



**American Water Works
Association**

ANSI/AWWA C110/A21.10-12
(Revision of ANSI/AWWA C110/A21.10-08)

The Authoritative Resource on Safe Water®

AWWA Standard

Ductile-Iron and Gray-Iron Fittings



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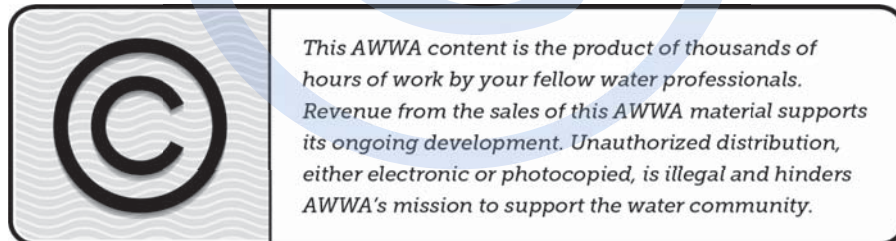
AWWA Standard

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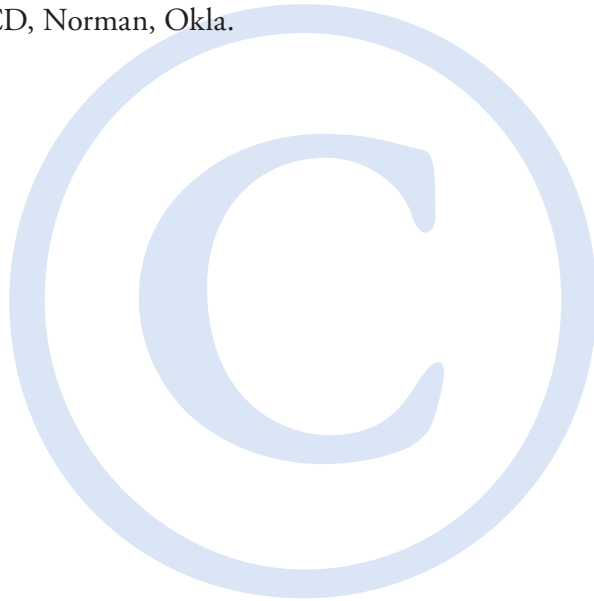
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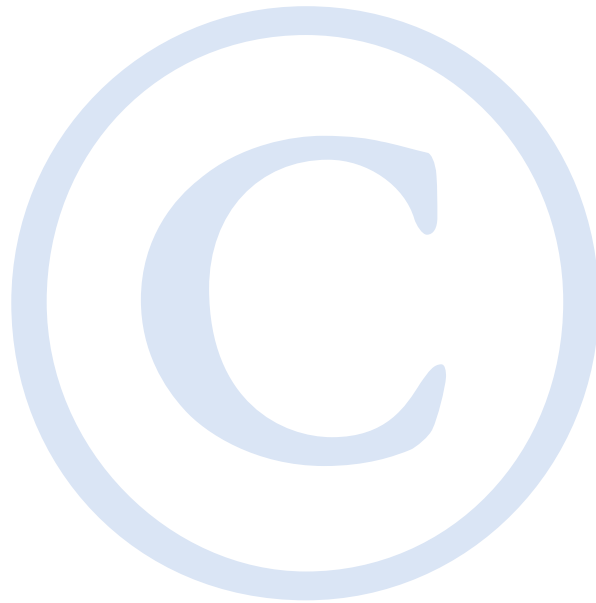
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Foreword

This foreword is for information only and is not a part of ANSI/AWWA C110/A21.10.*

I. Introduction.

I.A. *Background.* American National Standards Committee A21 on Cast-Iron Pipe and Fittings was organized in 1926 under the sponsorship of the American Gas Association (AGA), the ASTM International (ASTM), the American Water Works Association (AWWA), and the New England Water Works Association (NEWWA). Between 1972 and 1984, the co-secretariats were AGA, AWWA, and NEWWA, with AWWA serving as administrative secretariat. In 1984, the committee became an AWWA committee with the name AWWA Standards Committee A21 on Ductile Iron Pipe and Fittings. In 1988, NEWWA withdrew as a separate secretariat; however, it continues to maintain its representation on the A21 Committee. In 1997, AGA withdrew as co-secretariat.

The present scope of Committee A21 activity is the development of standards and manuals addressing ductile-iron pressure pipe for water and ductile-iron and gray-iron fittings for use with such pipe. These standards and manuals include topics, such as design, dimensions, materials, coatings, linings, joints, accessories, methods of inspection and testing, and installation.

