

TABLE OF CONTENTS

FOREWORD	iii
RECTANGULAR INDUSTRIAL TASK FORCE	iv
FORMER COMMITTEE MEMBERS AND OTHER CONTRIBUTORS	iv
NOTICE TO USERS OF THIS PUBLICATION	v
TABLE OF CONTENTS	vii
CHAPTER 1 INTRODUCTION	Page
1.1 SCOPE	1.1
1.2 PURPOSE	1.1
1.3 DEVELOPMENT OF THE SECOND EDITION	1.1
1.4 INDUSTRIAL DUCT DESIGN	1.1
1.5 HOW TO USE THIS MANUAL	1.2
1.6 MANUAL CONTENTS	1.2
CHAPTER 2 INDUSTRIAL DUCT APPLICATIONS	
2.1 INTRODUCTION	2.1
2.2 DEFINITION OF INDUSTRIAL DUCT	2.1
2.3 DUCT SYSTEM CLASSIFICATION	2.1
2.4 MATERIAL (PARTICULATE) CHARACTERISTICS AND CLASSES	2.2
CHAPTER 3 DUCT MATERIALS	
3.1 INTRODUCTION	3.1
3.2 MATERIAL TYPES	3.1
3.3 CARBON AND COATED STEEL DATA	3.4
3.4 STAINLESS STEEL DATA	3.9
3.5 ALUMINUM DATA	3.12
3.6 MATERIAL PROPERTIES SUMMARY	3.14
3.7 CORROSION	3.15
CHAPTER 4 DESIGN CRITERIA	
4.1 INTRODUCTION	4.1
4.2 GENERAL PROVISIONS	4.1
4.3 NOMENCLATURE	4.1
4.4 LOADS	4.3
4.5 LIMITS AND TOLERANCES	4.7
4.6 SERVICEABILITY AND DURABILITY	4.7
4.7 DESIGN OF DUCT THICKNESS	4.7
4.8 DESIGN OF STIFFENER SIZE	4.11
4.9 DESIGN OF SUPPORT SPACING	4.12
4.10 BOLTING OF CONNECTIONS	4.13
4.11 CHECKING SHEAR CAPACITY OF DUCT SIDE WALLS	4.16
4.12 CRITERIA FOR THE DESIGN OF SYSTEMS WITH INTERNAL SUPPORTS	4.21
4.13 HANGERS AND SUPPORTS	4.24
4.14 THERMAL EXPANSION	4.26



CHAPTER 5	DESIGN EXAMPLES	Page
5.1	DESIGN EXAMPLES	5.1
5.2	SUBDIVIDING PANELS AND SELECTING INTERNAL SUPPORTS	5.30
	EXAMPLE #5-1	5.2
	EXAMPLE #5-2	5.5
	EXAMPLE #5-3	5.7
	EXAMPLE #5-4	5.12
	EXAMPLE #5-5	5.15
	EXAMPLE #5-6	5.21
	EXAMPLE #5-7	5.25
CHAPTER 6	DUCT SELECTION TABLES — CARBON AND COATED STEELS	
6.1	INTRODUCTION	6.1
6.2	SCOPE	6.1
6.3	MINIMUM MATERIAL MECHANICAL PROPERTIES	6.1
6.4	USE OF THE TABLES	6.1
6.5	DESIGN PROCESS	6.5
6.6	DUCT SELECTION TABLES	6.9
6.7	AUXILIARY TABLES	6.96
CHAPTER 7	DUCT SELECTION TABLES — STAINLESS STEEL	
7.1	INTRODUCTION	7.1
7.2	SCOPE	7.1
7.3	MINIMUM MATERIAL MECHANICAL PROPERTIES	7.1
7.4	USE OF THE TABLES	7.1
7.5	DESIGN PROCESS	7.5
7.6	DUCT SELECTION TABLES	7.9
7.7	AUXILIARY TABLES	7.17
CHAPTER 8	DUCT SELECTION TABLES — ALUMINUM	
8.1	INTRODUCTION	8.1
8.2	SCOPE	8.1
8.3	MINIMUM MATERIAL MECHANICAL PROPERTIES	8.1
8.4	USE OF THE TABLES	8.1
8.5	DESIGN PROCESS	8.5
8.6	DUCT SELECTION TABLES	8.9
8.7	AUXILIARY TABLES	8.17
CHAPTER 9	HANGERS, SUPPORTS, FASTENERS, GASKETS, AND JOINT SEALANTS	
9.1	INTRODUCTION AND SCOPE	9.1
9.2	HANGERS AND SUPPORTS COMMENTARY	9.1
9.3	GENERAL GUIDELINES	9.1
9.4	METHODS FOR HANGING AND SUPPORTING DUCT	9.2
9.5	DUCT HANGERS AND SUPPORTS	9.2
9.6	GASKETS, CAULKING, AND JOINT SEALANTS	9.14
CHAPTER 10	WELDING	
10.1	INTRODUCTION	10.1
10.2	WELDED JOINT ACCEPTED INDUSTRY PRACTICE	10.1
10.3	WELDED JOINT CONSIDERATIONS	10.1
10.4	TYPES OF JOINTS AND EDGE PREPARATION	10.8
10.5	WELDING PROCEDURES	10.8
10.6	WELDING SYMBOLS	10.16



