

REV.
D

AS1895™/2

RATIONALE

FEDERAL SUPPLY CLASS
5340

GRAPHICS REDRAWN. .710 DIMENSION CHANGED FROM A REFERENCED TO A DEFINED DIMENSION. TABLE 1 REDRAWN TO REMOVE DIMENSIONS FOR DIM A FOR SIZES ABOVE -.325 AND TO ADD 'REF' TO DIM C AND D. NOTE 3 REVISED TO STATE CURRENT QML NOTE. GENERAL UPDATING OF SPECIFICATIONS BEING SPECIFIED HEREIN. CHANGE BAR NOTE REVISED. NOTE 18 ADDED.

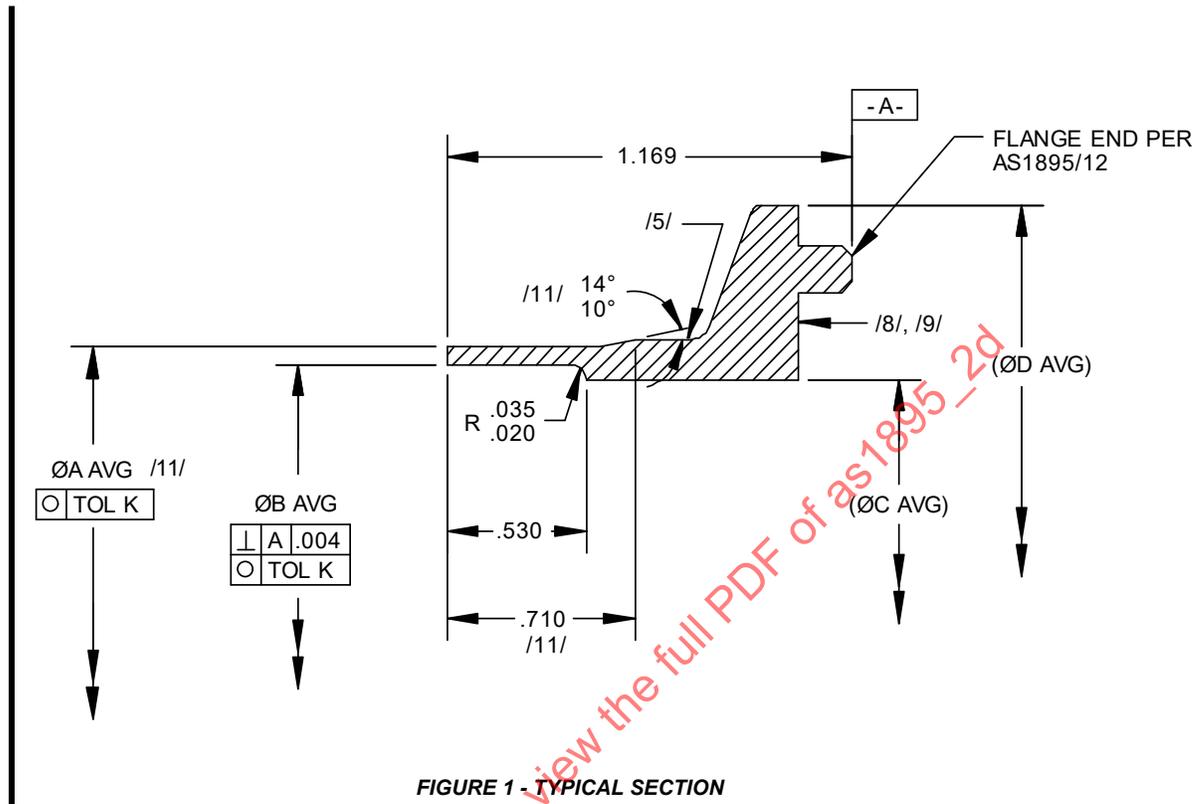
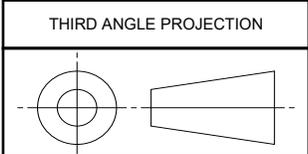


FIGURE 1 - TYPICAL SECTION

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<https://www.sae.org/standards/content/AS1895/2D/>



CUSTODIAN: G-3/G-3A

PROCUREMENT SPECIFICATION: AS1895 /3/



AEROSPACE STANDARD

FLANGE, MALE, SEAM WELD
TYPE I STANDARD PROFILE

AS1895™/2
SHEET 1 OF 3

REV.
D

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ISSUED 1985-12 REAFFIRMED 2013-01 REVISED 2021-03

