



Metal Seated Ball Valves

Engineered Valves for Severe Service Reliability with Innovative Process Solutions

Severe Series
Extreme Series
Shut-Off Class IV, V & VI



Automated Metal Seated
Valves of All Types Shown
with High Temperature Extension

Flo-Tite works with customers to design valves tailored to their specific needs. Knowledge of applications, materials and design allows our engineers to find solutions to problems quickly and effectively.

Extreme Temperatures, Extreme Pressures and Your Toughest Application Challenges

- ANSI - Class - Flanged Ends
- 150, 300, 600, 900, 1500, 2500
- Size 1/2" thru 24 inch
- Floating & Trunnion Types
- On-Off & Modulating Options
- Threaded Ends
- Socket and Butt Weld Ends
- 2250 / 3000 / 6000 PSI Ratings
- Two & Three PC Designs
- 3 & 4 Way Multiport Designs

Severe Series

Demanding services requiring resistance to abrasion, erosion, corrosion, solids and high temperatures beyond the capabilities of polymer seated ball valves, temperatures up to 800 °F

Extreme Series

Applications where temperatures exceed 800 °F & up to temperatures as high as 1200 °F. Media build-up, cycling with solids in the line & erosive attack of materials & coatings. Flo-Tite extreme series valves are designed & developed for the most severe services heavy industry has to offer.

Tri-Ton Series

High pressure 3pc ball valve
 Manufactured from forged or bar stock materials
 This series is manufactured to your exact specifications
 Available in all ANSI pressure classes from 150 thru 2500
 Consult factory for more information on this series



3/4" SW
6000 PSI

Corrosion / Erosion Resistance

- Extend the life of metals with a wide selection of surface coatings, available for valve internal / externals. These coatings include Teflon, chrome, electroless nickel, zinc phosphate, galvanizing & many more options.

In-line Repairability

- Three-piece valve assembly
- Valve body can be easily removed while end connections remain in-line
- Allows valve body to be tested after repair, prior to insertion back in the pipe line

Ball & Seats

- Mate-lapped for 100% sealing contact
- Ensures absolute shutoff per ANSI classification
- Corrosion resistant
- Seats are protected from flow in open / closed position
- Seats are available as field replaceable sets

Body Gaskets

- Encapsulated spiral wound body seals guarantee zero leaks to the surrounding area.
- Lowers contact stresses

Seat Spring

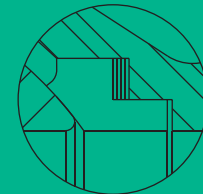
- Assisted by line pressure, provides a constant mechanical force on ball against seat to maintain a tight seal

Quarter-turn, Non-rising Stem

- Live loaded expanded graphite stem seals guarantees zero leaks and low emissions
- Quick open / close operation, compact design

Scraper Seat Design

Flo-Tite's scraper seat is ideal for most difficult applications where build-up of damaging fluid deposit may occur on the ball face. Overtime, this occurrence to the critical smooth ball surface will cause the ball to become rough and dull rendering the valve inoperative. This problem is most common in pulp making recovery in white, black & green liquors.



Standards and Specifications

Valves covered in this bulletin are available to conform to the following industry standards and specifications

All valves are manufactured to ISO 9001 quality standards.

WW-V-35C	Federal Specification: Valve, Ball
ANSI/ASME B16.10	Face-to-Face / End-to-End Dimensions of Ferrous Valves
ANSI/ASME B16.5	Steel Pipe Flanges and Flange Fittings
ANSI/ASME B16.34	Steel Valves - Flanged and Buttwelded End
ANSI/ASME B31.1	Power Piping
ANSI/ASME B31.3	Chemical Plant & Petroleum Refinery Piping
ANSI/FCI 70-2-1976	For Control Valve Leakage
BS 6755, Part 2	Testing of Valves - Specification for Fire Type Testing
ISO 5752:1982	Metal Valves for use in Flanged Piping Systems
ISA 75.02	Valve Sizing Coefficient Cv, Piping Geometry Factor Fp and Pressure Drop Limitation XT
ISA 575.19	Hydrostatic Testing of Control Valves
ISO 5211	Dimensions for Attachment of Actuators/Gear Boxes to Valves (ISO Mounting)
MSS-SP-25	Standard Marking Systems for Valves
MSS SP-55	Quality Standards for Steel Castings

MSS-SP-6	Standard Finishes for Contact Faces of Pipe Flanges and Connecting-End Flanges of Valves and Fittings
MSS-SP-44	Steel Pipe Line Flanges
MSS-SP-61	Pressure Testing of Steel Valves
MSS-SP-72	Flanged or Butt and Weld End Ball Valves Having Full or Reduced Bores for General Liquid and Gas Service
MSS-SP-96	Terminology for Valves and Fittings
NACE MR01-75	Sulfide Stress Cracking Resistant Materials for Oilfield Equipment.

