



Standard Specification for Electric-Fusion (Arc)-Welded Steel Pipe (NPS 4 and Over)¹

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1. Scope*

1.1 This specification covers five grades of electric-fusion (arc)-welded straight-seam or helical-seam steel pipe. Pipe of NPS 4 (**Note 1**) and larger with nominal (average) wall thickness of 1.0 in. [25.4 mm] and less are covered. Listing of standardized dimensions are for reference (**Note 2**). The grades of steel are pipe mill grades having mechanical properties which differ from standard plate grades. The pipe is intended for conveying liquid, gas, or vapor.

NOTE 1—The dimensionless designator NPS (nominal pipe size) has been substituted in this standard for such traditional terms as “nominal diameter,” “size,” and “nominal size.”

NOTE 2—A comprehensive listing of standardized pipe dimensions is contained in ASME B36.10M.

NOTE 3—The suitability of pipe for various purposes is somewhat dependent on its dimensions, properties, and conditions of service. For example, for high-temperature service see applicable codes and Specification **A691**.

1.2 The values stated in either inch-pound units or in SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values in each system are not exact equivalents; therefore, each system is to be used independently of the other.

2. Referenced Documents

2.1 ASTM Standards:²

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A691 Specification for Carbon and Alloy Steel Pipe, Electric-Fusion-Welded for High-Pressure Service at High Temperatures

A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products

¹ This specification is under the jurisdiction of ASTM Committee **A01** on Steel, Stainless Steel and Related Alloys, and is the direct responsibility of Subcommittee **A01.09** on Carbon Steel Tubular Products.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

2.2 American Welding Society Standard:³

AWS B2.1 Standard for Welding Procedure and Performance Qualifications Welding Handbook, Vol 1, 8th ed

2.3 ASME Standards:⁴

ASME B36.10M Welded and Seamless Wrought Steel Pipe

ASME B36.19M Stainless Steel Pipe

ASME Boiler and Pressure Vessel Code, Section IX

3. Ordering Information

3.1 Orders for material under this specification should include the following, as required, to describe the desired material adequately:

3.1.1 Quantity (feet, metres, or number of lengths),

3.1.2 Name of material (electric-fusion-(arc) welded steel pipe),

3.1.3 Grade (**Table 1**),

3.1.4 Size (NPS, or outside diameter, and nominal wall thickness, or schedule number),

3.1.5 Lengths (specific or random, **Section 17**),

3.1.6 End finish (**Section 18**),

3.1.7 Hydrostatic test pressure (**Section 16**, **Note 8**, and **Note 9**),

3.1.8 ASTM specification designation, and

3.1.9 End use of material.

4. Process

4.1 The steel shall be made by one or more of the following processes: open-hearth, basic-oxygen, or electric-furnace.

4.2 Steel may be cast in ingots or may be strand cast. When steels of different grades are sequentially strand cast, identification of the resultant transition material is required. The producer shall remove the transition material by any established procedure that positively separates the grades.

NOTE 4—The term “basic-oxygen steelmaking” is used generically to describe processes in which molten iron is refined to steel under a basic slag in a cylindrical furnace lined with basic refractories, by directing a jet of high-purity gaseous oxygen onto the surface of the hot metal bath.

³ Available from American Welding Society (AWS), 550 NW LeJeune Rd., Miami, FL 33126, <http://www.aws.org>.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.



TABLE 1 Chemical Requirements

Element	Composition, max, %				
	Grade A	Grade B	Grade C	Grade D	Grade E
Carbon	0.25	0.26	0.28	0.30	0.30
Manganese	1.00	1.00	1.20	1.30	1.40
Phosphorus	0.035	0.035	0.035	0.035	0.035
Sulfur	0.035	0.035	0.035	0.035	0.035

5. Manufacture

5.1 The longitudinal edges of the steel shall be shaped to give the most satisfactory results by the particular welding process employed. The weld shall be made by automatic (Note 5) means (except tack welds if used) and shall be of reasonably uniform width and height for the entire length of the pipe.

