

Approvals and Specifications

This product meets the following standards:

- Hydrostatically tested
- Non-destructively electric tested
- Flattening test for NPS 1" and greater
- UL, ULC Listed and FM Approved
- Made in Canada

Product Marking

Each length of pipe 1" 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

NPS	OD (in)	S10 wall (in)	S10 weight lb/ft
1	1.315	0.109	1.41
1 1/4	1.660	0.109	1.81
1 1/2	1.900	0.109	2.09
2	2.375	0.109	2.64
2 1/2	2.875	0.120	3.53
3	3.500	0.120	4.34
3 1/2	4.000	0.120	4.98
4	4.500	0.120	5.62
5	5.563	0.134	7.78
6	6.625	0.134	9.30

Scope

Covers bare, black and hot-dipped galvanized Electric Resistance Welded, Grade A pipe. Pipe is intended for use in fire protection systems. Pipe produced under ASTM A795 is UL, ULC Listed, sizes 1" to 6" S10 and FM Approved sizes 1" to 6" S10, for use in Fire Sprinkler Pipe applications. Light-weight pipe is suitable for joining by welding and by rolled grooving while the standard-weight pipe is suitable cut or rolled groove, threading, and welding. Produced to latest revisions of ASTM A795/A795M and ASME B36.10M.

Hot-Dipped Galvanized

The average weight of zinc coating determined by the ASTM A90 testing method shall not be less than 1.5 oz. per sq. ft. of surface (inside and outside), and 1.8 oz. per sq.ft if FM marked. 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" and larger.

NPS	S10	Hydro test
1	1200	tested
1 1/4	1200	tested
1 1/2	1200	tested
2	1200	tested
2 1/2	1200	tested
3	1200	tested
3 1/2	1200	tested
4	1200	tested
5	1200	tested
6	1200	tested

End Finish

Plain end: NPS 1 1/4" and larger: ends are beveled top a angle of 30°, + 5° - 0° with a root face of 1/16 ± 1/32

Chemical Requirements

Composition, max % Carbon: 0.25, Manganese: 0.95, Phosphorus: 0.035, Sulfur: 0.035

Flattening Test

NPS 1 1/4" 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.

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 2" and over: ±1%.

Pipe Diameter NPS 1 1/2" and under: ±1/64 in.

Pipe weight per foot shall not vary more than ±5% from the standard specified.