Optional Standards & Specification

API 608	Metal Ball valves Used in On-Off Service that have Buttwelded or Flanged Ends for Size 1/2" NPS - 12" NPS
API 6D	Specifications for Pipeline Valves
API 598	Valve Inspection and Testing
MSS-SP-53	Quality Standard for Steel Casting and Forging for Valves, Flanges and Fittings and Other Piping Components-Magnetic Particle Examination Method
MSS-SP-93	Quality Standard for Steel Casting and Forging for Valves, Flanges and Fittings and Other Piping Components-Liquid Penetrant Method

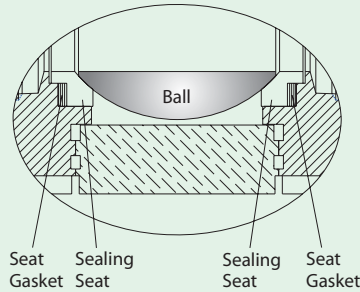
G Seat - Graphite Sealed Seat

(B1)

A series of Graphite seal rings behind the metal seat, coupled with a Graphite outer diameter seat seal, prevent media from building up behind the seat. The rings also allow for expansion of the internal valve components in high temperature applications.

Temperature Range:
200 to 800 deg F
Application: Steam, Abrasion, High Temperatures, Fine Solids
Shut-Off: Class V, VI

Bi-Directional Flow



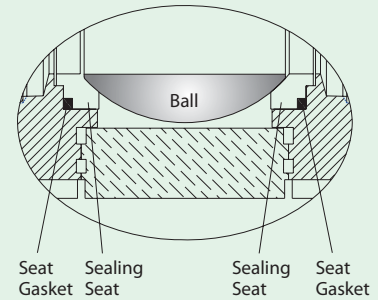
O Seat - O-Ring Sealed Seat

(B2)

A double seal design providing both spring loading and excellent sealing capabilities. There is no area for media to build up behind the seat, which prevents the valve from locking up.

Temperature Range:
-150 to 500 deg F
Application: Steam, Abrasion, Low Pressure Differentials, Fine Solids, Emulsions
Shut-Off: Class IV, Class V, Class VI

Bi-Directional Flow



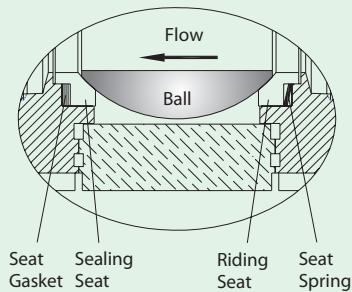
P Seat - Spring Loaded

(B3)

For unidirectional applications. The sealing seat is available as a separate seat ring for reparability, or integral with the tailpiece for high temperature applications. The spring seat OD seal prevents media from building up between the spring and the back of the seat.

Temperature Range:
400 to 1200 deg F
Application: Steam, Low Pressure Differentials, High Temperatures
Shut-Off: Class V, Class VI
Preferred automated design

Uni-Directional Flow



R Seat - Replaceable Seat Design

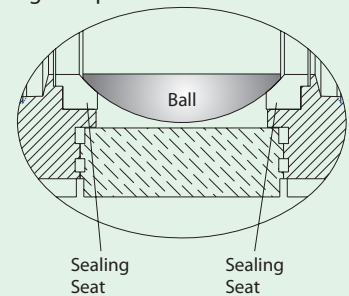
(B4)

This seat design is an ideal choice for that application that exceeds the requirements for the high temperature soft seated ball valves.

All valve balls are upgraded to assure a precise spherically finish. If needed, this valve is considered as drop-in replacement of the valve seat and can be rebuilt in the field. No special machining is required.