The work of Committee A21 is conducted by subcommittees. The scope of Subcommittee 3, Fittings, includes the periodic review of current A21 standards for fittings and the preparation of revisions and new standards, when needed, for fittings to be used with cast-iron and ductile-iron pressure pipe included in A21 standards.

I.B. *History.* The evolution of AWWA and ANSI standards for fittings is presented in this foreword to provide information relating to systems having aged cast-iron pipe and fittings still in service.

The earliest record of an AWWA standard for cast-iron pipe is contained in the Report of Proceedings of the Tenth Annual Meeting of the American Water Works Association (1890). In 1902, NEWWA adopted a more detailed standard titled "Standard Specification for Cast Iron Pipe and Special Castings."

The next AWWA standard for pipe and fittings, AWWA 7C.1-1908, was approved May 12, 1908. A second edition, AWWA C100-52T, was approved by AWWA Dec. 31, 1952, and by NEWWA Jan. 23, 1953. The third edition, AWWA C100-54T,

* American National Standards Institute, 25 West 43rd Street, Fourth Floor, New York, NY 10036.

was approved by AWWA Oct. 25, 1954, and finally issued as AWWA C100-55, having been advanced from tentative to standard without change June 17, 1955. AWWA C100-55 covered fittings in the size range 4 to 60 in. (100 to 1,500 mm). The fittings were bell and spigot (caulked joint) of the so-called long-radius design. The outside diameter (OD) for spigots varied with wall thicknesses, which were designated classes A, B, C, and D. Fittings 4 to 12 in. (100 to 300 mm) were made to class D patterns, having only one OD and pressure rating. Fittings 14 to 24 in. (350 to 600 mm) in size were provided in classes B and D, and fittings 30 to 60 in. (750 to 1,500 mm) in size were provided in classes A, B, C, and D. Fittings made in accordance with AWWA 7C.1-1908 and C100-55 had the class identification cast on the fitting.

ASA* A21.10-1952 (AWWA C110-52) was approved by ASA Sept. 30, 1952, following approval by AWWA May 4, 1951. The standard described 3- to 12-in. (80- to 300-mm) fittings of the so-called short-body design, which were the subject of extensive research and tests by Committee A21. The rated pressure given by the standard was 250 psi (1,724 kPa) plus water hammer. The standard provided a safety factor of 2.5 plus water hammer based on burst tests. Hydraulic losses were determined and compared with those found with long-radius fittings manufactured in accordance with AWWA Standards. The minimum grade of cast iron in the standard was 25,000 psi (172.4 MPa) tensile strength.

ASA A21.10-1964 (AWWA C110-64) was approved by ASA Jan. 9, 1964. The revision described 2- to 48-in. (50- to 1,200-mm) fittings. The design of the 14- to 48-in. (350- to 1,200-mm) fittings in the revision was based on an exhaustive series of burst tests. The minimum grade of cast iron (25,000 psi [172.4 MPa] tensile strength) was retained, and higher grades up to 35,000 psi (241.3 MPa) tensile strength were used to secure higher pressure ratings without radically changing the thicknesses. Ductile iron, grade 80-60-03, was also added in the 14- to 48-in. (350- to 1,200-mm) sizes with a rated working pressure of 250 psi (1,724 kPa), having the same wall thicknesses as 150-psi (1,034-kPa) rated gray-iron fittings. The minimum safety factor based on burst tests of representative fittings of the weakest type was three times the rated working pressure. Tables for flanged fittings and mechanical-joint fittings were added for the first time.

* American Standards Association (ASA) is the former name of the American National Standards Institute.

ANSI A21.10-1971 (AWWA C110-71) was approved by ANSI July 14, 1971. Ductile-iron fittings were added in sizes 3 to 12 in. (80 to 300 mm) and were rated for 350 psi (2,413 kPa) working pressure. The grade of ductile iron was changed to 70-50-05 to provide greater toughness. The safety factor against bursting was three times the rated working pressure. If required by the purchaser on special order, fittings were required to withstand a hydrostatic proof test not to exceed one and one half times the rated working pressure without leaks or permanent distortions.

ANSI A21.10a-1972 (AWWA C110a-72) was approved Dec. 17, 1972, as a supplement to ANSI A21.10-1971. The pressure rating for 14- to 24-in. (350- to 600-mm) ductile-iron fittings was increased to 350 psi (2,413 kPa).

