



18 Gauge Welded Galvanized Ductwork Specifications With Vanstone Flanges Connection

A. General : Fabricate single wall ducts, elbows, transitions, offsets, branch connections, and other construction according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible" and complying with requirements for metal thickness and minimum gauge as shown, reinforcing types and intervals, and joint intervals per static pressure class indicated.

1. Lengths : Fabricate round ducts in lengths appropriate to reinforcement and rigidity class required for pressure class. 5'-0" lengths
2. Deflection : Duct systems shall not exceed deflection limits according to SMACNA's "HVAC Duct Construction Standards - Metal and Flexible".
3. Round Fittings : Fabricate fittings to match adjoining ducts, and to comply with duct requirements as applicable to fittings. Provide fitting types as indicated on drawings.
4. Round Elbows : Except as otherwise indicated, fabricate elbows with center-line radius equal to 1-1/2 times associated duct width. Where installation requirements prevent the use of fitting types indicated on the drawings and/or with center-line radius equal to 1-1/2 times the duct width, provide center-line radius equal to 1 times the duct width.

B. Material :

1. Galvanized ASTM A527

C. Minimum Ductwork and Fittings Gauge

1. 18 GA

D. Longitudinal Seams :

1. Ductwork Seams : (RL-4) ANSI/AWS D9.1-90 Mig Welded (GMAW)
2. Fittings Seams : (RL-4) ANSI/AWS D9.1-90 Mig Welded (GMAW)

E. Transverse Joints: Vanstone Flanges