Temperature Range:
400 to 650 deg F
Application: Steam, Low Pressure Differentials, High Temperatures
Shut-Off: Class V, Class VI

Bi-Directional Flow

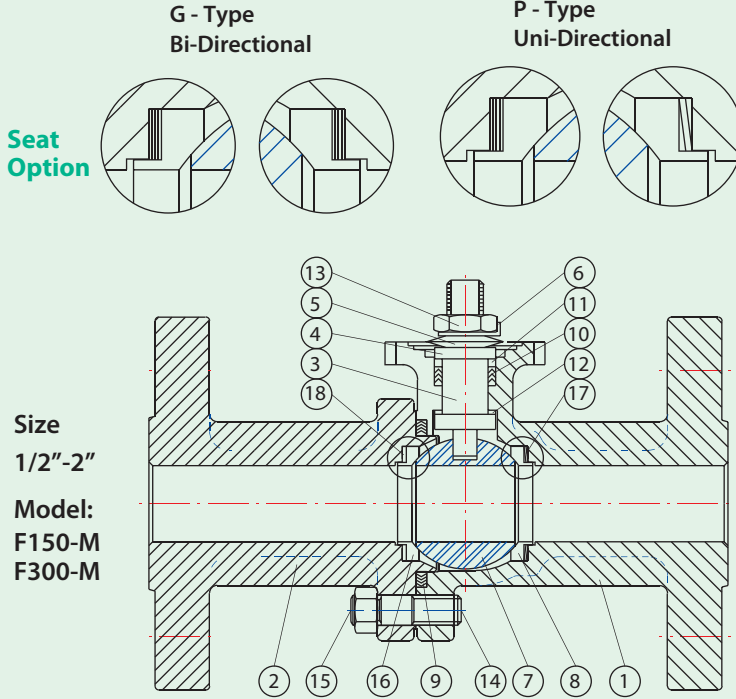


High-Temperature Metal-Seated Ball Valves are well suited for a variety of demanding services where high-temperature and abrasive solids are present

Features:

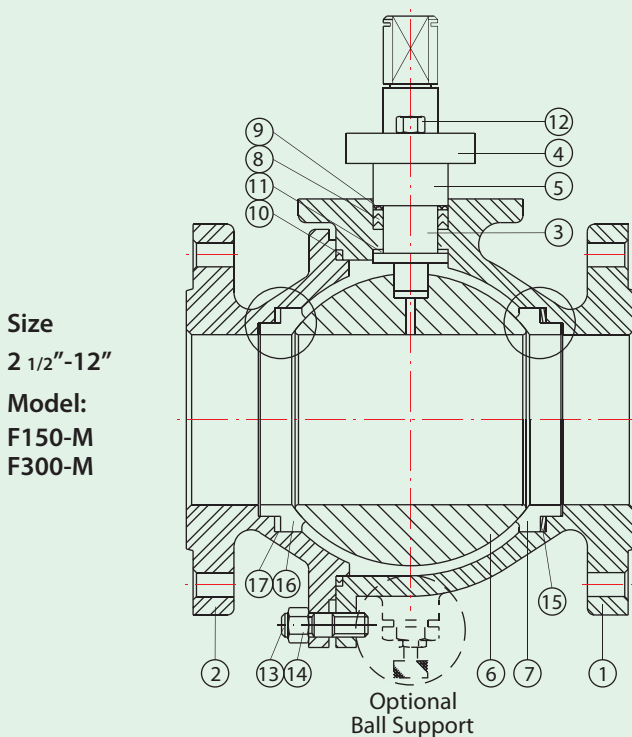
- The spring seat design provides freedom for thermal expansion of the ball without jamming, even at extreme temperatures. Proven in qualification tests and field operation to be excellent, even for the toughest applications on slurry service with solids.
- 17-4PH internal entry stem provides extra strength and durability in severe services.
- Ball solid, high-sphericity 316 stainless steel with hard chrome plating provides durability in severe applications while maintaining a smooth, low turbulence flow.
- Flo-Tite's non-magnetic cobalt based superalloy maintains good strength up to 2150°F. AMS 5759 requires minimum yield strength of 45,000 psi at room temperature. This material maintains good oxidation resistance up to 1900°F. Unique ability to resist corrosion in very severe environments. Highly resistant to hydrochloric acid, nitric acid and wet chlorine (subject to need for exercising care in its selection at certain concentrations and temperatures)

Metal Seated Flanged End Connection Severe Series / Full Port Technical Submittal