ANSI/AWWA C110-77 (ANSI A21.10) was approved by ANSI Apr. 7, 1977. The major change in this revision was the discontinuance of bell-and-spigot fittings (caulked joints) and 2- and 2¹/₄-in. (50- and 56-mm) fittings in the standard. These actions were taken because the use of caulked joints had steadily declined until their use had become a rarity and the 2- and 2¹/₄-in. (50- and 56-mm) sizes were no longer manufactured in the United States. (Bell-and-spigot fittings are still available from some foundries on special order.) With the elimination of 2- and 2¹/₄-in. (50- and 56-mm) sizes, the standard included 3- to 48-in. (80- to 1,200-mm) mechanical-joint and flanged fittings only.

Another change made in the 1977 edition was in bolt lengths for flanged fittings to comply with ANSI/AWWA C115/A21.15-75, Standard for Flanged Cast-Iron and Ductile-Iron Pipe With Threaded Flanges. Appendix A was added to the standard to cover bolts, gaskets, and the installation of flanged fittings. Appendix B was added as a listing of available special fittings that are not a part of the standard. These include reducing bends, Y-branches, blind flanges, reducing tees, bullhead tees, flared fittings, side-outlet tees and elbows, and wall pipe.

The following note introduced in the 1977 edition cautioned about using mechanical-joint fittings with aged existing cast-iron pipe:

NOTE: Care should be used when connecting mechanical-joint fittings to aged existing cast-iron pipe. The outside diameter of aged pipe should be measured prior to cutting since some of the older pipe was manufactured to a larger diameter than is presently specified in A21 standards. Mechanical-joint sleeves or bell-and-spigot (caulked-joint) sleeves are available to provide transition from existing cast-iron pipe; however, they must be specified on the purchase order. Center to bottom-of-socket dimensions (dimension *A* in Table 3 and dimension *J* in Table 4 of this standard) for A21.10 mechanical-joint fittings are the same as the center to bottom-of-socket

dimensions for bell-and-spigot (caulked-joint) fittings specified in the 1971 and previous editions of A21.10. The following standards contain reference dimensions useful in classifying existing cast-iron pipe:

AWWA 7C.1-1908 (AWWA C100-55), Standard Specifications for Cast Iron Pressure Fittings, Table 1.

ASA A21.2-1953 (AWWA C102-53), American Standard for Cast Iron Pit Cast Pipe for Water or Other Liquids, Tables 2.1 and 2.2.

ANSI A21.6-1975 (AWWA C106-75), American National Standard for Cast-Iron Pipe Centrifugally Cast in Metal Molds for Water or Other Liquids, Tables 6.4, 6.5, and 6.6.

ANSI A21.8-1975 (AWWA C108-75), American National Standard for Cast Iron Pipe Centrifugally Cast in Sand-Lined Molds for Water or Other Liquids, Tables 8.4, 8.5, and 8.6.

ANSI/AWWA C110/A21.10-82, as approved by ANSI Aug. 24, 1982, introduced no major revisions.

ANSI/AWWA C153/A21.53-84 (First Edition), American National Standard for Ductile-Iron Compact Fittings, 3 In. through 12 In. (80 mm through 300 mm), for Water and Other Liquids, was approved by ANSI Feb. 4, 1985. This standard, developed by Standards Committee A21, Subcommittee 3, Fittings, presents compact fittings designed to use the attendant strength of ductile iron.

ANSI/AWWA C151/A21.51-86, American National Standard for Ductile Iron Pipe Centrifugally Cast in Metal Molds or Sand-Lined Molds for Water or Other Liquids, Tables 51.4 and 51.5.

ANSI/AWWA C110/A21.10-87 was approved by ANSI Oct. 30, 1987. The major revisions included new sections on rejection of fittings and determination of rejection, and ductile-iron grade 60-42-10 was added. Cast marking of the country where cast was added; Sec. 10-4.3, Joint Accessories, was added; and 14-in. through 48-in. (350-mm through 1,200-mm) solid sleeves made with B-pattern equipment were added.

ANSI/AWWA C110/A21.10-93 was approved by ANSI Aug. 10, 1993. Major revisions in this edition of the standard included the addition of a section on health effects and permeation, allowance for reduced metal-section thicknesses for ductile-iron glands, addition of a precautionary note on the use of flange gaskets thinner than 1/8 in. (3.2 mm) in appendix A, addition of flanged-joint bolt tightening sequence to appendix A, and the addition of a section on ring gaskets in appendix A.

