

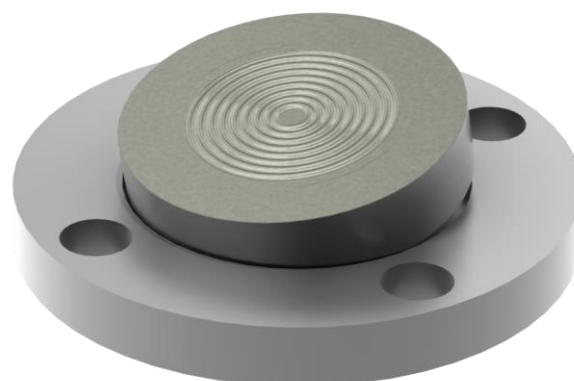
FSO-BRF type seal - flush diaphragm

Design description

The FSO-BRF construction is designed to obtain a diaphragm seal with full wetted parts in exotic materials. With Badotherm's unique resistance weld technology, a stainless steel body (non-wetted) has its wetted parts (diaphragm and raised face portion) covered by sheet material in the required exotic material. This is far more economic than producing the full flange in exotic material. FSO-BRF is typically used in combination with (differential) pressure transmitters for applications such as level, flow and (absolute) pressure measurement.

Diaphragm in exotic materials

The unique feature of the BRF is the Badotherm resistance-weld technology. The stainless steel body (non-wetted) has its wetted parts (diaphragm and raised face area) covered by sheet material in the required exotic material. The standard thickness of diaphragm foil is 0.075mm, for some materials other thickness may be available.



Body Material	Diaphragm material		
	General name	UNS	Wst.
AISI 316(L)	AISI 304L	S30400	1.4306
	AISI 321	S32100	1.4541
	AISI 316 UG	S31603	1.4435
	AISI 304L	S30400	1.4306
	25-22-2 LMN	S31050	1.4466
	AISI 316 UG	S31600	1.4435
	AISI 904L	N08904	1.4539
	Alloy 20	N08020	2.4660
	Alloy 400	N04400	2.4360
	Alloy 600	N06600	2.4816
	Alloy 625	N06625	2.4856
	Alloy 825	N08825	2.4858
	Alloy B2	N10665	2.4617
	Alloy C-22	N06022	2.4602
	Alloy C-276	N10276	2.4810
	254 SMO (6Mo)	S31254	1.4547
	Duplex 2205	S32205	1.4462
	Super Duplex 2507	S32750	1.4410
	Nickel 201	N02201	2.4068
	Tantalum	R05200	-
	Titanium Gr. 1	R50250	2.7025
	Zirconium 702	R60702	-

Flange size, rating and facings - ASME B16.5

ASME B16.5			
Size	Rating	Facing	Roughness
1" to 4"	cl. 150 - cl. 2500	RF, LMF, FF	Ra 3.2-6.3 µm
		SMF	Ra <3.2 µm

Flange size, rating and facings - EN 1092-1

EN 1092-1			
Size	Rating	Type	Roughness
DN20 to DN100	PN10-400	A, B1, F	Ra 3.2-12.5 µm
		B2	Ra <0.8-3.2 µm

Flange size, rating and facings – JIS B2220

JIS B2220			
Size	Rating	Type	Roughness
DN25 to DN100	10-20K	RF	Ra 3.2-12.5 µm

Cover flanges

FSO seals are equipped with a cover flange of a different material than the seal body material. The material can be selected based on pressure/temperature rating, corrosive ambient conditions, or other influencing conditions. Examples are A350 LF2, A105, F55, AISI 321, or in combination with one of the polymer coatings.

Gold Coating

Due to its design, gold coating on the BRF designed is not recommended.

