



# 411G Inverted Bucket Steam Traps

Forged Carbon Steel for Vertical Installation  
For Pressures to 69 barg...Capacities to 590 kg/h

## Description

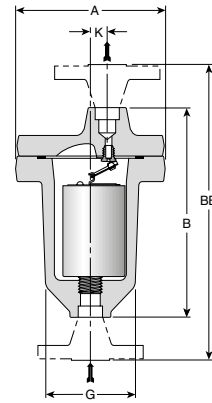
Armstrong Model 411G vertical installation offer smaller capacities at higher pressures.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket.

Inverted bucket traps drain continuously to prevent condensate backup. They are also resistant to water hammer.



Model 411G Trap

## Connections

Screwed BSPT and NPT  
Socketweld  
Flanged DIN or ANSI (welded), (consult factory for material specification)

## Materials

Body: ASTM A105  
Cap: Stainless steel  
Internals: All stainless steel – 304  
Valve and seat: Titanium

## Options

Stainless steel internal check valve

## Specifications

Inverted bucket steam trap, type ... in forged carbon steel, with continuous air venting at steam temperature, free-floating stainless steel mechanism, with the discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

## How to Order

Specify:

- Model number
- Size and type of pipe connection. When flanges are required, specify type of flange in detail
- Maximum working pressure that will be encountered or orifice size
- Any options required

**Table ST-96-1. Model 411G Bottom Inlet, Top Outlet Trap (dimensions in mm)**

Add suffix "CV" to trap number for internal check valve.

Model No. Screwed or SW Model No. Flanged	411G 411G-FW
Pipe Connections	15 – 20
"A" Flange Diameter	160
"B" & "C" Face-to-Face (screwed & SW)	224
"BB" & "CC" Face-to-Face (flanged PN100*)	298 – 304
"G" Body Outside Diameter	103
"K" $\varnothing$ Outlet to $\varnothing$ Inlet	19
Number of Bolts	8
Weight in kg (screwed & SW)	11.3
Weight in kg (flanged PN100*)	14.4 – 15.4

\* Other flange sizes, ratings and face-to-face dimensions are available on request.  
All models comply with the Article 4.3 of the PED (2014/68/UE).

**All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.**

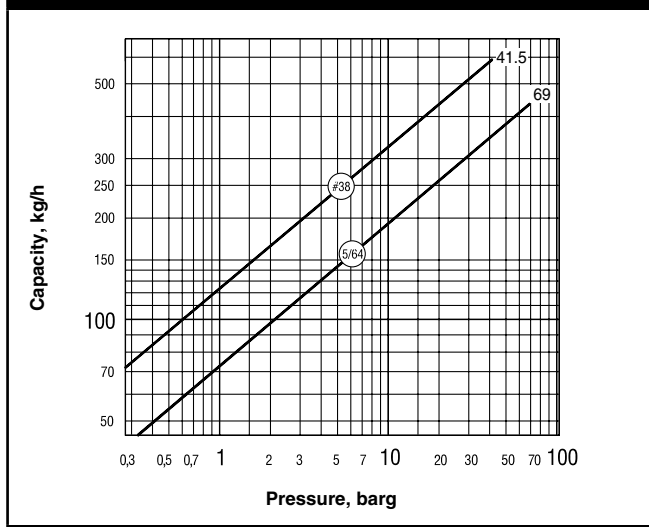
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**Table ST-97-1. Model 411G Capacity**



**Table ST-97-2. Pressure-Temperature Rating for Forged Steel Traps**

Model No.	Maximum Operating Pressure, Saturated Steam barg	Max. Allowable Pressure (Vessel Design)† of Pressure-Containing Parts at Indicated Temp.		
		-21 / +371°C	399°C	427°C
<b>411G</b>	69	<b>69</b>	65.5	58

**Notes:** Maximum operating pressure to be marked on nameplate will be determined by actual orifice used.  
 Maximum allowable pressures shown in boldface will be marked on nameplate, unless otherwise requested.  
 Traps with flanges may have different pressure-temperature ratings.  
 Maximum back pressure is 99% of inlet pressure.

† May be derated depending on flange rating and type.

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