
Standard Method of Test for

Helical Lock Seam Corrugated Pipe

AASHTO Designation: T 249-03 (2020)

Technical Subcommittee: 4b, Flexible and Metallic Pipe

Release: Group 2 (June)



**American Association of State Highway and Transportation Officials
555 12th Street NW, Suite 1000
Washington, DC 20004**

Standard Method of Test for

Helical Lock Seam Corrugated Pipe

AASHTO Designation: T 249-03 (2020)



Technical Subcommittee: 4b, Flexible
and Metallic Pipe

Release: Group 2 (June)

1. SCOPE

- 1.1. This method of test is to be followed in ascertaining the quality of the seam of a helical lock seam corrugated pipe.
-

VISUAL METHOD

2. PROCEDURE

- 2.1. Determine lock seam quality by examining samples of the lock seam cross section sawed from the pipe. See Figure 1 for location of sample. See Figure 2 for the cross section of the sample.
- 2.2. The manufacturer will saw a triangular sample from the seam at one end of a length of pipe to show the cross section normal to the seam. The base of the triangular sample shall be of sufficient width to show complete lock seam profile (see Figure 1).

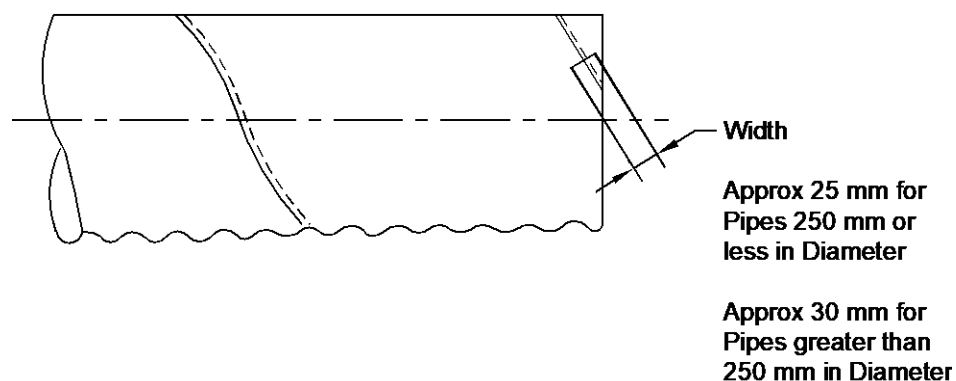


Figure 1—Location of Sample

- 2.3. The edges of the sheets within the cross section of the lock seam shall lap at least 4.0 mm for pipe 250 mm or less in diameter and at least 7.9 mm for pipe greater than 250 mm in diameter, with an occasional tolerance of –10 percent of lap width allowable. The lapped surfaces shall be in tight contact. There shall be no visible cracks in the metal, loss of metal-to-metal contact, or excessive angularity on the interior of the 180-degree fold of metal at the completion of forming the lock seam. Measure the seam lap and retaining offset distances (Figure 2) for conformance with