Standard Bill of Materials

NO.	Name	Materials	
		Stainless Steel	Carbon Steel
1	Body	ASTM A351 CF8M	ASTM A216 WCB
2	Cap	ASTM A351 CF8M	ASTM A216 WCB
3	Stem	SS316 / 17-4PH	
4	Packing Follower	SS304	
5	Belleville Washer	SS301	
6	Lock Washer	SS304	
7	Ball	SS316 Chrome Plated	
8	Riding Seat	SS316 w / Stellite / 17-4 PH	
9	Gasket	Spiral Wound Wire SS316 / Graphite	
10	Stem Packing	TFM / Graphite	
11	Packing Protector	50%PTFE+SS316	
12	Thrust Washer	Nitronic 60	
13	Thin Nut	SS304	
14	Body Stud	ASTM A193 B8	ASTM A193 B7
15	Body Nut	ASTM A194 Gr.8	ASTM A194 2H
16	Sealing Seat	SS316 w / Stellite / 17-4 PH	
17	Spring	17-4PH / Inconel	
18	Seat Gasket	TFM / Graphite	

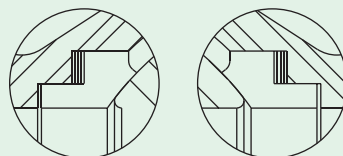


Standard Bill of Materials

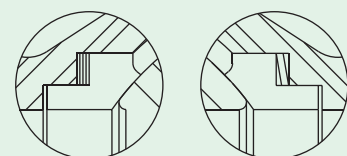
NO.	Name	Materials	
		Stainless Steel	Carbon Steel
1	Body	ASTM A351 CF8M	ASTM A216 WCB
2	Cap	ASTM A351 CF8M	ASTM A216 WCB
3	Stem	SS316 / 17-4PH	
4	Packing Gland	ASTM A351 CF8	
5	Packing Follower	SS304	
6	Ball	SS316 Chrome Plated	
7	Riding Seat	SS316 w / Stellite / 17-4 PH	
8	Stem Packing	TFM / Graphite	
9	Packing Protector	50%PTFE+SS316	
10	Gasket	Spiral Wound Wire SS316 / Graphite	
11	Thrust Washer	Nitronic 60	
12	Gland Bolt	SS304	Steel
13	Body Stud	ASTM A193 B8	ASTM A193 B7
14	Body Nut	ASTM A194 Gr.8	ASTM A194 2H
15	Spring	17-4PH / Inconel	
16	Sealing Seat	SS316 w / Stellite / 17-4 PH	
17	Seat Gasket	TFM / Graphite	