ANSI/AWWA C110/A21.10-98 was approved by ANSI September 10, 1998. Major revisions included limiting the scope to water service, noting the possibility of 350 psi

(2,413 kPa) rating for 12 in. (300 mm) and smaller flanged fittings with the use of special gaskets, and the optional status of seal coat on cement–mortar linings. Table 1 was revised to include plus tolerances on the K1, K2, and L dimensions; longer bolt lengths for 42 -and 48-in. (1,050- and 1,200-mm) sizes; and the footnote on ductile-iron glands. Tables 16 through 19 were revised to show 3- through 12-in. (80- through 300-mm) flanged ductile-iron fittings with the same dimensions as gray-iron fittings.

ANSI/AWWA C110/A21.10-03 was approved by ANSI on October 7, 2003. Major revisions included recognition of the current scope of the A21 Committee. The scope of the standard was amended and Tables 12 and 15 through 19 were footnoted to recognize that 24-in. (600-mm) and smaller flanged fittings may be rated for 350 psi (2,413 kPa) with the use of specially designed gaskets, either ring or full-face, using annular rings molded into the gasket to improve performance as recommended by the manufacturer.

The scope of the standard was additionally revised to include a surge allowance. Sec. 4.3.1 was revised to reference ANSI/AWWA C111/A21.11 for the details of mechanical joint bell, plain end, and accessories. The figure and table providing details of the mechanical joint were deleted. Sec. 4.4.4 was revised to include fusion-bonded epoxy coating systems as a manufacturer's option.

ANSI/AWWA C110/A21.10-08 was approved by the AWWA Board of Directors on Jan. 27, 2008. Major revisions included expansion of the scope and purpose to include wastewater and reclaimed water and additional requirements for materials.

This edition was approved on Jan. 22, 2012.

I.C. Acceptance. In May 1985, the US Environmental Protection Agency (USEPA) entered into a cooperative agreement with a consortium led by NSF International (NSF) to develop voluntary third-party consensus standards and a certification program for direct and indirect drinking water additives. Other members of the original consortium included the American Water Works Association Research Foundation (AwwaRF, now Water Research Foundation) and the Conference of State Health and Environmental Managers (COSHEM). The American Water Works Association and the Association of State Drinking Water Administrators (ASDWA) joined later.

In the United States, authority to regulate products for use in, or in contact with, drinking water rests with individual states.* Local agencies may choose to impose requirements more stringent than those required by the state. To evaluate the health

* Persons outside the United States should contact the appropriate authority having jurisdiction.

effects of products and drinking water additives from such products, state and local agencies may use various references, including

1. An advisory program formerly administered by USEPA, Office of Drinking Water, discontinued on Apr. 7, 1990.
2. Specific policies of the state or local agency.
3. Two standards developed under the direction of NSF, NSF*/ANSI 60, Drinking Water Treatment Chemicals—Health Effects, and NSF/ANSI 61, Drinking Water System Components—Health Effects.
4. Other references, including AWWA standards, *Food Chemicals Codex*, *Water Chemicals Codex*,[†] and other standards considered appropriate by the state or local agency.

Various certification organizations may be involved in certifying products in accordance with NSF/ANSI 61. Individual states or local agencies have authority to accept or accredit certification organizations within their jurisdiction. Accreditation of certification organizations may vary from jurisdiction to jurisdiction.

Annex A, “Toxicology Review and Evaluation Procedures,” to NSF/ANSI 61 does not stipulate a maximum allowable level (MAL) of a contaminant for substances not regulated by a USEPA final maximum contaminant level (MCL). The MALs of an unspecified list of “unregulated contaminants” are based on toxicity testing guidelines (noncarcinogens) and risk characterization methodology (carcinogens). Use of Annex A procedures may not always be identical, depending on the certifier.

ANSI/AWWA C110/A21.10 does not address additives requirements. Thus, users of this standard should consult the appropriate state or local agency having jurisdiction in order to

1. Determine additives requirements, including applicable standards.
2. Determine the status of certifications by parties offering to certify products for contact with, or treatment of, drinking water.
3. Determine current information on product certification.

II. Special Issues.

II.A. *Advisory Information on Product Application.* Unless otherwise provided in the purchaser’s documents, all fittings and accessories shall comply with this standard.

* NSF International, 789 N. Dixboro Road, Ann Arbor, MI 48105.

† Both publications available from National Academy of Sciences, 500 Fifth Street NW, Washington, DC 20418.

