

# ASTM A500 Type E, Grade A, B, C Pipe

## Submittal Data Sheet

### Approvals and Specifications

This product meets the following standards:

- Hydrostatically tested (if required)
- Non-destructively electric tested
- Flattening tested for NPS ½" and greater
- 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 (if required)
- Lot number (if galvanized)
- Date

### Dimensions and Weights

	OD	Wall	Weight	S40 wall	S40 weight	S80 wall	S80 weight
NPS	in	in	lb/ft	in	lb/ft	in	lb/ft
½	0.840	0.083	8.67	0.109	0.85	0.147	1.09
¾	1.050	0.083		0.113	1.13	0.154	1.48
1	1.315	0.109		0.133	1.68	0.179	2.17
1 ¼	1.660	0.109		0.14	2.27	0.191	3.00
1 ½	1.900	0.109		0.145	2.72	0.200	3.63
2	2.375	0.109		0.154	3.66	0.218	5.03
2 1/2	2.875	0.120		0.203	5.80	0.276	7.67
3	3.500	0.120		0.216	7.58	0.300	10.26
3 ½	4.000	0.120		0.226	9.12	0.318	12.52
4	4.500	0.188	8.67	0.237	10.80	0.337	15.00
5	5.563	0.188	10.80	0.258	14.63		
6	6.625	0.188	12.94	0.280	18.99		

# ASTM A500 Type E, Grade A, B, C Pipe

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### Scope

Covers bare and black electric resistance welded, Grade A, B, C pipe. 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 revision of ASTM A500/A500M.

### Manufacture

Welded tubing shall be made from flat-rolled steel by the electri-resistance welding process.

### 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.