NOTE 5—Upon agreement between the purchaser and the manufacturer, manual welding by qualified procedure and welders may be used as an equal alternative under these specifications.

5.2 All weld seams made in manufacturing pipe shall be made using complete joint penetration groove welds.

6. Chemical Composition

6.1 The steel shall conform to the chemical requirements prescribed in Table 1 and the chemical analysis shall be in accordance with Test Methods, Practices, and Terminology A751.

7. Tensile Requirements for the Steel

7.1 Longitudinal tension test specimens taken from the steel shall conform to the requirements as to tensile properties prescribed in Table 2. At the manufacturer's option, the tension test specimen for sizes 8⁵/₈ in. [219.1 mm] in outside diameter and larger may be taken transversely as described in 19.4.

7.2 The yield point shall be determined by the drop of the beam, by the halt in the gage of the testing machine, by the use of dividers, or by other approved methods. The yield strength corresponding to a permanent offset of 0.2 % of the gage length of the specimen, or to a total extension of 0.5 % of the gage length under load shall be determined.

TABLE 2 Tensile Requirements

	Grade A	Grade B	Grade C	Grade D	Grade E
Tensile strength, min, ksi [MPa]	48 [330]	60 [415]	60 [415]	60 [415]	66 [455]
Yield strength, min, ksi [MPa]	30 [205]	35 [240]	42 [290]	46 [315]	52 [360]
Elongation in 2 in. or 50 mm, min, %:					
Basic minimum elongation for walls ⁵ / ₁₆ in. [7.9 mm] and over in thickness, longitudinal strip tests	35	30	25	23	22
For longitudinal strips tests, a deduction for each ¹ / ₃₂ -in. [0.8-mm] decrease in wall thickness below ⁵ / ₁₆ in. [7.9 mm] from the basic minimum elongation of the following percentage ^A	1.75 ^A	1.50 ^A	1.25	1.50	2.0
Elongation in 8 in. or 200 mm, min, % ^{B,C}					

Inch Pound Units, 1500/specified minimum tensile strength (ksi)
SI Units, 10 300/specified minimum tensile strength [MPa]

^A The table below gives the computed minimum values.

^B For wall thicknesses ¹/₂ in. [12.7 mm] and greater, the elongation may be taken in 8 in. or 200 mm.

^C The elongation in 8 in. or 200 mm need not exceed 30 %.

Wall Thickness		Elongation in 2 in. or 50 mm, min, %	
in.	mm	Grade A	Grade B
⁵ / ₁₆ (0.312)	7.9	35.00	30.00
⁹ / ₃₂ (0.281)	7.1	33.25	28.50
¹ / ₄ (0.250)	6.4	31.50	27.00
⁷ / ₃₂ (0.219)	5.6	29.75	25.50
³ / ₁₆ (0.188)	4.8	28.00	24.00
⁵ / ₃₂ (0.156)	4.0	26.25	22.50
¹ / ₈ (0.125)	3.7	24.50	21.00
³ / ₃₂ (0.094)	2.4	22.75	19.50
¹ / ₁₆ (0.062)	1.6	21.00	18.00

Note—The above table gives the computed minimum elongation values for each ¹/₃₂-in. [0.8-mm] decrease in wall thickness. Where the wall thickness lies between two values shown above, the minimum elongation value shall be determined by the following equation:

Grade	Equation Inch-Pound Units	Equation SI Units
A	$E = 56t + 17.50$	$E = 2.20t + 17.50$
B	$E = 48t + 15.00$	$E = 1.89t + 15.00$
C	$E = 40t + 12.50$	$E = 1.57t + 12.50$
D	$E = 48t + 8$	$E = 1.89t + 8$
E	$E = 64t + 2$	$E = 2.52t + 2$

where:

E = elongation in 2 in. or 50 mm, %, and

t = actual thickness of specimen, in. [mm]