

Date: May 21, 2008

Attn: General Distribution

Re: Inner Rings Now Recommended in New **ASME B16.20 Metal Gasket Standard**

To whom it may concern:

The New Metricated Addition of the ASME B16.20 Standard has been released as of May 19, 2008. In a previous correspondence the most recent changes were explained in detail. We would like to take a moment and reiterate these changes.

Along with the switch to metric dimensions for the gaskets, the standard states that all graphite filled spiral wound gaskets will be furnished with inner rings unless otherwise specified by the purchaser. In order to receive a spiral wound gasket without an inner ring, purchasing must specifically state that no inner ring is required when placing an order. However, even if the gaskets are purchased without the inner ring the gasket will be stamped in compliance to B16.20. This change only affects graphite filled spiral wounds, since the inner rings were already required for PTFE-filled spirals.

The revision of the Standard allows a 6 month grace period for the changes to take full effect.

**Following is the new approved language for the ASME B16.20 Standard:**



“3.2.5 Inner Ring. Inward buckling of spiral wound gaskets has been identified as a potential problem. Inner rings shall be furnished with all spiral-wound gaskets having PTFE (polytetrafluoroethylene) filler material. Inner rings for flexible graphite filled spiral wound gaskets shall be furnished unless the purchaser specifies otherwise. For all filler materials, inner rings shall be furnished in spiral wound gaskets for:

- a) NPS 24 and larger in Class 900
- b) NPS 12 and larger in Class 1500
- c) NPS 4 and larger in Class 2500

Inner rings are required for these gaskets due to high available bolt loads, which may result in outer ring damage. The inner ring thickness shall be from 2.97 to 3.33mm (0.117 to 0.131 in). Tables 12 through 14 (Tables I.12 through I.14 of Appendix I) show inner ring inside diameters that may extend a maximum of 1.5mm (0.06 in.) into the flange bore under the worst combination of flange bore, eccentric installation, and tolerance. Gaskets with inner rings should be used only with socket welding, lapped, welding neck, and integral flanges. Reference Table 15 for minimum pipe wall thickness for use with gaskets with inner rings. Reference Tables 16, 17 and 18 (Tables I.16 and I.17 of Appendix I) for maximum allowable bore for use with gaskets without inner rings.”

Please do not hesitate to contact Applications Engineering with any further questions or concerns that you may have.

Sincerely,

A handwritten signature in blue ink that reads "Chad Yoder".

Chad Yoder  
Applications Engineering  
Industrial Gasketing