

RECOMMENDED PRACTICE FOR COLOR CODING OF PIPING MATERIALS

Prepared by
Pipe Fabrication Institute Engineering Committee



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1. Scope

- 1.1 The intent of this standard is to provide a system for easy identification of piping materials by general material classifications.

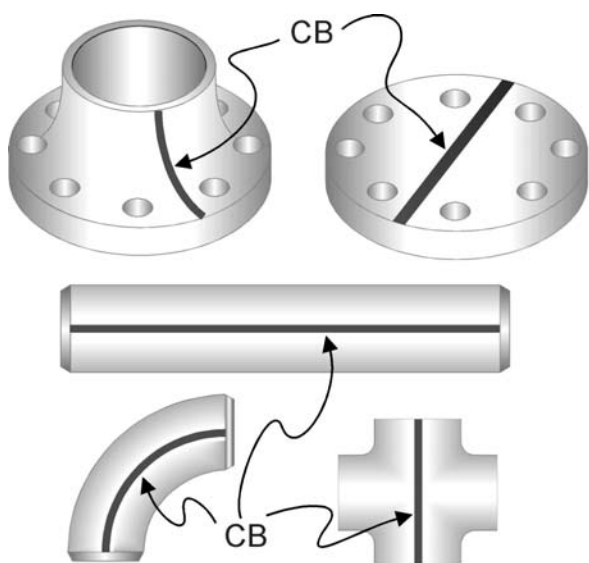
2. General

- 2.1 This standard cannot possibly distinguish between all the various grades or specifications of material. However, the user is encouraged to develop his own identification system depending on the specific materials involved for a project. Table 1 identifies the most common grades of material used in piping systems.
- 2.2 Color markings may be made using paint, dye, tape, or dry marker. Color markings are assigned on the basis of nominal chemical composition. Color coding for dual stamped materials shall be marked in accordance with the material required for the project or stock.
- 2.3 Identification by this method is not a substitute for other permanent manufacturer's marking, as is required by applicable ASTM or other piping material specifications.
- 2.4 The principal purpose of this standard is to simplify identification of the pipe during storage and after the pipe has been cut for fabrication or returned to stock.

- 2.5 Where pipe spool pieces are painted after completion of fabrication, further material color marking is not necessary except where required by code or the purchaser. Material identification after fabrication is complete is typically traceable by referencing the spool piece mark to the corresponding fabrication drawing and bill of material..
- 2.6 Paint and marking materials for use on nuclear piping systems shall be approved as suitable for the material to which it will be applied. Marking materials for stainless steel and nickel alloy piping must not contain undesirable substances such as chlorides, fluorides, sulfur, and low melting point metals.
- 2.7 The Fabricator, contractor, or purchaser may choose to implement positive material identification prior to color coding. Reference PFI standard ES-42, Standard for Positive Material Identification of Piping Components using Portable X-ray Emission Type Test Equipment

3. Location Of Marking

- 3.1 Pipe shall be marked for its full length.
- 3.2 Flanges shall be banded on the back of the flange at the intersection of the back face and the hub.
- 3.3 Fittings shall be striped from bevel to bevel.
- 3.4 Miscellaneous material shall be color marked so as to provide proper identity.
- 3.5 The paint shall not cover welding surfaces.
- 3.6 Typical markings are shown in Figure 1.



CB = Color band location

Note : Do not apply paint to gasket-seating areas or weld bevel areas

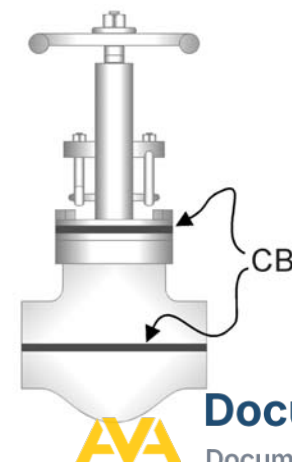


Figure 1 - Application of Color Code