CHAPTER 11	ACCEPTED INDUSTRIAL CONSTRUCTION PRACTICES	Page
11.1	INTRODUCTION	11.1
11.2	COMMON SEAMS AND JOINTS	11.1
11.3	FABRICATION TOLERANCES	11.1
CHAPTER 12	GUIDE SPECIFICATION	
12.1	INTRODUCTION	12.1
12.2	DRAWINGS	12.1
12.3	SEISMIC RESTRAINT PROVISIONS	12.1
12.4	GUIDE SPECIFICATION	12.1
APPENDIX A	COMMENTARY ON FORMULA DERIVATIONS AND UNITS	
APPENDIX B	SUPPLEMENTARY DESIGN DATA	
B.1	INTRODUCTION	B.1
APPENDIX C	COMMENTARY ON SURFACE PREPARATION TECHNIQUES	
C.1	INTRODUCTION	C.1
C.2	METAL SURFACE PREPARATION	C.1
APPENDIX D	REFERENCED DOCUMENTS	
D.1	ASTM STANDARDS	D.1
D.2	ANSI STANDARDS	D.2
D.3	NFPA STANDARDS	D.2
D.4	ASME STANDARDS	D.2
D.5	SMACNA STANDARDS	D.2
D.6	OTHER STANDARDS	D.2
D.7	OTHER RESOURCES	D.4
GLOSSARY		
INDEX		



TABLES

Page

2-1	Duct Classes and Minimum Conveying Velocities	4.10
2-2	Material Class Descriptions	2.4
2-3	Specific Materials Classes	2.5
3-1	Hot-rolled Steel Gages	3.4
3-2	Cold-rolled Steel Gages	3.5
3-3	Galvanized and Aluminized Steel Gages	3.6
3-4	Yield Strength Reduction Factor (η_f) at Elevated Temperatures for Carbon and Coated Steels	3.7
3-5	Modulus of Elasticity Reduction Factor (η_e) at Elevated Temperatures for Carbon and Coated Steels	3.7
3-6	Stainless Steel Gages	3.10
3-7	Yield Strength Reduction Factor (η_f) at Elevated Temperatures for Stainless Steel	3.10
3-8	Modulus of Elasticity Reduction Factor (η_e) at Elevated Temperatures for Stainless Steel	3.11
3-9	Aluminum Sheet Gages	3.12
3-10	Yield Strength Reduction Factor (η_f) at Elevated Temperatures for Aluminum	3.13
3-11	Modulus of Elasticity Reduction Factor (η_e) at Elevated Temperatures for Aluminum	3.13
3-12	Material Properties and Temperature Limits	3.14
3-13	Corrosion Chart	3.16
4-1	Coefficients for Mode B Analysis	4.10
5-1	Design Example Variables	5.1
6.1-XAX	List of Commercial Grade 32 ksi Carbon Steel Tables	6.9
6.2-XAX	List of Structural Grade 36 ksi Carbon Steel Tables	6.43
6.3-XAX	List of Structural Grade 50 ksi Carbon Steel Tables	6.69
6-X	List of Auxiliary Carbon Steel Tables	6.95
7-A.X	List of 35 ksi Stainless Steel Tables	7.9
7-X	List of Auxiliary Stainless Steel Tables	7.17
8-A.X	List of 20 ksi Aluminum Tables	8.9
8-X	List of Auxiliary Aluminum Tables	8.17
9-1	Support Capacity of Horizontal Channel	9.6
9-2	Support Capacity of Horizontal Angle	9.7
9-3	Standard Steel Pipe Column – Loads	9.8
9-4	Hanger Rod Capacity	9.9
9-5	Hanger Bar Capacity	9.9
9-6	Hanger Angle Capacity	9.9
9-7	Knee Brace Hanger Capacity	9.10
9-8	Knee Brace Support Capacity	9.11
9-9	Bolt Stress Area	9.12
9-10	Grade Markings for Steel Bolts	9.13
9-11	Gaskets, Caulking, and Joint Sealants	9.14
9-11	Gaskets, Caulking, and Joint Sealants (continued)	9.15
10-1	Allowable Stress For Stitch Welds	10.3
10-2	Welded Joint Designs — Butt Joints (B)	10.4
10-3	Welded Joint Designs — Corner and Butt Joints (C and B)	10.5
10-4	Welded Joint Designs — Corner and Tee Joints (C and T)	10.6
10-5	Gas Metal Arc Welding of Carbon Steel	10.10
10-6	Shielded Metal Arc Welding (SMAW) of Carbon Steel	10.11
10-7	Gas Tungsten Arc Welding (GTAW) of Carbon Steel	10.11
10-8	Gas Metal Arc Welding (GMAW) of Galvanized Steel	10.12
10-9	Shielded Metal Arc Welding (SMAW) of Galvanized Steel	10.12
10-10	Gas Tungsten Arc Welding (GTAW) of Galvanized Steel	10.12
10-11	Gas Metal Arc Welding of Stainless Steel	10.13
10-12	Shielded Metal Arc Welding (SMAW) of Austenitic Stainless Steel	10.14
10-13	Gas Tungsten Arc Welding (GTAW) of Austenitic Stainless Steel	10.14
10-14	Gas Metal Arc Welding of Aluminum	10.15
10-15	Gas Tungsten Arc Welding (GTAW) of Aluminum	10.15



