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1 Product description

**Welded socket**
Welded sockets are used for connection of level and pressure sensors to the process. Depending on the version, the process fitting is optional or belongs to the scope of delivery. Depending on the version, accessory parts such as welding dummies and blind stoppers are available.

**Adapter**
Screwed adapters are used for adaptation of level and pressure sensors with connection G¾ A or G1½ A to existing welded sockets. Depending on the version, the seal is optional or belongs to the scope of delivery.
2 Welded socket - universal

2.1 Thread

Thread G½ A  
Welded socket G½ A acc. to DIN 3852-X  
Art. no. 2.36839  
Material 316L

![Diagram 1: Dimensions welded socket G½ A acc. to DIN 3852-X]

Thread G¾ A  
Welded socket G¾ A acc. to DIN 3852-X  
Art. no. 2.36840  
Material 316L

![Diagram 2: Dimensions welded socket G¾ A acc. to DIN 3852-X]

Thread G1 A  
Welded socket G1 A acc. to DIN 3852-X  
Art. no. 2.36841  
Material 316L
Thread G1½ A

**Welded socket G1½ A acc. to DIN 3852-X**

Art. no. 36842

Material 316L

---

**2.2 Clamp according to DIN 32676, ISO 2852/316L**

**Clamp 1"**

**Welded socket Clamp 1" PN16 DIN 32676, ISO 2852/316L**

Product code ESTC.AXX

Material 316L

**Seal (optional)**

Material EPDM, FKM

**Tension ring**

Material 1.4301

---
Clamp 1½"

**Welded socket Clamp 1½" PN16 DIN 32676, ISO 2852/316L**

Product code ESTC.BXX

Material 316L

**Seal (optional)**

Material EPDM, FKM

**Tension ring**

Material 1.4301

---

Clamp 2"

**Welded socket Clamp 2" PN16 (ø 64 mm) DIN 32676, ISO 2852/316L**

Product code ESTC.CXX

Material 316L

**Seal (optional)**

Material EPDM, FKM
**Tension ring**
Material 1.4301

![Diagram of tension ring](image)

*Fig. 7: Dimensions welded socket Clamp 2" PN16 (ø 64 mm) DIN 32676, ISO 2852/316L*

**Clamp 2½"**

**Welded socket Clamp 2½" PN16 (ø 77.5 mm) DIN 32676, ISO 2852/316L**
Product code ESTC.DXX

Material 316L

**Seal (optional)**
Material EPDM, FKM

**Tension ring**
Material 1.4301

![Diagram of tension ring](image)

*Fig. 8: Dimensions welded socket 2½" PN16 (ø 77.5 mm) DIN 32676, ISO 2852/316L*

**Clamp 3"**

**Welded socket 3" PN16 (ø 91 mm) DIN 32676, ISO 2852/316L**
Product code ESTC.EXX

Material 316L
**Seal (optional)**
Material EPDM or FKM

**Tension ring**
Material 1.4301

![Diagram](image)

*Fig. 9: Dimensions welded socket 3" PN16 (ø 91 mm) DIN 32676, ISO 2852/316L*

### 2.3 Hygienic fittings

**Hygienic fitting LA**
**Welded socket LA for compression nut**
Product code ESTA.LAXXX
Material 316L

**Seal (optional)**
Material EPDM

**Welding dummy**
Product code DMONT.A
Material 1.4305

**Blind stopper**
Product code DMONT.B1
Material 316Ti
Hygienic fitting LB

**Welded socket LB for tension flange**
Product code ESTA.LBXXX

Material 316L

**Seal (optional)**
Material EPDM

**Welding dummy**
Product code DMONT.C

Material 1.4305

**Blind stopper**
Product code DMONT.D

Material 316Ti

---

**DRD connection**

**Welded socket DRD**
Product code ESTD.AAXX

Material 316L
Seal (optional)
Material PTFE

![Diagram of welded socket DRD dimensions](image)

**Fig. 12: Dimensions welded socket DRD**

**Cone connection DN 25**

**Welded socket conus DN 25**
Product code ESTK.KAXX
Material 316L

Seal (optional)
Material EPDM

![Diagram of welded socket conus DN 25 dimensions](image)

