The American Society of Mechanical Engineers

AN AMERICAN NATIONAL STANDARD

METALLIC GASKETS FOR PIPE FLANGES

Ring-Joint, Spiral-Wound, and Jacketed

ASME B16.20-1998

(Revision of ASME B16.20-1993)

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The American Society of Mechanical Engineers
Three Park Avenue, New York, NY 10016-5990

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ASME B16.20a-2000

ADDENDA

to

ASME B16.20-1998
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Ring-Joint, Spiral-Wound, and Jacketed

THE AMERICAN SOCIETY OF MECHANICAL ENGINEERS
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ASME B16.20a-2000

Following approval by the ASME B16 Committee and ASME, and after public review, ASME B16.20a-2000 was approved by the American National Standards Institute on May 3, 2000.

Addenda to the 1998 edition of ASME B16.20 are issued in the form of replacement pages. Revisions, additions, and deletions are incorporated directly into the affected pages. It is advisable, however, that this page, the Addenda title and copyright pages, and all replaced pages be retained for reference.

SUMMARY OF CHANGES

This is the first Addenda to be published to ASME B16.20-1998.

Replace or insert the pages listed. Changes given below are identified on the pages by a margin note, **(a)**, placed next to the affected area. The pages not listed are the reverse sides of the listed pages and contain no changes.

Page	*Location*	*Change*
v	Committee Roster	Updated to reflect Addenda
xi	Contents	Updated to reflect Addenda
2, 2.1	Paragraph 3.2.5	Revised
21	Table 12	Notes (1) and (3) revised
23	Table 14	General Note (c) and Notes (1) and (2) revised
24	Table 15	(1) Title revised (2) General Notes added
28	Table 19	Revised
35	Mandatory Annex I	Revised

FOREWORD

Ring-joint gaskets and grooves probably originated in the boiler field, where they were used in various forms for manhole covers, autoclaves, and other closures; however, it was in the oil industry (both in the production and refining of oil) that they received the greatest recognition and were developed into their present form. Their use expanded steadily as temperatures and pressures were increased in steam plants. Tests examining their application in flanges and valves were conducted as early as 1928.

In June 1936, the American Petroleum Institute (API) issued Tentative Standard 5-G-3 on Ring-Joints for Steel Flanges and Flange Unions for use with API Tubular Goods. This standard was known as API Specification 6B, Ring-Joint Flanges. Following the acceptance of ring-joints for flanges and valves by API and the issuance of their standard, ASA B16e on Steel Pipe Flanges and Flanged Fittings was revised to include them, and the 1939 edition included standard dimensions for a full line of ring-joint flanges based on the API standard. Development work continued, and API formulated Standard 6E, Specification for Wellhead Equipment, which included ring-joints not covered in ASA B16e-1939.

In 1949, the American Standards Association (ASA), Sectional Committee B16, Subcommittee 3, Steel Flanges and Flanged Fittings, assembled the available information on ring-joint gaskets into a single standard. ASA approval was granted on April 30, 1952, with the designation ASA B16.20-1952.

Ring gaskets for Class 900 (900 lb at that time) in sizes NPS 26 through 36 were added, and ASA approval was granted on April 30, 1952.

An updated version was submitted, and ASA approval was granted on April 4, 1955, with the designation ASA B16.20-1955. The standard was reviewed, and reaffirmation approval was granted by the ASA on April 25, 1963.

The standard was reviewed, and reaffirmation approval was granted by the American National Standards Institute (ANSI) on April 25, 1973, with the designation of an American National Standard.

API requested that ASME convert their gasket standard, API 601, into an ASME American National Standard. As a result of that request, this edition was expanded to include requirements for spiral-wound and jacketed gaskets that were formerly listed in API 601, 7th edition, 1988. Also, ring-joint groove dimensions are not included in this edition because they are included in ASME/ANSI B16.5-1988, titled Pipe Flanges and Flanged Fittings, and ASME B16.47-1990, titled Large Diameter Steel Flanges.

The 1993 edition was approved by the B16 Standards Committee. Following approval by ASME, approval by ANSI was given on January 22, 1993, with the designation ASME B16.20-1993.

In the 1998 edition of ASME B16.20, reference standards are updated, a quality system program annex is added, inner ring inside diameters for spiral-wound gaskets are revised, and several editorial revisions are made. Following approval by ASME B16 Subcommittee B and the B16 Main Committee, ANSI approved this American National Standard on November 20, 1998.

Requests for interpretations or suggestions for revision should be sent to The American Society of Mechanical Engineers; Secretary, B16 Committee; Three Park Avenue, New York, New York 10016-5990.

ASME B16 COMMITTEE (a)
Standardization of Valves, Flanges, Fittings, Gaskets, and Valve Actuators

(The following is the roster of the Committee at the time of approval of this Standard.)

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General. ASME Standards are developed and maintained with the intent to represent the consensus of concerned interests. As such, users of this Standard may interact with the Committee by requesting interpretations, proposing revisions, and attending Committee meetings. Correspondence should be addressed to:

Secretary, B16 Main Committee
The American Society of Mechanical Engineers
Three Park Avenue
New York, NY 10016-5990

Proposing Revisions. Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

Interpretations. Upon request, the B16 Committee will render an interpretation of any requirement of the Standard. Interpretations can only be rendered in response to a written request sent to the Secretary of the B16 Main Committee.