B-1	Conversion of Wind Loads	B.3
B-2	Insulation Physical Data	B.7
B-3	Lagging Physical Data	B.8
B-4	Thermal Expansion Chart	B.9
C-1	Surface Conditions and Recommended Treatment	C.2
C-2	Surface Preparation Methods	C.2



FIGURES

Page

4-1	Critical Load Diagrams for Worst Case Conditions	4.4
4-2	Particulate Load	4.5
4-3	Panel Loading—Mode A	4.8
4-4	Panel Loading—Mode B	4.10
4-5	Stiffener Loading	4.11
4-6	Equivalent Beam Cross-Section	4.13
4-7	Flanged Connection	4.13
4-8	Types of Sidewall Buckling	4.17
4-9	Reinforcement Patch	4.18
4-10	Comparison of Critical Buckling Loads for 48 x 24 in. duct	4.19
4-11	Comparison of Critical Buckling Loads for 72 x 36 in. duct	4.20
4-12	Internal Supports	4.21
4-13	Fixed Stiffeners	4.22
4-14	Unfixed Stiffeners	4.22
4-15	Definition of Riser Support Loads	4.25
5-1	Subdividing Panels	5.31
5-2	Internal Pipe Supports	5.33
6-1	Critical Load Diagrams for Worst Case Conditions	6.4
6-2	Stiffening Guidelines for Flat Panels	6.6
6-3	Sample Panel capacity Options from Table 6.1-1A.1	6.7
6-4	Panel Thickness & Deflection per Stiffener Spacing	6.7
6-5	Stiffener Size per Stiffener Spacing	6.8
7-1	Critical Load Diagrams for Worst Case Conditions	7.4
7-2	Stiffening Guidelines for Flat Panels	7.6
7-3	Sample Panel capacity Options from Table 7-A.3	7.7
7-4	Panel Thickness & Deflection per Stiffener Spacing	7.7
7-5	Stiffener Size per Stiffener Spacing	7.8
8-1	Critical Load Diagrams for Worst Case Conditions	8.4
8-2	Stiffening Guidelines for Flat Panels	8.6
8-3	Sample Panel Capacity Options from Table 8-A.2	8.7
8-4	Panel Thickness & Deflection per Stiffener Spacing	8.7
8-5	Stiffener Size per Stiffener Spacing	8.8
9-1	Hanger Attachments to Structures	9.3
9-2	Upper Attachment Devices – Typical	9.4
10-1	Joints, Welds, and Grooves	10.7
10-2	Standard Location of Elements of a Welding Symbol	10.18
10-3	Supplementary Symbols	10.18
10-4	Typical Weld Symbols Used for Sheet Metal and Light Plate	10.19
10-5	Plate Welding Symbols	10.20
11-1	Longitudinal Seams	11.2
11-2	Longitudinal Seams (continued)	11.3
11-3	Transverse Seams or Joints	11.4
11-4	Crossbraking Light Gage Panels	11.5
11-5	Types of Stiffeners	11.6
11-6	Types of Stiffeners (continued)	11.7
11-7	Internal Pipe Supports	11.8
11-8	Types of Flanged Connections	11.9
11-9	Expansion Joints	11.10
11-10	Flexible Connections	11.11
11-11	Access Doors	11.12
11-12	Explosion Door	11.13
11-13	Various Fittings	11.14
B-1	Basic Wind Speed (mph)	B.2
B-2	Snow Ground Load – Western U.s. (lb/sq ft)	B.4
B-3	Snow Ground Load – eastern U.s. (lb/sq ft)	B.5
B-4	Glaze Ice Accretion Zone	B.6