Seat Option

**G - Type
Bi-Directional**



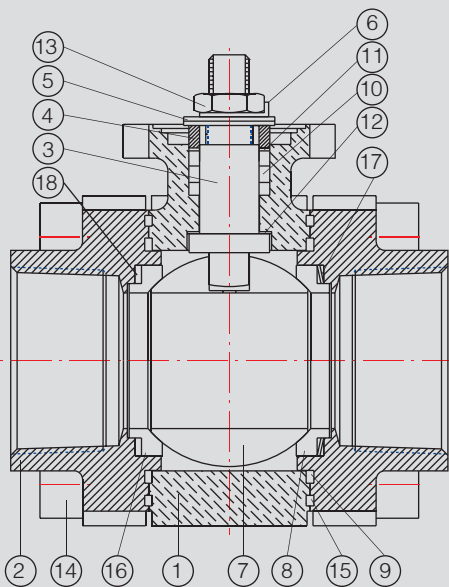
**P - Type
Uni-Directional**



Metal Seated Threaded & Welded Connections

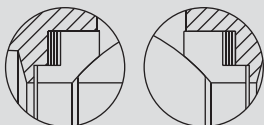
Technical Submittal

Model
 Size 1/2"-2" HPF51/52/53-M
 HPF41/42/43-M

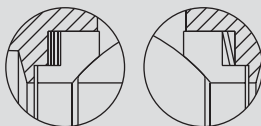


Seat Option

G - Type
 Bi-Directional



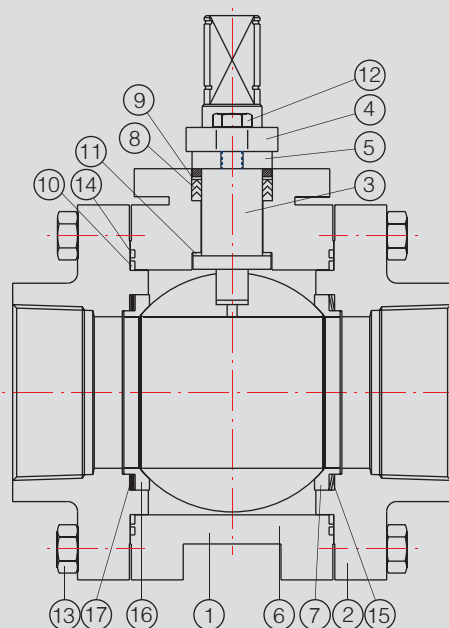
P - Type
 Uni-Directional



Standard Bill of Materials

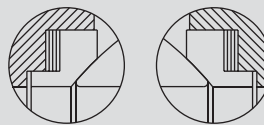
NO.	Name	Materials	
		Stainless Steel	Carbon Steel
1	Body	ASTM A351 CF8M	ASTM A216 WCB
2	Cap	ASTM A351 CF8M	ASTM A216 WCB
3	Stem	SS316 / 17-4PH	
4	Packing Follower	SS304	
5	Belleville Washer	SS301	
6	Lock Washer	SS304	
7	Ball	SS316 Chrome Plated	
8	Riding Seat	SS316 w/ Stellite/17-4 PH	
9	Gasket, Inner	Graphite	
10	Stem Packing	TFM / Graphite	
11	Packing Protector	50%PTFE+SS316	
12	Thrust Washer	Nitronic 60	
13	Thin Nut	SS304	
14	Body Bolt	ASTM A193 B8	ASTM A193 B7
15	Gasket, Outer	Graphite	
16	Sealing Seat	SS316 w/ Stellite / 17-4 PH	
17	Spring	17-4PH / Inconel	
18	Seat Gasket	TFM / Graphite	

Model:
 Size 2 1/2"-4" HPF51/52/53-M
 HPF41/42/43-M

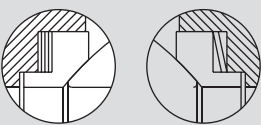


Seat Option

G - Type
 Bi-Directional



P - Type
 Uni-Directional



Standard Bill of Materials

NO.	Name	Materials	
		Stainless Steel	Carbon Steel
1	Body	ASTM A351 CF8M	ASTM A216 WCB
2	Cap	ASTM A351 CF8M	ASTM A216 WCB
3	Stem	SS316 / 17-4PH	
4	Packing Gland	ASTM A351 CF8	
5	Packing Follower	SS304	
6	Ball	SS316 Chrome Plated	
7	Riding Seat	SS316 w/ Stellite / 17-4 PH	
8	Stem Packing	TFM / Graphite	
9	Packing Protector	50%PTFE+SS316	
10	Gasket, Inner	Graphite	
11	Thrust Washer	Nitronic 60	
12	Gland Bolt	SS304	Steel
13	Body Stud	ASTM A193 B8	ASTM A193 B7
14	Gasket, Outer	Graphite	
15	Spring	17-4PH / Inconel	
16	Sealing Seat	SS316 w/ Stellite / 17-4 PH	
17	Seat Gasket	TFM / Graphite	

Flo-Tite's Unique Design Options

Unique Problem solving ball designs eliminate most common problems found in the typical ball valve.

Class VI Shut - Off



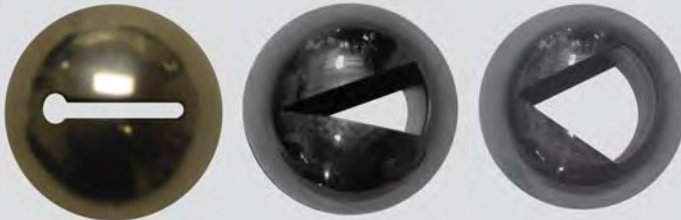
Flo-Tite's unique escaping ball design relieves ball-seat contact during the 90-degree rotation. Full ball seat contact is made at the beginning and at the end of the 90-degree stroke. This reduced contact results in longer life for the class VI shut-off with lower operating torques and improved overall performance.

The escaping ball design is an exceptional design for metal seated valves when class VI shut-off is required.