The request for interpretation should be clear and unambiguous. It is further recommended that the inquirer submit his/her request in the following format:

Subject:	Cite the applicable paragraph number(s) and the topic of the inquiry.
Edition:	Cite the applicable edition of the Standard for which the interpretation is being requested.
Question:	Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. The inquirer may also include any plans or drawings, which are necessary to explain the question; however, they should not contain proprietary names or information.

Requests that are not in this format will be rewritten in this format by the Committee prior to being answered, which may inadvertently change the intent of the original request.

ASME procedures provide for reconsideration of any interpretation when or if additional information that might affect an interpretation is available. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME Committee or Subcommittee. ASME does not "approve," "certify," "rate," or "endorse" any item, construction, proprietary device, or activity.

Attending Committee Meetings. The B16 Main Committee regularly holds meetings, which are open to the public. Persons wishing to attend any meeting should contact the Secretary of the B16 Main Committee.

IMPORTANT INFORMATION CONCERNING USE OF ASBESTOS OR ALTERNATIVE MATERIALS

Asbestos is referenced for use as a filler material in metallic gaskets. It has served as a universal sealing material, compatible with most fluid services. It has been of extreme usefulness in minimizing fire hazards.

Certain serious adverse health effects are associated with asbestos, among them the serious and often fatal diseases of lung cancer, asbestosis, and mesothelioma (a cancer of the chest and abdominal linings). The degree of exposure to asbestos varies with the product and the work practices involved.

Consult the most recent edition of the Occupational Safety and Health Administration, U.S. Department of Labor, Occupational Safety and Health Standard for Asbestos, Tremolite, Anthophyllite, and Actinolite, 29 Code of Federal Regulations Section 1910.1001; the U.S. Environmental Protection Agency, National Emission Standard for Asbestos, 40 Code of Federal Regulations Sections 61.140 through 61.156; and the proposed rule by the U.S. Environmental Protection Agency proposing labeling requirements and phased banning of asbestos products, published at 51 Federal Register 3738-3759 (January 29, 1986).

There are currently in use and under development a number of substitute materials to replace asbestos in certain applications. Manufacturers and users are encouraged to develop and use effective substitute materials that can meet the specifications for, and operating requirements of, the equipment to which they would apply.

Information concerning safety and health risks and proper precautions with respect to particular materials and conditions should be obtained from one's employer, the manufacturer or supplier of that material, or the Material Safety Data Sheet.

CONTENTS

(a)

Mandatory Annex

Nonmandatory Annex

METALLIC GASKETS FOR PIPE FLANGES

Ring-Joint, Spiral-Wound, and Jacketed

1 SCOPE

1.1 General

This Standard covers materials, dimensions, tolerances, and markings for metal ring-joint gaskets, spiral-wound metal gaskets, metal-jacketed gaskets, and filler material. These gaskets are dimensionally suitable for use with flanges described in reference flange standards ASME B16.5, ASME B16.47, and API Specification 6A. This Standard covers spiral-wound metal gaskets and metal-jacketed gaskets for use with raised-face and flat-face flanges.

1.2 Quality Systems

Requirements relating to the product manufacturers' quality system programs are described in Annex A.

1.3 References

Standards and specifications adopted by reference in this Standard are shown in Annex I, which is part of this Standard.

2 RING-JOINT GASKETS

2.1 Types

Ring-joint gaskets shall be either octagonal or oval in cross section.

2.2 Size

Ring-joint gaskets shall be identified by an R, RX, or BX number that relates to flange size (NPS), pressure class, and the appropriate flange standards (ASME B16.5, ASME B16.47, or API Specification 6A).

2.3 Materials

2.3.1 General. Ring-joint gasket materials, some of which are listed in Table 1, shall be selected by the user based on suitability for the service conditions.

TABLE 1 MAXIMUM HARDNESS FOR RING GASKETS

Ring Gasket Material	Maximum Hardness	
	Brinell	Rockwell "B" Scale
Soft iron (1)	90	56
Low-carbon steel	120	68
4–6 chrome ½Mo	130	72
Type 410	170	86
Type 304	160	83
Type 316	160	83
Type 347	160	83

NOTE:
(1) May be low-carbon steel, not to exceed maximum hardness of 90 Brinell—56 Rockwell "B."

It is recommended that ring-joint gaskets be of a lesser hardness than that of the mating flanges.

2.3.2 Hardness. Ring-joint gaskets of materials listed in Table 1 shall have a hardness equal to or less than that shown in Table 1.

2.4 Marking

The outer surface of each gasket shall carry the manufacturer's name or identification trademark and gasket number prefixed by the letters R, RX, or BX followed by the gasket material identification. Materials shall be identified as shown in Table 2. The gasket shall also be marked with an ASME B16.20 designation. The marking shall be applied so as not to harmfully distort the gasket or affect the integrity of the seal.

2.5 Dimensions and Tolerances

Dimensions and tolerances for ring-joint gaskets shall be as shown in Tables 3 through 8.

2.6 Surface Finish

Types R and RX gaskets shall have a finish not rougher than 63 μin. roughness. Type BX gaskets shall have a finish not rougher than 32 μin. roughness. Surface finishes shall pertain to the gasket-sealing surfaces.