**Fig. 13: Dimensions welded socket conus connection DN 25**

**Cone connection M52 x 2**

**Welded socket conus M52 x 2**
Product code ESTK.KBXX
Material 316L

Seal (optional)
Material EPDM

![Diagram of welded socket conus M52 x 2](image)
2.4 Bolting acc. to DIN 11851

**Bolting DN 25**

*Welded socket, bolting DN 25 according to DIN 11851*

Product code ESTR.DA1X

Material 316L

**Seal (optional)**

Material FKM, EPDM, NBR

---

**Bolting DN 40**

*Welded socket, bolting DN 40 according to DIN 11851*

Product code ESTR.FA1X

Material 316L

**Seal (optional)**

Material FKM, EPDM, NBR
**Bolting DN 50**

**Welded socket, bolting DN 50 according to DIN 11851**

Product code ESTR.GA1X

Material 316L

**Seal (optional)**

Material FKM, EPDM, NBR

---

**Bolting DN 80**

**Welded socket, bolting DN 80 according to DIN 11851**

Product code ESTR.IA1X

Material 316L

**Seal (optional)**

Material EPDM, NBR
Bolting DN 100

Welded socket, bolting DN 100 according to DIN 11851
Product code ESTR.JA1X
Material 316L

Seal (optional)
Material EPDM

Bolting DN 40

Welded socket DN 40 acc. to DIN 11864-1
Product code ESTR.FBXX
Material 316L

Seal (optional)
Material FKM, EPDM or NBR
Fig. 20: Dimensions welded socket DN 40 acc. to DIN 11864-1

Bolting DN 50

Welded socket DN 50 acc. to DIN 11864-1
Product code ESTR.GBXX
Material 316L

Seal (optional)
Material FKM, EPDM or NBR

Fig. 21: Dimensions welded socket DN 50 acc. to DIN 11864-1
3 Welded socket - VEGABAR

3.1 VEGABAR 17

Thread G½ B

Welded socket G½ B acc. to ISO 228-1 - vessel
Product code ESMBR17.86*IXTX
Material 316Ti

![Fig. 22: Dimensions welded socket G½ B acc. to ISO 228-1 - vessel](image)

Welded socket G½ B acc. to ISO 228-1 - pipeline
Product code ESMBR17.86*AXVX
Material 316Ti

![Fig. 23: Dimensions welded socket thread G½ B acc. to ISO 228-1 - pipeline](image)

Thread G1 B

Welded socket G1 B acc. to ISO 228-1
Product code ESMBR17.85*IXTX
Material 316Ti
Thread G1 hygienic

Welded socket G1 aseptic

Product code ESMBR17.84*JXVX

Material 316L

---

3.2 VEGABAR 52

Thread G½ A

Welded socket thread G½ A acc. to EN 837

Product code ESMBR52.GVBKVX

Material 316L
**Thread G1 A**

**Welded socket thread G1 A according to DIN ISO 228-1**

Product code ESMBR52.GCBKVX

Material 316Ti

---

**Thread G½ B**

**Welded socket G½ B acc. to ISO 228-1 - vessel**

Product code ESMBR53.GFIXTX

Material 316Ti
Welded socket G½ B acc. to ISO 228-1 - vessel
Product code ESMBR53.GFAXVX
Material 316Ti

Welded socket G½ B acc. to ISO 228-1 - pipeline
Product code ESMBR53.GCIXTX
Material 316Ti

Thread G1 B

Welded socket G1 B acc. to ISO 228-1
Product code ESMBR53.GCIXTX
Material 316Ti
3.4 VEGABAR 54

Thread G½ A

Welded socket G½ A acc. to ISO 228-1
Product code ESMBR54.GBAXVX

Material 316L

Seal (optional)
Material Kalrez

Fig. 32: Dimensions welded socket G½ A acc. to ISO 228-1
Seal (optional)
Material Viton, EPDM, Kalrez

![Fig. 33: Dimensions welded socket G 3/4 A acc. to DIN 3852-X](image)

**Thread G1 A**

Welded socket G1 A acc. to ISO 228-1
Product code ESMBR54.GCIXTX
Material 316Ti

![Fig. 34: Dimensions welded socket G1 A acc. to ISO 228-1](image)

### 3.5 VEGABAR 52, 54 - Paper industry

**M30 x 1.5**

Welded socket M30 x 1.5
Product code ESMBR54.BFGXVX
Material 316L

Seal (optional, mounting on pressure transmitter)
Material Viton

**Welding dummy**
Product code DMONT.G
Material brass
**Blind stopper**
Material 316Ti

![Diagram of blind stopper](image)

