



ASTM A589 Type E, Grade B, Type IV/
ASTM A53/ASME SA-53 Type E Grade A

Approvals and Specifications

This product meets the following standards:

- Hydrostatically tested
- Nondestructive electric test
- Flattening test for NPS 3" and greater
- NSF 372
- Made in Canada

Product Marking

Each length of pipe 3" NPS and larger are 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

NPS	OD (in.)	Thickness (in.)	Weight (lbs/ft)
3	3.500	0.125	4.51
3 ½	4.000	0.134	5.53
4	4.500	0.142	6.61
4	4.500	0.188	8.67
5	5.563	0.188	10.80
6	6.625	0.188	12.94
6	6.625	0.219	15.00
6	6.625	0.250	17.04

Scope

Covers bare, black and hot-dipped galvanized Electric Resistance Welded, Type IV, Pipe.

Pipe is intended for mechanical and pressure applications and is acceptable for ordinary uses in Water Well Casing. Produced to latest revisions of ASTM A589/A589M, ASTM A53/A53M, ASME SA53/SA53M and ASME B36.10M

Hot-Dipped Galvanized

The average weight of zinc coating determined by the ASTM A90 testing method shall be not 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 Nondestructive 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 3" and larger.

NPS	OD (in.)	Thickness (in.)	Test Pressure psi
3	3.500	0.125	1290
3 ½	4.000	0.134	1400
4	4.500	0.142	1250
4	4.500	0.188	1500
5	5.563	0.188	1220
6	6.625	0.188	1020
6	6.625	0.219	1190
6	6.625	0.250	1360

Flattening Test

NPS 3" 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.

End Finish

Plain end: NPS 3" and larger: ends are beveled top a angle of 30 °, + 5 ° - 0 ° with a root face of 1/16 ± 1/32

Chemical Requirements

Composition, max % Carbon: 0.25, Manganese: 0.95, 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 or Table 1 of ASTM A589

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 3" and over ±1%
- Pipe weight per foot shall not vary more than ± 5% from the standard specified