III. Use of This Standard. It is the responsibility of the user of an AWWA standard to determine that the products described in that standard are suitable for use in the particular application being considered.

III.A. *Purchaser Options and Alternatives.* The following items should be provided by the purchaser:

1. Standard used—that is ANSI/AWWA C110, Ductile-Iron and Gray-Iron Fittings, of latest revision.
2. Size, joint type, pressure rating (Sec. 1.1 and tables).
3. Details of other federal, state or provincial, and local requirements (Sec. 4.1.1)
4. For applications other than potable water, whether compliance with NSF/ANSI 61, Drinking Water System Components—Health Effects, is required (Sec. 4.1.2).
5. Permeation (Sec. 4.2)
6. Joint requirements (Sec. 4.3.1 and 4.3.2).
7. Joint accessory requirements (Sec. 4.3.3).
8. Type of iron required, gray or ductile (Sec. 4.3.4).
9. End combinations for nonstandard fittings (Sec. 4.3.5).
10. Type of coating and lining required: asphaltic coating, cement–mortar lining, or fusion bonded epoxy lining (Sec. 4.4.1). If cement–mortar lining is required, identify if asphaltic seal coat is required or not (Sec. 4.4.3)
11. Elimination of lining (either cement–mortar lining or fusion bonded epoxy), and if eliminated, identify whether to apply asphaltic lining or not (Sec. 4.4.5). Experience has indicated that the petroleum asphaltic inside coating is not complete protection against loss in pipe capacity caused by tuberculation. Cement–mortar linings are recommended for most waters.
12. Special coatings and linings requirements (Sec. 4.4.5 and 4.4.6).
13. Special flange bolt-hole orientation (Sec. 4.5.3.2).
14. Requirement for certification by manufacturer (Sec. 5.1.3).
15. Inspection by purchaser (Sec. 5.2).
16. Acceptance tests requirements transverse or tensile (Sec. 5.4.1.1).
17. Special tests requirements (Sec. 5.6).

III.B. *Special Service Requirements.* The following special service requirements should be noted:

1. The fittings for which this standard is intended are those normally used for potable water, wastewater, and reclaimed water. The 120°F (49°C) temperature maximum (Sec. 1.1) reflects immersion temperature limitations of most epoxies. Seal-

coated cement–mortar lining and bare cement–mortar linings have higher temperature limitations. Consult the manufacturer for service requirements above 120°F (49°C).

2. The method of installation of fittings depends on the type of joint and should be made in accordance with applicable parts of ANSI/AWWA C111/A21.11, Rubber-Gasket Joints for Ductile-Iron Pressure Pipe and Fittings; ANSI/AWWA C600, Installation of Ductile-Iron Mains and Their Appurtenances; and recommendations of manufacturers regarding their product.

3. Attention is directed to an apparent conflict between this standard and ASME B16.1, Cast Iron Pipe Flanges and Flanged Fittings, with regard to pressure ratings for flanged fittings.

In ANSI/AWWA C110/A21.10, flanged joint fittings are rated for 150- or 250-psi (1,034- or 1,724-kPa) working pressure, depending on the material, that is, gray iron or ductile iron; the wall thickness of gray iron; and the size of the fitting. The ratings of these fittings were established on the basis of hydrostatic testing of fittings to bursting and provide for a factor of safety of at least 3.0 at the rated working pressure and at ambient temperature. ANSI/AWWA C110/A21.10 flanges that are adequate for water service of 250-psi (1,724-kPa) working pressure have facing and drilling identical to ASME B16.1 class 125 flanges and match class 125 B16.1 flanges that for service at –20° to 150°F (–28.9° to 65.6°C) are rated for only 150 to 200 psi (1,034 to 1,724 kPa), depending on the flange size and the class or grade of iron.

ASME B16.1 describes both separate flanges and flanged fittings of gray iron for service at both ambient and elevated temperatures. The pressure-temperature ratings of these flanges, as stated in ASME B16.1 and stated on the flyleaf of that standard, are not based on burst strength, but have evolved over an extended period of time of satisfactory performance in a wide range of general service conditions. These ratings encompass pressure combined with elevated temperature, stresses imposed by piping, thermal stresses caused by temperature variations, and many other conditions causing stress in the flange or fitting.

ASME B16.1 also contains the design of a class 250 flange, which is much heavier, has a larger bolt circle, and uses larger-sized bolts than the B16.1 class 125 flange and the flanges described in ANSI/AWWA C115/A21.15 and in this standard. ASME B16.1 class 250 flanges will not connect to the B16.1 class 125 flange, the ANSI/AWWA C115/A21.15 flange, or the ANSI/AWWA C110/A21.10 flange.