*Fig. 35: Dimensions welded socket M30 x 1.5*

**M30 x 1.5 for headbox**

**Welded socket M30 x 1.5**
Product code ESMBR54.BSGXVX
Material 316L

**Seal (optional)**
Material Viton

**Welding dummy**
Product code DMONT.G
Material brass

**Blind stopper**
Material 316Ti

![Diagram of welded socket M30 x 1.5](image)

*Fig. 36: Dimensions welded socket M30 x 1.5 for headbox*
M44 x 1.25

**Welded socket M44 x 1.25**
Product code ESMBR**.B*MXVX

Material 316L

**Welding dummy**
Product code DMON T.F

Material brass

**Blind stopper**
Product code DMONT.H

Material 316Ti

![Dimensions welded socket M30 x 1.25](image)

**M48 x 1.5**

**Welded socket M48 x 1.5**
Product code ESMBR52.DGSXVX

Material 316L
**Fig. 38: Dimensions welded socket M48 x 1.5**

**G1" suitable for PASVE**

**Welded socket G1" suitable for PASVE**
Product code ESMBR54.VPHXVX
Material 316L

**Dummy**
Product code DMONT.S
Material brass

**Blind stopper**
Product code DMONT.P
Material 316Ti
**PMC 1"**

**Welded socket PMC 1"**

Product code ESMBR54.PCDXVX

Material 316L

---

**Fig. 39: Dimensions welded socket G1" suitable for PASVE**

**Fig. 40: Dimensions welded socket PMC 1"**
4 Welded socket - Level switch

4.1 VEGASWING 51, 61, 63

Thread G¾ A

Welded socket G¾ A acc. to DIN 3852-X
Product code ESTSG.1GBX1
Material 316L

Seal
Material FKM, EPDM

Fig. 41: Dimensions welded socket G¾ A acc. to DIN 3852-X

Thread G1 A

Welded socket G1 A acc. to DIN 3852-X
Product code ESTSG.1GAX1
Material 316L

Seal
Material FKM, EPDM

Fig. 42: Dimensions welded socket G1 A acc. to DIN 3852-X
4.2 VEGAKON

Thread G1 A

Welded socket G1 A acc. to DIN 3852-X

Product code ESTKN.1GA

Material 316Ti

Fig. 43: Dimensions welded socket G1 A acc. to DIN 3852-X
5 Adapter

5.1 G¾ A on Clamp according to DIN 32676, ISO 2852

Clamp 1½"

Adapter G¾ A according to DIN 3852-X on Clamp 1½" PN16
DIN 32676, ISO 2852/316L
Product code GEWADA-A.CG1

Material 316L

Seal (optional)
Material FKM, EPDM

![Diagram of adapter G¾ A on Clamp 1½"
DIN 32676, ISO 2852/316L](image)

**Fig. 44:** Dimensions adapter G¾ A according to DIN 3852-X on Clamp 1½" PN16 DIN 32676, ISO 2852/316L

Clamp 2"

Adapter G¾ A according to DIN 3852-X on Clamp 2" PN16 (ø 64 mm) DIN 32676, ISO 2852/316L
Product code GEWADA-A.CA1

Material 316L

Seal (optional)
Material FKM, EPDM
Fig. 45: Dimensions adapter G¾ A according to DIN 3852-X on Clamp 2" PN16 (ø 64 mm) DIN 32676, ISO 2852/316L

**Clamp 2½"**

**Adapter G¾ A according to DIN 3852-X on Clamp 2½" PN16 (ø 77.5 mm) DIN 32676, ISO 2852/316L**

Product code GEWADA-A.CD1

Material 316L

**Seal**

Material FKM, EPDM

Fig. 46: Dimensions adapter G¾ A according to DIN 3852-X on Clamp 2½" PN16 (ø 77.5 mm) DIN 32676, ISO 2852/316L