-> See datasheet "Gold coatings"

Polymer Coatings

Polymer solutions come in several types. Additional specifications of the polymer solutions (thickness, temperature limitation, and more) can be found in datasheet "polymer solutions". Due to its design, BRF has only a few options available:

- PTFE coating (low temp applied)
- PTFE sheet

-> See datasheet "Polymer solutions"

Capillary tube and armor (protection)

The standard capillary mounting position is top side (axial) of the seal. The standard tube material is TP316 (316SS), optionally available in Alloy 400. There are three options in ID of the capillary; 2mm, 1mm, and 0.7mm. Badotherm capillaries are always protected against mechanical forces by armor. This doubled shielded armor consist is standard AISI 304, and optionally AISI 316. Additionally, the armor could be protected with a PVC sleeve in white, black, optionally with ATEX114 approval to protect against dust and water ingress and possibly corrosive ambient atmosphere.

-> See datasheet "Capillary lines"

Flush rings and flush flanges

Badotherm offers matching flush rings or flush flanges to their diaphragm seal. On request equipped with blind plugs, vent plug and or flushing / draining needle valves, which can be fitted or welded to the complete construction.

-> See datasheet flush rings

-> See datasheet flush flanges

-> See datasheet reducer flanges

Lifting handles

Larger sizes and ratings of diaphragm seals can weigh up to 50 kg. Handling and installation can become a challenge. As from 15kg it is recommended to apply a set of lifting handles, welded on the sides of the flange of the seal. This can be used to handle it easier and install it in a safer way or have attach lifting tools to it.

-> See datasheet "diaphragm seal accessories"

Material Certification

Material traceability and related certification are applicable for all process wetted parts. Material certification possibilities depend on the type of seal, the assembly construction and the materials used. Material certification is in accordance with EN10204 3.1.

Additional material certification and testing can be provided on request, such as Positive Material Identification (PMI), Intergranular corrosion (IGC) testing, material certification in accordance with EN10204 3.2, NACE conformity for ISO-15156 (MR-0175) and/or ISO-17945 (MR-0103), NORSOK M-630 and many more.

-> Please note that the responsibility for material selection always rests with the user.

Flange Marking & Traceability

All flanges are marked by the forging shop with heat number, material designation, size, and rating. Badotherm adds a Badotherm reference number and the manufacturers name to the flange for traceability purposes.

Flanges and origin

The seal parts are made from forged materials according to the applicable standards. The standard sourcing of flanges is of international origin. Optionally regional preference can be requested, for example materials from EU origin.

Testing

All seals are helium tested according the EN 13185 test procedure A.3 up to 10^{-9} mbar l/s before used on a diaphragm seal application.

-> See datasheet "Diaphragm Seal testing"

Cleanliness of the wetted parts

All parts are standard cleaned from excessive oil and grease. When additional requirements are needed, the parts can be cleaned according customer requirements and cleaning specifications.

Limitations

There are some limitations in mounting the FSO-BRF to pressure instruments.

- $\leq 1.5"$ (DN25) can have maximum capillary length 6 mtr
- Direct mount is always with 80mm extension tube.

Gaskets

For the BRF soft gaskets are advised, such as camprofil (grooved) gaskets. Sizes of the diaphragm area are designed to match the gaskets used between the process and seal or flush ring. For the ASME B16.5 RF flanges the ASME B16.20 is used for dimension restriction to ensure both the spiral and grooved gaskets are fully supported by the serrated area. For the EN type B1 flanges the gasket dimensions are matching the sizes of the EN 1514-2. The size "G" in the tables refer to the start of the gasket surface.

Example performance calculation

Whether a diaphragm seal can be used for a specific measurement, depends on the size of the diaphragm. That size is restricted by the size of the diaphragm seal.

For pressure transmitters, Badotherm offers an online performance calculation tool to calculate its performance and to ensure that the diaphragm size is suitable for your measurement.

The table below presents the minimum span of the respective diaphragm sizes with standard process conditions. As rule of thumb, a TPE of max 5% is often considered acceptable, but it depends per situation.

Minimum span table

dD	AP/GP	DP
23.5mm	17.5 bar	na
32mm	11 bar	1850 mbar
44mm	1575 mbar	255 mbar
57mm	415 mbar	70 mbar
72mm	155 mbar	30 mbar
81mm	110 mbar	20 mbar

Pressure transmitter; ambient temperature -10...+30°C; process temperature 100°C with BSO 22 fill fluid; 3 meter capillary; ID 1mm, DP both sides mounted with seal

See the general overview of all diaphragm sizes with several standard situations and in combination with Badotherm pressure gauges.

