

2.2.4 Elbows with long Radii

Table 2.2.4_1: Available elbows with long radii

Outside pipe Ø mm	Wall thickness mm ²⁾	Minimum radius mm ^{1) 3)}
18 – 60.3	1.5–5.0	300
> 60.3 – 76.1	2.0–5.0	300
> 60.3 – 76.1	1.5–2.0	400
> 76.1 – 88.9	2.0–4.0	300
> 76.1 – 88.9	1.5–2.0	500
> 76.1 – 88.9	4.0–5.0	500
> 88.9 – 98	1.5–4.0	500
> 98 – 101.6	2	500
> 98 – 101.6	2–4.0	1,000
>101.6 – 114.3	1.5–4.0	1,000
104	2	300
105	2.0–2.5	300
106	2.0–3.0	300
108	2.0–4.0	300
110 – 120	2.0–5.0	300
>120 – 145	2.0–6.0	375
>145 – 168.3	2.0–6.0	450
> 168.3 – 184	2.0–6.0	525
>184 – 195	2.0–6.0	600
>195 – 219.1	3.0–6.0	600
>195 – 219.1	2.5–8.0	1,000
>195 – 219.1	2.0–8.0	1,500
> 219.1 – 240	3.0–6.0	675
> 219.1 – 240	3.0–8.0	1,000
> 219.1 – 240	2.5–8.0	1,200
> 219.1 – 240	2.0–8.0	1,800
>240 – 273	3.0–6.0	750
>240 – 273	3.0–8.0	1,000
>240 – 273	2.0–8.0	2,000
>273 – 290	3.0–6.0	800
>273 – 290	3.0–8.0	1,200
>290 – 318	3.0–6.0	900
>290 – 318	3.0–8.0	1,200
323.9	3.0–6.0	900
323.9	3.0–8.0	1,200

Available elbows with long radii

- cold bent, free of folds
- with or without straight ends
- according to specifications
- not cut square, sawn ends
- not heat-treated, pickled
- other materials available at customer request

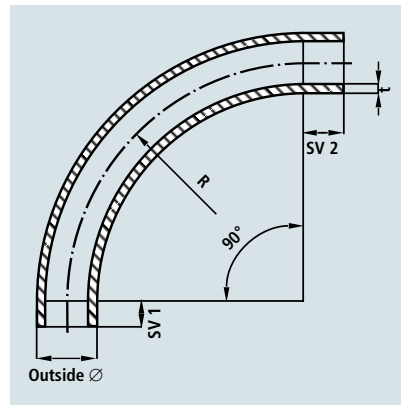
¹⁾Radius tolerance up to NB 80 ± 15 mm, then ± 30 mm for radius over 1,500 mm = ± 50 mm, and radius over 2,500 mm = ± 80 mm.

²⁾Note weakening of walls depending on degree of bend. This may be 10–30%.

³⁾For materials with 0.2 % strength ≥ 300N/mm², the minimum radius is 400 mm or 4× NB.

These elbows can be bent from pipe to any desired radius in the dimensions given in the production table above. However, please note the minimum radii listed in table 2.2.4_1; smaller radii are not possible.

Straight ends – without circumferential welds – can be provided. The elbows can also be supplied with RAUMATIC roughened inside surfaces, a preferred finish for the transport of polyethylene granulate. The wall thicknesses listed apply to **stainless steel elbows**.



See also ...

- Chapter 2.1.10: "RAUMATIC pipes – solutions for pneumatic conveyor technology"
- Chapter 2.2.2: "Elbows according to DIN 2605"
- Chapter 2.2.7: "Elbows with long radii ensure a safe, clean and careful transport of your products"

No guarantee for correctness

2.2.5 Elbows with long Radii in Duplex

Table 2.2.5_1: Available elbows in duplex – 1.4462 with long radii

Outside pipe Ø mm	Wall thickness mm ²⁾	Minimum radius mm ^{1) 3)}
18 – 60.3	1.5–5.0	300
> 60.3 – 76.1	2.0–5.0	300
> 60.3 – 76.1	1.5–2.0	400
> 76.1 – 88.9	2.0–4.0	300
> 76.1 – 88.9	1.5–2.0	500
> 76.1 – 88.9	4.0–5.0	500
> 88.9 – 98	1.5–4.0	500
> 98 – 101.6	2	500
> 98 – 101.6	2–4.0	1,000
> 101.6 – 114.3	1.5–4.0	1,000
104	2	400
105	2.0–2.5	400
106	2.0–3.0	400
108	2.0–4.0	400
110 – 120	2.0–5.0	500
> 120 – 145	2.0–6.0	600
> 145 – 168.3	2.0–6.0	600
> 168.3 – 184	2.0–6.0	600
> 184 – 195	2.0–6.0	800
> 195 – 219.1	3.0–6.0	1,000
> 219.1 – 240	2.0–6.0	1,000
> 240 – 273	3.0–6.0	1,500
> 273 – 290	3.0–6.0	1,500
> 290 – 318	3.0–6.0	1,500
323.9	3.0–6.0	1,500

No guarantee for correctness

Available elbows with long radii

- cold bent, free of folds
- with or without straight ends
- according to specifications
- not cut square, sawn ends
- not heat-treated, pickled

¹⁾Radius tolerance up to NB 80 ± 15 mm, then ± 30 mm for radius over 1,500 mm = ± 50 mm, and radius over 2,500 mm = ± 80 mm.

²⁾Note weakening of walls depending on degree of bend. This may be 10–30%.

³⁾For materials with 0.2 % strength ≥ 300 N/mm², the minimum radius is 400 mm or 4× NB.

These elbows can be bent from pipe to any desired radius in the dimensions given in the production table above. However, please note the minimum radii listed in table 2.2.5_1; smaller radii are not possible. Straight ends – without circumferential welds – can be provided.

See also ...

- Chapter 2.1.3: “Pipes from duplex material grades”
- Chapter 2.2.3: “Elbows according to DIN 2605 in duplex steel”