TABLE 1 - DIMENSIONS A-K AND WEIGHTS

PART NUMBER	(TUBE SIZE) DIA	A	B	C	D	K	LB/EA MAX
		+ .000/- .005	+ .005/- .000	REF	REF		
AS1895/2-150	1.50	1.600	1.505	1.450	2.250	.002	.28
AS1895/2-175	1.75	1.850	1.755	1.700	2.500	.002	.32
AS1895/2-200	2.00	2.100	2.005	1.950	2.750	.002	.36
AS1895/2-225	2.25	2.350	2.255	2.200	3.000	.002	.40
AS1895/2-250	2.50	2.600	2.505	2.440	3.250	.003	.45
AS1895/2-275	2.75	2.850	2.755	2.680	3.500	.003	.48
AS1895/2-300	3.00	3.100	3.005	2.920	3.750	.003	.52
AS1895/2-325	3.25	3.350	3.255	3.170	4.000	.003	.57
AS1895/2-350	3.50	/11/	3.505	3.410	4.250	.004	.72
AS1895/2-400	4.00	/11/	4.005	3.900	4.750	.004	.80
AS1895/2-450	4.50	/11/	4.505	4.380	5.250	.005	.92
AS1895/2-500	5.00	/11/	5.005	4.870	5.750	.005	1.03
AS1895/2-550	5.50	/11/	5.505	5.360	6.250	.006	1.14
AS1895/2-600	6.00	/11/	6.005	5.850	6.750	.006	1.25
AS1895/2-650	6.50	/11/	6.505	6.340	7.250	.007	1.37
AS1895/2-700	7.00	/11/	7.005	6.830	7.750	.007	1.49
AS1895/2-750	7.50	/11/	7.505	7.320	8.250	.008	1.61

NOTES:

1. MATERIAL:

- a) DASH NUMBERS 150 THROUGH 350 - NICKEL ALLOY 625 IN ACCORDANCE WITH AMS5666, AMS5599, OR AMS5581.
- b) DASH NUMBERS 400 AND LARGER - NICKEL ALLOY 718 IN ACCORDANCE WITH AMS5596, AMS5662, OR AMS5589 IN THE PRECIPITATE HARDENED CONDITION.

2. FINISH: DESCALED AND FREE OF SURFACE CONTAMINATION.

/3/ PROCUREMENT SPECIFICATION: AS1895 EXCEPT AS SPECIFIED ON THIS STANDARD. PRODUCT MANUFACTURED TO THIS STANDARD SHALL MEET THE REQUIREMENTS SPECIFIED HEREIN AND THE PROCUREMENT SPECIFICATION. ORIGINAL COMPONENT MANUFACTURERS (OCM) AND VALUE ADDED DISTRIBUTORS (VAD) SHALL BE LISTED IN THE NADCAP QUALIFIED MANUFACTURER LIST (QML) FOR THIS PRODUCT TYPE. THE QML IS AVAILABLE AT www.eAuditNet.com.

4. THIS FLANGE, WHEN MATED WITH FLANGE P/N AS1895/3-XXX, FLANGE P/N AS1895/11-XXX OR AS1895/19-XXX, FLANGE END PER AS1895/13-XXX, SEALS P/N AS1895/7-XXX OR AS1895/23-XXX, COUPLING P/N AS1895/1-XXX OR AS1895/22-XXX SHALL MEET ALL THE REQUIREMENTS OF SPECIFICATION AS1895.

/5/ MARKING: MARK FLANGE WITH SUPPLIER IDENTIFICATION AND AS1895/2-XXX PART NUMBER PER AS1895.

6. MAXIMUM VARIATION OF WALL (RADIAL) THICKNESS IN ANY DIAMETRAL PLANE TO BE WITHIN .004 TOTAL.

7. FLANGES ARE DESIGNED FOR SEAM RESISTANCE WELDING TO TUBING IN ACCORDANCE WITH AWS D17.2/D17.2M.

/8/ INTENDED USE: FLATNESS LIMIT AFTER WELDING PER AS1895.

/9/ WORKMANSHIP: THE FLANGES SHALL BE FREE OF SHARP EDGES AND BURRS AND SHALL BE CAPABLE OF MATING UNDER ALL TOLERANCE CONDITIONS OF THE COMPONENT PARTS.

FLANGES SHALL BE FREE OF STREAKS, STAINS, DISCOLORATION, OR DEPOSITS.

SEALING SURFACE SHALL BE FREE OF SCRATCHES AND SURFACE FINISH SHALL BE CIRCULAR AND CONCENTRIC TO BORE DIAMETER.

10. INSPECTION REQUIREMENT - MANUFACTURER: PENETRANT INSPECT ALL FLANGES IN ACCORDANCE WITH ASTM E1417. ACCEPTANCE CRITERIA: .015 DIA MAXIMUM ROUNDED INDICATIONS, NO LINEAR OR CRACK INDICATIONS.

/11/ THIS DIMENSION REQUIRED ONLY FOR SIZES UP TO -325 INCLUSIVE. FOR SIZES OVER -325, DIA A IS STRAIGHT TO THE BACK RADIUS PER AS1895/12 AND DOES NOT REQUIRE ANGLED SURFACE TRANSITION.

	AEROSPACE STANDARD	AS1895™/2 SHEET 2 OF 3	REV. D
	FLANGE, MALE, SEAM WELD TYPE I STANDARD PROFILE		