Flo-Tite's Media Cap unit provides an added safety feature with the addition of a secondary set of graphite stem packing with a live loaded design using Belleville washers that automatically compensate for temperature and pressure fluctuation, maintaining a leak proof seal for an extended cycle life. This unit's focus is on safety with duplicate stem seals and added height which helps distance and protect the valve operator from dangerous high temperature heat.



**Redundant Seals
Assuring Added
Safety**



Control ball or slotted V-ports 15, 30, 60, 90 deg V.

Accurate Flow Control

Flo-Tite offers modulating V-port control valves. The V-ball is characterized to meet all custom flow requirements.

From simple on-off to modulating control applications See tech bulletin page 120.

Ball Surface Treatments and Coatings

Choosing the right hard surface technique for ball coatings is key in overcoming a wide variety of application problems. These surfaces must resist high temperature wear, galling and corrosion, in addition to maintaining total sealability.

Hard Chrome Plating is very hard electroplate exceeding Rockwell C-67. Together with its low coefficient of friction and its self-lubricating properties. Hard Chrome is an ideal material for any wear surfaces. It can be used in applications up to 2000 °F with no ill effects.

Nitriding is a surface treatment technique that significantly increases the hardness and wear resistance of austenitic 300 series stainless steel, by thermochemical diffusion.

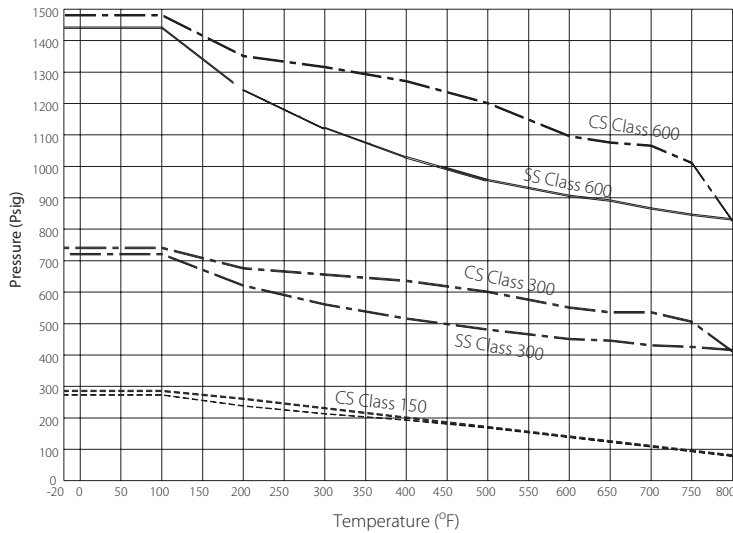
Tungsten Carbide with a cobalt binder coating applied by HVOF techniques similar to Cr3C2. WC-Co coating applied mainly to 400 series martensitic stainless steel results with micro-hardness as high as 72 Rc. This coating resists cryogenic temperature down to -320 °F (-196 °C) and high temperatures up to 1000 °F (538 °C). WC-Co is a wear resistance and dense coating with chemical resistance to sulphur environment on Nickel based alloy.

Stellite, A cobalt-based stellite coating provides excellent mechanical wear resistance, with good corrosion resistance at temperatures up to 1000 °F (538 °C).

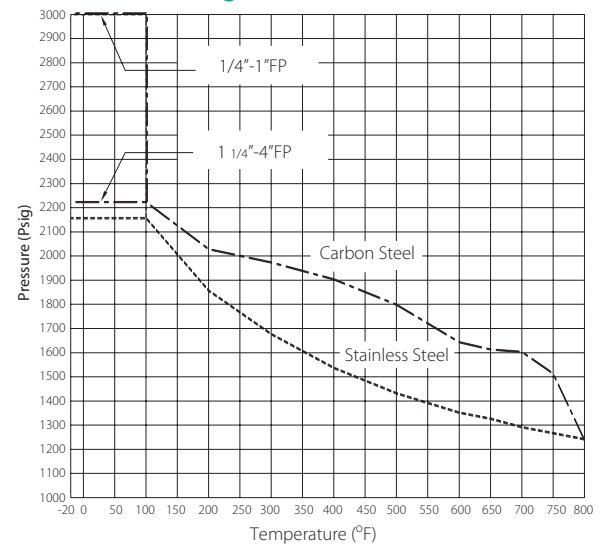
Design & Technical Data

Pressure Temperature Chart

Flanged End Designs



Three Piece Designs



Hydrostatic Testing - psi [bar]

