thickness<br>e<br>(mm) | Weight per meter<br>(kg/m) |                     | 6m                 | 8m    |
| 1000                           | 1048                   | 13.5                        | 309.3                      | 146.6               | 2002               | 2621  |
| 1200                           | 1255                   | 15.3                        | 420.1                      | 201                 | 2722               | 3562  |
| 1400                           | 1462                   | 17.1                        | 547.2                      | 265.8               | 3549               | 4643  |
| 1600                           | 1668                   | 18.9                        | 690.3                      | 375.4               | 4517               | 5898  |
| 1800                           | 1875                   | 20.7                        | 850.1                      | 490.6               | 5591               | 7291  |
| 2000                           | 2082                   | 22.5                        | 1026.3                     | 626.4               | 6784               | 8837  |
| 2200                           | 2288                   | 24.3                        | 1218.3                     | 784.2               | 8094               | 10531 |
| 2400                           | 2495                   | 26.1                        | 1427.2                     | 966.2               | 9529               | 12384 |
| 2600                           | 2702                   | 27.9                        | 1652.4                     | 1173.7              | 11088              | 14393 |

## DUCTILE IRON PIPE



(DN100-1600mm管长6m, DN800-2600mm管长8m) Permissible Deflection Angles

| Nominal Diameter<br>DN(mm) | Allowable Angles of Deflection<br>at Installation work |                            |
|----------------------------|--|----------------------------|
|                            | push-on joint<br>T-TYPE                                | Mechanical joint<br>K-TYPE |
| 100                        | 5° 00  | 5° 00                      |
| 125                        | 5° 00  | 5° 00                      |
| 150                        | 5° 00  | 5° 00                      |
| 200                        | 5° 00  | 5° 00                      |
| 250                        | 4° 00  | 5° 00                      |
| 300                        | 4° 00  | 5° 00                      |
| 350                        | 4° 00  | 4° 00                      |
| 400                        | 3° 00  | 4° 00                      |
| 450                        | 3° 00  | 3° 00                      |
| 500                        | 3° 00  | 3° 00                      |
| 600                        | 3° 00  | 2° 00                      |
| 700                        | 2° 00  | 2° 00                      |
| 800                        | 2° 00  | 2° 00                      |
| 900                        | 2° 00  | 2° 00                      |
| 1000                       | 2° 00  | 1° 00                      |
| 1200                       | 2° 00  | 1° 00                      |
| 1400                       | 2° 00  | 1° 00                      |
| 1600                       | 2° 00  | 1° 00                      |
| 1800                       | 2° 00  | 1° 00                      |
| 2000                       | 2° 00  | 1° 00                      |
| 2200                       | 2° 00  | 1° 00                      |
| 2400                       | 2° 00  | 1° 00                      |
| 2600                       | 2° 00  | 1° 00                      |

Weight of Self-anchoring joint D.I. pipe(k9, Effective Length 6m)

| Nominal Diameter<br>DN(mm) | Straight pipe (Barrel) |                                | Total Weight<br>(kg) |
|----------------------------|------------------------|--------------------------------|----------------------|
|                            | O.D.<br>DE<br>(mm)     | Wall<br>thickness<br>e<br>(mm) |                      |
| 100                        | 118                    | 6.1                            | 95                   |
| 150                        | 170                    | 6.3                            | 145                  |
| 200                        | 222                    | 6.4                            | 195                  |
| 250                        | 274                    | 6.8                            | 256                  |
| 300                        | 326                    | 7.2                            | 326                  |
| 350                        | 378                    | 7.7                            | 405                  |
| 400                        | 429                    | 8.1                            | 485                  |
| 450                        | 480                    | 8.6                            | 577                  |
| 500                        | 532                    | 9                              | 673                  |
| 600                        | 635                    | 9.9                            | 889                  |
| 700                        | 738                    | 10.8                           | 1129                 |
| 1000                       | 1048                   | 13.5                           | 2026                 |
| 1200                       | 1255                   | 15.3                           | 2769                 |

The different type locked joint ductile iron pipes can be produced made-to-order.

Mechanical properties of ductile iron pipes and fittings

| Standard | Product               | Nominal Diameter<br>DN(mm)                    | Tensile Strength<br>N/mm <sup>2</sup> | Yield Strength<br>N/mm <sup>2</sup> | Elongation<br>% | Hardness<br>HB |
|----------|-----------------------|---|---------------------------------------|-------------------------------------|-----------------|----------------|
| ISO2531  | Ductile iron pipes    | DN100<br>~<br>1000mm<br>DN1100<br>~<br>2600mm | ≥420                                  | ≥300                                | ≥10<br><br>≥7   | ≤230           |
|          | Ductile iron fittings | DN80<br>~<br>2600mm                           | ≥420                                  | ≥300                                | ≥5              | ≤250           |

