

Approvals and Specifications

This product meets the following standards:

- Hydrostatically tested
- Non-destructively electric tested
- Flattening tested for NPS ½" and greater
- Bend tested for pipe NPS 2" or smaller
- UL, ULC Listed and FM Approved
- Made in Canada

Product Marking

Each length of pipe ½ " NPS and larger is continuously stenciled to show:

- The manufacturer name
- "Made in Canada"
- Grade
- Type of pipe
- Size
- Length
- Heat number
- Lot number (if galvanized)
- Date

Dimensions and Weights

	OD	Wall	Weight	S40wall	S40weight	S80wall	S80weight
NPS	in	in	lb/ft	in	lb/ft	in	lb/ft
½	0.840			0.109	0.85	0.147	1.09
¾	1.050			0.113	1.13	0.154	1.48
1	1.315			0.133	1.68	0.179	2.17
1 - ¼	1.660			0.14	2.27	0.191	3.00
1 - ½	1.900			0.145	2.72	0.200	3.63
2	2.375			0.154	3.66	0.218	5.03
2 - ½	2.875			0.203	5.80	0.276	7.67
3	3.500			0.216	7.58	0.300	10.26
3 - ½	4.000			0.226	9.12	0.318	12.52
4	4.500	.188	8.67	0.237	10.80	0.337	15.00
5	5.563	.188	10.80	0.258	14.63		
6	6.625	.188	12.94	0.280	18.99		

Scope

Covers bare, black and hot-dipped galvanized Electric Resistance Welded, Grade B pipe. Pipe is intended for mechanical and pressure applications and is acceptable for ordinary uses in steam, water, gas and air lines. Pipe is suitable for: welding, forming, threading, flanging, grooving and bending. Produced to the latest revisions of ASTM A53/A 53M, ASME SA53 /SA53M and ASME B36.10M. Pipe is UL, ULC Listed for sizes 1/2" to 6" S40, FMApproved 1/2" to 6" S40, for use in Fire Sprinkler Pipe applications. Pipe is also certified NSF/ANSI 372 Drinking Water System Components - Lead Content for sizes 1/2"to 6" S40, S80 and NSF/ANSI 61 Drinking Water System Components - Health Effects for sizes 1/2"to 2" S40, S80 (excluding zinc coated pipe).

Manufacture

The weld seam of electric-resistance welded pipe in Grade B shall be heat treated after welding or otherwise processed in such a manner that no untempered martensite remains.

Hot-Dipped Galvanized

The average weight of zinc coating determined by the ASTM A90 testing method shall not be less than 1.8 oz. per sq. ft. of surface (inside and outside) When galvanized pipe is bent or otherwise fabricated to a degree which causes zinc coating to stretch or compress beyond the limit of elasticity, some flaking of the coating may occur.

Hydrostatic Testing and Non-destructive Electric Testing

Hydrostatic test pressures for plain-end pipe are indicated below (psi). Test pressures shall be maintained for a minimum of 5 seconds. Non-destructive electric testing of the weld seam is done on each length of ERW pipe NPS 1/2" and larger.

NPS	.188	S40	S80
1/2		1200	1200
3/4		1200	1200
1		1200	1200
1 -1/4		1300	1900
1-1/2		1300	1900
2		2500	2500
2 -1/2		2500	2500
3		2500	2500
3- 1/2		2370	2800
4	1700	2210	2800
5	1420	1950	
6	1190	1780	

Flattening Test

NPS 1/2" and greater: As a test for quality of the weld, position of the weld at 90° from the direction of force and flatten until the OD is 2/3 of the original outside diameter. No cracks shall occur along the inside or outside surface of the weld.

Bend Test

NPS 2" and smaller, a sufficient length of pipe shall be capable of being bent cold through 90° around a cylindrical mandrel, the diameter of which is twelve times the specified outside diameter of the pipe, without developing cracks at any portion and without opening the weld.

End Finish

Plain end: NPS 1/2" and larger: ends are beveled top a angle of 30°, + 5° - 0° with a root face of 1/16 ± 1/32
Threaded: To ANSI Standard B1.20.1
Couplings: To ASTM Standard A865

Chemical Requirements

Composition, max % Carbon: 0.30, Manganese: 1.20, Phosphorus: 0.05, Sulfur: 0.045, *Copper: 0.40, *Nickel: 0.40, *Chromium: 0.40, *Molybdenum: 0.15, *Vanadium 0.08
*The combination of these five elements shall not exceed 1.00%

Tensile Requirements

Tensile Strength: 60000 Psi (415 Mpa) minimum
Yield Strength: 35000 Psi (240 Mpa) minimum
Elongation: Refer to ASTM A53 table X4.1

Permissible Variations In Wall Thickness, In Outside Diameter, In Weight Per Foot

Minimum wall thickness at any point shall not be more than ±12.5% under nominal wall thickness specified. Pipe Diameter NPS 1 1/2" and under: ±1/64 in.

Pipe Diameter NPS 2" and over: ±1%.

Pipe weight per foot shall not vary more than ±10% from the standard specified.