



1101 McKinley Street  
Anoka, MN 55303  
Phone (763) 786-6682  
Fax (763) 786-2167  
www.polycam.com



Part Name: Extra Heavy ID-Controlled Weld-On Transition Fitting

Part Number: 865-xxxx

### **ID Controlled Weld-On Transition Fitting**

**Description** - The Poly-Cam ID-Controlled Weld-On is designed to provide a smooth, interior transition between the steel pipe and the polyethylene pipe. The connection between the steel fitting and the polyethylene pipe is accomplished with a multi-level barb system and a compression ring supporting the connection. The multi-level barb system provides the sealing connection between the steel and the polyethylene pipe. The interior of the fitting contains no sharp edges in which pipeline cleaning pigs can be caught or damaged. The weld-on is coated with an epoxy coating. The compression ring is constructed out of carbon steel material and coated with an epoxy-coated material. Stainless steel compression rings are optional.

The Poly-Cam ID-Controlled Weld-On is a custom design fitting allowing the installer to transition from one specific type of steel materials to a specific type of polyethylene pipe.

Tested and complies to ASTM D2513, ASTM 1973-05, D1599, D1598

#### **Steel Material Options:**

- A53B ERW Carbon Steel / A106 Seamless Carbon Steel  
Available in the following upon request and subject to availability:  
X42, X52, X60, X65, X70, API 5L, NACE MR0175, A333 Grade 6
- 304 Stainless Steel
- 316 Stainless Steel

#### **Polyethylene Pipe Options:**

- PE 3408 ASTM F-714
- PE 3408 ASTM 2513 Gas Pipe
- PE 2406
- PE 4710

Additional options are available.

#### **Epoxy Coated Material:**

- Color HB, Red Oxide, IF1947T or Green 3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 6233

# Series 865 Extra Heavy ID Controlled Weld-On (A53/A106)

## SDR<sub>9</sub>

Nominal Size (In.)	HDPE/ Steel Pipe O.D. <b>A</b>	Steel Pipe I.D. <b>B</b>	Steel Length <b>C</b>	HDPE Pipe Length <b>D</b>	Compression Ring Length <b>E</b>	Compression Ring O.D. SDR 9 <b>F</b>	SDR 9 HDPE I.D. <b>G</b>
2	2.375	1.939	12	24	3.5	~2.95	1.815
2.5	2.875	2.323	14	24	3.5	~3.54	2.198
3	3.5	2.9	14	24	5	~4.29	2.675
4	4.5	3.826	14	24	5.5	~5.64	3.44
6	6.625	5.761	20	30	8	~8.2	5.065
8	8.625	7.625	22	30	10	~10.7	6.594
10	10.75	9.75	26	40	12	~13.4	8.219
12	12.75	11.75	28	40	12	~15.9	9.746
14	14	13	28	40	12	~17.4	10.701
16	16	15	28	48	14	~19.9	12.231
18	18	17	28	48	14	~22.4	13.76
20	20	19	28	48	15	~24.9	15.289
24	24	23	28	48	15	~29.8	18.346