Hydro test standard(Class K9 ISO2531)

| Product               | Nominal Diameter<br>DN(mm) | Test pressure(bar) | Time of testing(second) |
|-----------------------|----------------------------|--------------------|-------------------------|
| Ductile iron pipes    | 100~300                    | 50                 | ≥10                     |
|                       | 350~600                    | 40                 |                         |
|                       | 700~1000                   | 32                 |                         |
|                       | 1100~2000                  | 25                 |                         |
|                       | 2200~2600                  | 18                 |                         |
| Ductile iron fittings | 80~300                     | 25                 | ≥10                     |
|                       | 350~600                    | 16                 |                         |
|                       | 700~260                    | 10                 |                         |

## DUCTILE IRON PIPE FITTING

As lost-foam casting is applied, the production line is flexible to provide clients with ductile iron parts of different size, different shape, or small quantity. Different painting and lining is available.

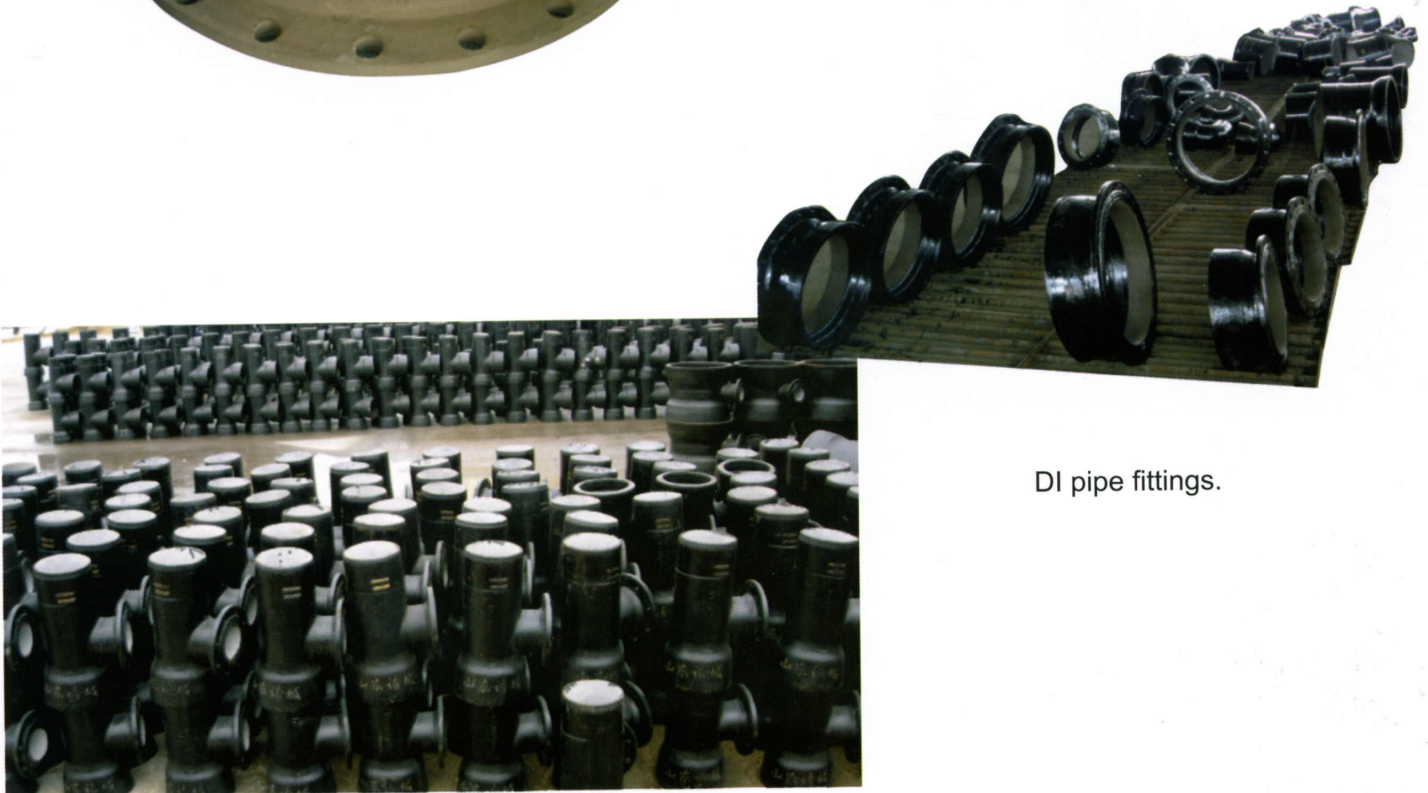
Size: DN80-DN2600

Standard: ISO2531

Pressure: 1.0 Mpa~2.5 MPa



Foam pattern



DI pipe fittings.