Retaining screws

The cover flange and the seal part are fixed together hexagon socket cap screws. The length of the screws depends on the thickness of the cover flange.

Grade bolt	Type	Size
A2-70 (ISO 3506-1)	ISO 4762	M6

Standards used

Design Standards

Standard	Description
ASME B16.5 - 2020	Pipe flanges and flanged fittings
ASME B16.20 - 2017	Metalic gaskets for flanges
EN 1092-1 - 2018	Circular flanges for pipes
EN 1514-2 - 2021	Dimensions of gaskets
JIS B2220 - 2012	Japanese Flange Standard
GOST 33259 - 2015	Russian Flange Standard

Test Standards

Standard	Description
ISO 20485 - 2018	Non-destructive testing - Leak testing - Tracer gas method

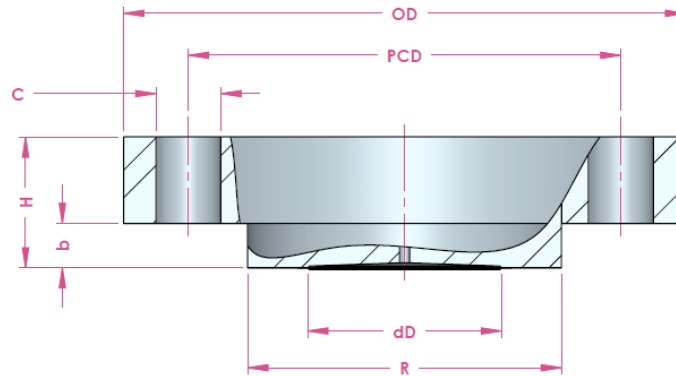
Material Standards

Standard	Description
NACE MR0175/MR0103 ISO 15156 - 2020	use in H ₂ S-containing environments in oil and gas production
NORSOK M-630 - 2010	specification for use in pipelines
ASTM standards	Material specific standards

Certification Standards

Standard	Description
EN 10204 - 2017	Inspection documents
ASME IX	Welding, Brazing, and Fusing Qualifications
ISO 15610	Specification and qualification of welding procedures for metallic materials