Class	Material	Shell	Seat
150	Carbon Steel	450 [31]	320 [22]
	Stainless Steel	425 [29]	315 [22]
300	Carbon Steel	1125 [78]	820 [57]
	Stainless Steel	1100 [76]	800 [55]
600	Carbon Steel	2225 [153]	1630 [112]
	Stainless Steel	2175 [150]	1590 [110]

Hydrostatic Testing - psi [bar]

Class	Material	Shell	Seat
1/4"-1"	Carbon Steel	4500 [310]	3300 [228]
	Stainless Steel	4500 [310]	3300 [228]
1 1/4"-4"	Carbon Steel	3350 [231]	2450 [167]
	Stainless Steel	3250 [224]	2380 [164]

For 6000psi valve shell and seat test pressure, consult factory

Note: WCB carbon steel valves limited to -20°F [-29°C]; Higher Pressures/Temperatures available with optional seat design

Unconditional Firesafe Provision & Inherent electrical continuity

While metal seats are extremely heat resistant, other sealing components such as packing and gaskets are made of heat resistant flexible graphite. No part of the valve will be affected by extraordinary heated environments.

The provision of an anti-static device is not required because of inter-component electric conductivity.

Allowable Industry Leakage Standard

Flo-Tite valves are designed to meet ANSI/FCI requirements, meeting a shut-off class of IV, V or VI

CODE	Class or Seat Type	Test Fluid	Test Pressure	Allowed Pressure	Notes
ANSI/FCI 70-2-1976	I				No Tests performed by agreement between user & Mfg.
	II	Water or air	Lesser of 45-60 psig or max. Pressured difference	0.5% of full rated valve capacity	Pressure and flow measured within - 10%
	III	Water or air	Lesser of 45-60 psig or max. Pressured difference	0.1% of full rated valve capacity	Pressure and flow measured within - 10%
	IV	Water or air	Lesser of 45-60 psig or max. Pressured difference	0.01% of full rated valve capacity	Pressure and flow measured within - 10%
	V	Water	Max. difference Pressure or by agreement	5x10 ml per min per in. dia. Per psi	Pressure and flow measured within - 10%
	VI	Air or nitrogen	Lesser of 45-60 psig or max. Pressured difference	Per B16,104 table to 3" nom. dia	Approx. 6 or less bubbles per min. per in of dia.

Class V: The most frequently specified leakage class is class V, and the Flo-Tite standard.

Class VI: is frequently misinterpreted as "bubble-tight". Actually, a certain amount of leakage is allowed. Coincidentally, this leakage often is measured by the number of bubbles of air that escapes per minute within the established test guidelines.

The bubble-tight term is normally associated with resilient seated valves.

Valve Automation

Flo-Tite is a specialist in valve automation systems offering all types of pneumatic and electric actuators



Multiported - Valves

Flo-Tite offers a wide selection of metal seated 3 & 4 way valves, designs to simplify piping systems.



Trunnion Design Valves

Flo-Tite also offers its metal seated options in our TM - Series
Size range up to 48"
All ANSI pressure classes
Wide selection of body materials and designs



Quotation Information

When quoting metal seated valves, it is very important that we have the following information:

- Valve Type
- Pressure Class
- Materials
- Line Pressure
- Temperature
- Media
- Flow Direction
- Class Shut-Off Required
- Tag Required
- Flow Arrow Required

Applications

Power Generation

- Control Valve Isolation
- Bottom Ash Isolation
- Superheater Spray
- Boiler Feed Pump
- Main Steam Supply
- Main Boiler Drain

Refining

- Coal Slurry Handling
- Heavy Oil Units
- Hydrogen Isolation
- Coker - Isolation
- Catalyst Slurry
- Hydrotreating Units

Technical information such as dimensions, weights, Cv and assembly exploded views Can be found in our standard catalog brochure for all valve series

Flanged End Tech Bulletin Page 58

3PC Tri-Pro Tech Bulletin Page 51

3 Way Multiport Bulletin Page 90



Flo-Tite, Inc.
305 East 21st Street
Lumberton, NC 28358

P.O. Box 1293
Lumberton, NC 28359
Website: www.flotite.com

Tel: (910) 738-8904
Fax: (910) 738-9112
E-mail: flotite@nc.rr.com