**Clamp 3"**

**Adapter G¾ A according to DIN 3852-X on Clamp 3" PN16 (ø 77.5 mm) DIN 32676, ISO 2852/316L**

Product code GEWADA-A.CE1

Material 316L

**Seal**

Material FKM, EPDM
**5 Adapter**

**Clamp 4"**

**Adapter G¾ A according to DIN 3852-X on Clamp 4" PN16 (Ø 119 mm) DIN 32676, ISO 2852/316L**

Product code GEWADA-A.CC1

Material 316L

**Seal**

Material FKM, EPDM

**Fig. 47: Dimensions adapter G¾ A according to DIN 3852-X on Clamp 32" PN16 (Ø 91 mm) DIN 32676, ISO 2852/316L**

**5.2 G1½ A on Clamp according to DIN 32676, ISO 2852**

**Clamp 3"**

**Adapter G1½ A according to DIN 3852-X on Clamp 3" PN16 (Ø 77.5 mm) DIN 32676, ISO 2852/316L**

Product code GEWADA-B.CE1

Material 316L

**Seal**

Material FKM, EPDM

**Fig. 48: Dimensions adapter G¾ A according to DIN 3852-X on Clamp 4" PN16 (Ø 119 mm) DIN 32676, ISO 2852/316L**

Mounting bosses and adapters
5.3 **G1½ A on bolting acc. to DIN 11851**

**Bolting DN 40**

Adapter G1½ A acc. to DIN 3852-X on bolting DN 40 acc. to DIN 11851

Product code GEWADA-A.RA1

Material 316L

**Seal**

Material FKM, EPDM

**Bolting DN 50**

Adapter G1½ A acc. to DIN 3852-X on bolting DN 50 acc. to DIN 11851

Product code GEWADA-A.RB1

Material 316L
Seal
Material FKM, EPDM

Fig. 51: Dimensions adapter G1½ A acc. to DIN 3852-X on bolting DN 50 acc. to DIN 11851

Bolting DN 65
Adapter G1½ A acc. to DIN 3852-X on bolting DN 65 acc. to DIN 11851
Product code GEWADA-A.RC1
Material 316L

Seal
Material FKM, EPDM

Fig. 52: Dimensions adapter G1½ A acc. to DIN 3852-X on bolting DN 65 acc. to DIN 11851

Bolting DN 100
Adapter G1½ A acc. to DIN 3852-X on bolting DN 100 acc. to DIN 11851
Product code GEWADA-A.RD1
Material 316L
Seal
Material FKM, EPDM

Fig. 53: Dimensions adapter G1½ A acc. to DIN 3852-X on bolting DN 100 acc. to DIN 11851

5.4 G1½ A on further hygienic fittings

DRD connection
Adapter G1½ A acc. to DIN 3852-X on DRD connection
Product code GEWADA-A.AA1
Material 316L

Seal
Material FKM, EPDM

Fig. 54: Dimensions adapter G1½ A acc. to DIN 3852-X to DRD

Tuchenhagen DN 32
Adapter G1½ A acc. to DIN 3852-X on Tuchenhagen DN 32
Product code GEWADA-A.TA3
Material 316L

Seal
Material EPDM
Fig. 55: Dimensions adapter G1½ A acc. to DIN 3852-X on Tuchenhagen DN 32
6 Welding instructions

Information:
The following welding instructions are for information only. In general, the relevant welding regulations must be noted. The AD leaflets must also be noted when welding on pressure vessels.

Preparations
When welding stainless steel, utmost cleanliness is necessary. E.g. it is not allowed to use rusty tools or screwed parts. Also make sure that no mild steel is processed in the closer environment.

Use enough inert gas for tack-welding. Make sure that you use tack-welding and not spot-welding. For tack-welding and welding, the protective gas pure argon must be used.

Welding dummy
The suitable welding dummy must be used to avoid the distortion of the welded socket.

Fig. 56: Welding dummy
1 Welded socket
2 Dummy
3 Pipeline or vessel wall

Welding procedure
It is generally recommended to divide the weld joint into several segments.
After welding a segment, weld immediately the segment that lies exactly opposite. Interrupt the welding process after welding two segments until the weld joint cools or carefully cool the weld joint yourself before you start welding again.

**Pressure bearing**

The pressure loading capacity depends on the quality of the welding as well as the material of the welded socket. With threaded sockets, the thread length must be used completely bearing.
7 Supplement

7.1 Technical data

General data

Material 316L corresponds to 1.4404 or 1.4435, 316Ti corresponds to 1.4571.

Max. process temperature on the welded socket, depending on the seal

- FKM: -20 ... +120 °C (-4 ... +248 °F)
- FFKM: -20 ... +120 °C (-4 ... +248 °F)
- EPDM: -40 ... +120 °C (-40 ... +248 °F)
- EPDM cleaning temperature max. 1 h: -40 ... +140 °C (-40 ... +284 °F)
- NBR: -20 ... +105 °C (-4 ... +221 °F)
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All statements concerning scope of delivery, application, practical use and operating conditions of the sensors and processing systems correspond to the information available at the time of printing.

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