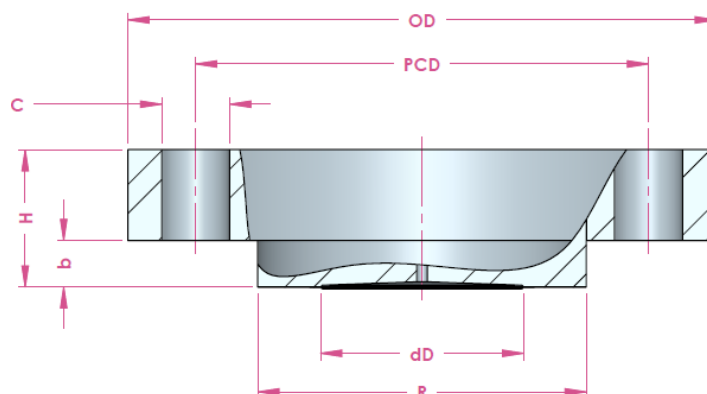
Dimensions table: ASME 16.5 RF facing



size	rating	OD	b	H	PCD	C / pcs	dD	R	f	weight
1"	cl. 150	108.0	18.0	30.7	79.2	15.9 / 4x	23.0	50.8	1.5	1.2
	cl. 300	124.0		33.7	88.9	19.1 / 4x				1.7
	cl. 400-600	149.0		30.5	101.6	25.4 / 4x				1.9
	cl. 900-1500	159.0		41.4	108.0	15.9 / 4x			6.4	3.9
	cl. 2500	117.0		48.1	88.9	15.9 / 4x			5.4	
1.25"	cl. 150	117.0	18.0	34.4	88.9	15.9 / 4x	32.0	63.5	1.5	1.7
	cl. 300	133.0		36.0	98.6	19.1 / 4x				2.3
	cl. 400-600	159.0		34.3	111.1	25.4 / 4x				2.6
	cl. 900-1500	184.0		51.7	130.0	28.6 / 4x			6.4	4.6
	cl. 2500	127.0		34.4	98.6	15.9 / 4x			7.9	
1.5"	cl. 150	127.0	18.0	34.4	98.6	15.9 / 4x	44.0	73.0	1.5	2.1
	cl. 300	155.0		37.6	114.3	22.3 / 4x				3.3
	cl. 400-600	178.0		35.9	124.0	28.6 / 4x				3.7
	cl. 900-1500	203.0		58.1	146.0	31.8 / 4x			6.4	6.4
	cl. 2500	152.0		36.0	120.6	19.1 / 4x			11.3	
2"	cl. 150	152.0	13.0	36.0	120.6	19.1 / 4x	57.0	91.9	1.5	3.0
	cl. 300	165.0		39.2	127.0	19.1 / 8x				3.9
	cl. 400-600	216.0		39.0	165.1	25.4 / 8x				4.6
	cl. 900-1500	235.0		51.7	171.4	28.6 / 8x			6.4	10.6
	cl. 2500	190.0		64.5	152.4	19.1 / 4x			16.3	
3"	cl. 150	190.0	13.0	40.8	152.4	19.1 / 4x	81.0	127.0	1.5	6.2
	cl. 300	210.0		45.5	168.1	22.4 / 8x				8.2
	cl. 400-600	241.0		45.4	190.5	25.5 / 8x				9.4
	cl. 900	267.0		51.7	203.2	31.9 / 8x			6.4	13.9
	cl. 1500	305.0		61.3	228.6	35.0 / 8x			20.0	
4"	cl. 150	229.0	13.0	40.8	190.5	19.2 / 8x	81.0	157.2	1.5	9.1
	cl. 300	254.0		48.7	200.2	22.4 / 8x				13.6
	cl. 400	273.0		48.6	215.9	25.5 / 8x				15.2
	cl. 600	292.0		51.7	235.0	31.9 / 8x			6.4	19.0
	cl. 900	311.0		58.1	241.3	35.0 / 8x			23.3	
	cl. 1500	356.0		67.6	273.0	41.4 / 8x			31.4	
	cl. 2500	89.8		273.0	41.4 / 8x	56.0				