4. Although this standard does not detail the orientation of bolt holes in the flanges of the mechanical joint, it is at times convenient or necessary to have the bolt holes specially oriented. The normal but not universal practice is to have the bolt holes

straddle the vertical centerline of the fittings, valves, and hydrants. (The vertical centerline of a fitting is determined when the fitting is in the position to change the direction of fluid flowing in a horizontal plane. With standard base bends and standard base tees, the vertical centerline is determined when the fitting is in a position to change the fluid flowing in a vertical plane.) If special orientation is known to be necessary, it should be stated on the purchase order.

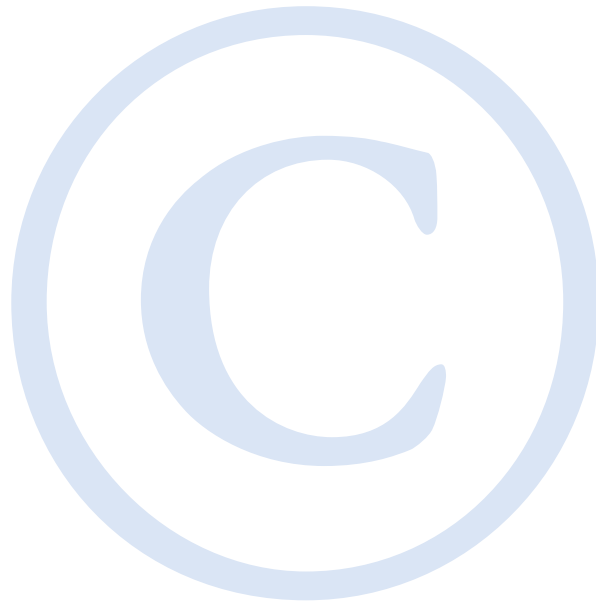
III.C. *Modification to Standard.* Any modification to the provisions, definitions, or terminology in this standard must be provided by the purchaser.

IV. Major Revisions. The major revisions made to this standard in this edition are as follows:

1. Sec. 1.1 was revised to include a temperature range.
2. A new Sec. 4.1.2 was added to include a requirement for NSF/ANSI 61 certification on products if they will be in contact with potable water.
3. Sec. 4.3.4 was revised to require a minimum safety factor of 2.5 times the rated working pressure.
4. Sec. 5.1.1 was revised to better describe parameters affecting test frequencies.
5. Sec. 5.3.1 was revised to require dimensional checks each production run.
6. Sec. 5.4.2.1.1 was revised to include 65-45-12 grade iron.
7. Sec. 5.5.1 and Sec. 5.5.2 were revised to require testing of each melt for chemical requirements.

V. Comments. If you have any comments or questions about this standard, please call AWWA Engineering and Technical Services at 303.794.7711, FAX at 303.795.7603, write to the department at 6666 West Quincy Avenue, Denver, CO 80235-3098, or e-mail at standards@awwa.org.

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**American Water Works
Association**

AWWA Standard

Ductile-Iron and Gray-Iron Fittings

SECTION 1: GENERAL

Sec. 1.1 Scope

This standard describes 3- to 48-in. (80- to 1,200-mm)* gray-iron or ductile-iron fittings to be used with ductile-iron pipe for potable water, wastewater, and reclaimed water for a temperature range of 33°–120° F (0.6°–49°C). Requirements for fittings with mechanical joints and flanged joints are listed in Tables 3 through 21 at the end of this standard. This standard may also be used for fittings with push-on joints or such other joints as may be agreed on at the time of purchase.

For the 3- to 24-in. (80- to 600-mm) size range, ductile-iron mechanical-joint fittings and ductile-iron push-on-joint fittings are rated for 350-psi (2,413-kPa) working pressure. Ductile-iron flange-joint fittings are rated for 250-psi (1,724-kPa) working pressure; however, 24-in. (600-mm) and smaller sizes may be rated for 350 psi (2,413 kPa) with the use of special gaskets. Gray-iron fittings having all types of joints described in this standard are rated for 150- or 250-psi (1,034- or 1,724-kPa) working pressures, as shown in the tables.

For the 30- to 48-in. (750- to 1,200-mm) size range, fittings with all types of joints described in this standard are shown in the tables with rated working

* Metric identifiers in this standard are nominal sizes and are not those specified in International Organization for Standardization (ISO) standards.