



JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

☞ JIS G 3457 : 2005
(JISF)

Arc welded carbon steel pipes

ICS 23.040.10; 77.140.75

Reference number : JIS G 3457 : 2005 (E)

Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee, as the result of proposal for revision of Japanese Industrial Standard submitted by The Japan Iron and Steel Federation (JISF) with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law applicable to the case of revision by the provision of Article 14.

Consequently **JIS G 3457** : 1988 is replaced with this Standard.

Attention is drawn to the possibility that some parts of this Standard may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have technical properties. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

Date of Establishment: 1962-03-01

Date of Revision: 2005-03-20

Date of Public Notice in Official Gazette: 2005-03-22

Investigated by: Japanese Industrial Standards Committee
Standards Board
Technical Committee on Iron and Steel

JIS G 3457:2005, First English edition published in 2005-09

Translated and published by: Japanese Standards Association
4-1-24, Akasaka, Minato-ku, Tokyo, 107-8440 JAPAN

In the event of any doubts arising as to the contents,
the original JIS is to be the final authority.

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Printed in Japan

Contents

	Page
1 Scope	1
2 Normative references	1
3 Grade and designation	1
4 Method of manufacture	1
5 Chemical composition	2
6 Mechanical properties	2
6.1 Tensile strength, yield point or proof stress and elongation	2
6.2 Tensile strength of welds	2
7 Hydraulic test characteristic or nondestructive test characteristic	3
8 Dimensions, mass and dimensional tolerances	3
8.1 Dimensions and mass	3
8.2 Dimensional tolerances	4
8.3 Pipe length	5
9 Appearance	5
10 Test	5
10.1 Chemical analysis	5
10.2 Tensile test	5
10.3 Hydraulic test or nondestructive examination	6
11 Inspection	7
11.1 Inspection	7
11.2 Reinspection	7
12 Marking	7
13 Report	7

Arc welded carbon steel pipes

1 Scope This Japanese Industrial Standard specifies the arc welded carbon steel pipes (hereafter referred to as “pipes”) used for piping for steam, water, gas, air, etc. of comparatively low working pressure.

2 Normative references The following standards contain provisions which, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

JIS G 0320 *Standard test methods for heat analysis of steel products*

JIS G 0404 *Steel and steel products—General technical delivery requirements*

JIS G 0415 *Steel and steel products—Inspection documents*

JIS G 0584 *Ultrasonic examination for arc welded steel pipes*

JIS Z 2201 *Test pieces for tensile test for metallic materials*

JIS Z 2241 *Method of tensile test for metallic materials*

JIS Z 3121 *Methods of tensile test for butt welded joints*

JIS Z 8401 *Guide to the rounding of numbers*

3 Grade and designation The pipes shall be classified into one grade and its letter symbol shall be as given in table 1.

Table 1 Letter symbol of grade

Designation of grade
STPY 400

4 Method of manufacture The method of manufacture of pipe shall be as follows:

- The pipes shall be manufactured by spiral seam or straight seam welding. In either case, the internal and external surfaces of the pipe shall be automatic submerged arc welded in a butt joint.
- The pipes shall be either as welded or as cold-expanded after welding, and, as a rule, should not be subjected to heat treatment.
- Both ends of the pipe shall be finished plain ended or bevel ended⁽¹⁾.

Note ⁽¹⁾ Unless otherwise specified, the shape of the bevel end shall be as shown in figure 1.