All dimensions in mm, weight in kg

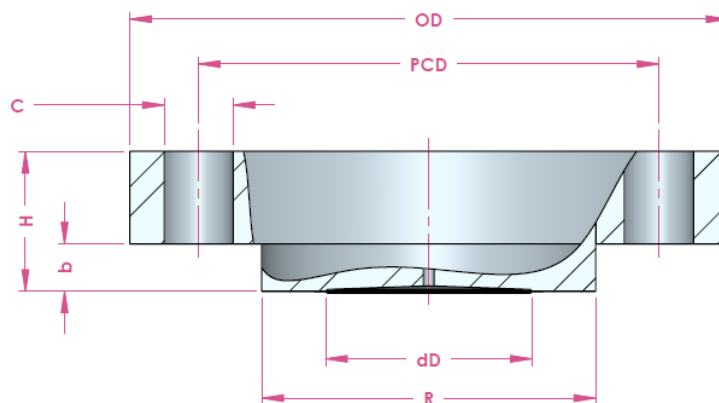
Dimensions table: EN 1092-1 B1 type



size	rating	OD	b	H	PCD	C / pcs	dD	R	f	G	Weight			
DN20	PN10-40	105.0	18.0	34.0	75.0	14.0 / 4x	23.0	58.0	2.0	33.8	1.4			
	PN63-100	130.0		38.0	90.0	18.0 / 4x					2.4			
DN25	PN10-40	115.0		34.0	85.0	14.0 / 4x	32.0				68.0	2.0	41.0	1.8
	PN63-100	140.0		40.0	100.0	18.0 / 4x								3.1
	PN160													3.5
	PN250	150.0		44.0	105.0	22.0 / 4x								3.9
	PN320	160.0		50.0	115.0									5.3
	PN400	180.0		54.0	130.0	26.0 / 4x								7.3
DN32	PN10-40	140.0		34.0	100.0	18.0 / 4x	32.0				78.0	2.0	41.5	2.5
	PN63-100	155.0		40.0	110.0	22.0 / 4x								3.8
DN40	PN10-40	150.0		34.0	110.0	18.0 / 4x	44.0				88.0	3.0	55.4	2.9
	PN63-100	170.0		42.0	125.0	22.0 / 4x								4.8
	PN160		44.0	5.3										
	PN250	185.0	50.0	135.0	26.0 / 4x	7.3								
	PN320	195.0	54.0	145.0		8.9								
	PN400	220.0	64.0	165.0	30.0 / 4x	13.9								
DN50	PN10-40	165.0	31.0	125.0	18.0 / 4x	57.0	102.0	3.0	70.2	3.6				
	PN63	180.0	37.0	135.0	22.0 / 4x					5.3				
	PN100	195.0	39.0	145.0	26.0 / 4x					6.4				
	PN160		41.0							7.1				
	PN250	200.0	49.0	150.0	26.0 / 8x					8.7				
	PN320	210.0	53.0	160.0						10.7				
	PN400	235.0	63.0	180.0	30.0 / 8x					16.1				
DN80	PN10-40	215.0	35.0	160.0	18.0 / 8x	81.0	138.0	3.0	93.0	6.6				
	PN63		39.0	170.0	22.0 / 8x					8.3				
	PN100	230.0	43.0	180.0	26.0 / 8x					10.3				
	PN160	230.0	47.0	180.0						11.2				
	PN250	255.0	57.0	200.0	30.0 / 8x					17.7				
	PN320	275.0	66.0	220.0						24.6				
	PN400	305.0	79.0	240.0						33.0 / 8x	36.9			
DN100	PN10-16	220.0	31.0	180.0	18.0 / 8x	81.0	156.6	3.0	93.0	7.0				
	PN25-40	235.0	35.0	190.0	22.0 / 8x					9.0				
	PN63	250.0	41.0	200.0	26.0 / 8x					12				
	PN100	265.0	47.0	210.0	30.0 / 8x					15.4				
	PN160		51.0							17.4				
	PN250	300.0	65.0	235.0	33.0 / 8x					29				
	PN320	335.0	76.0	265.0	36.0 / 8x					42.9				
	PN400	370.0	91.0	295.0	39.0 / 8x					64				

All dimensions in mm, weight in kg

Dimensions table: JIS 2220 RF



Size	rating	OD	dD	b	H	PCD	C / pcs	R	Weight
NS25	10K	125.0	32.0	18.0	30.0	90.0	19.0 / 4x	67.0	2.2
	16K				2.2				
	20K				3.4				
NS32	10K	135.0	44.0	18.0	32.0	100.0		76.0	2.5
	16K				2.5				
	20K				3.7				
NS40	10K	140.0	44.0	18.0	32.0	105.0		81.0	2.7
	16K				2.7				
	20K				3.0				
NS50	10K	155.0	57.0	18.0	32.0	120.0	19.0 / 8x	96.0	3.2
	16K				3.2				
	20K				3.5				
NS80	10K	185.0	81.0	18.0	34.0	150.0	23.0 / 8x	126.0	5.2
	16K	200.0			36.0				6.5
	20K	210.0			38.0				7.0
NS90	10K	195.0	81.0	18.0	34.0	170.0	19.0 / 8x	136.0	5.8
	16K	210.0			36.0				7.3
	20K	210.0			40.0				8.4
NS100	10K	225.0	81.0	18.0	34.0	175.0	19.0 / 8x	151.0	6.9
	16K				38.0				9.1
	20K				40.0				9.8

All dimensions in mm, weigh in kg

Change log

Date	Change
7-5-2020	Removed cap side (Radial) from capillary paragraph
8-3-2021	Updated dimension tables according ASME B16.5:2020
5-5-2021	Sizes H in dimension tables revised

Holland – Romania – India – Thailand – Dubai – USA

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