COMMERCIAL QUALITY (CQ)

Submittal Data Sheet

Approvals and Specifications

This product meets the following standards:

- Flattening test for NPS ½" and greater
- Nondestructive electric test
- Made in Canada

Product Marking

Each length of pipe ½" NPS and larger is continuously stenciled to show:

- The manufacturer name
- Made in Canada
- Lot number (if galvanized)
- The letters 'HT' if hydrostatically tested
- Date
- No stencil is applied on pipe intended for fencing

Dimensions and Weights

NPS	OD (in.)	Light Wall (in.)	Light Weight (lb./ft)	S10 Wall (in.)	S10 Weight (lb./ft)
½	0.840	-	-	-	-
¾	1.050	-	-	-	-
1	1.315	0.100	1.300	-	-
1¼	1.660	0.100	1.670	0.109	1.81
1½	1.900	0.100	1.920	0.109	2.09
2	2.375	0.100	2.430	0.109	2.64
2 ½	2.875	-	-	0.120	3.53
3	3.500	-	-	0.120	4.34
3 ½	4.000	-	-	0.120	4.98
4	4.500	-	-	0.120	5.62
6	6.625	-	-	0.134	9.30

NPS	OD (in.)	S40 Wall (in.)	S40 Weight (lb./ft)	S80 Wall (in.)	S80 Weight (lb./ft)
½	0.840	0.109	0.85	0.147	1.09
¾	1.050	0.113	1.13	0.154	1.48
1	1.315	0.133	1.68	0.179	2.17
1¼	1.660	0.140	2.27	0.191	3.00
1½	1.900	0.145	2.72	0.200	3.63
2	2.375	0.154	3.66	0.218	5.03
2 ½	2.875	0.203	5.80	0.276	7.67
3	3.500	0.216	7.58	0.300	10.26
3 ½	4.000	0.226	9.12	-	-
4	4.500	0.237	10.80	-	-
6	6.625	0.280	18.99	-	-

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5870 St Patrick Street, Montreal, QC H4E 1B3

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Scope

Covers bare, black and hot-dipped galvanized, Electric Resistance Welded pipe. Pipe is intended for general applications and as a structural support for fencing. Pipe is suitable for welding and threading. Pipe is not intended for flanging.

Hot-Dipped Galvanized

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.

Nondestructive Electric Testing

Non-destructive electric testing of the weld seam is done on each length of ERW pipe NPS ½" and larger.

Flattening Test

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 3/4 of the original outside diameter. No cracks shall occur along the inside or outside surface of the weld.

End Finish

Plain end: 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: 0.035, Sulfur: 0.035, *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: minimum 48000Psi (330 MPa)

Yield Strength: minimum 30000 Psi (205 MPa)

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 1 ½" and under: ±.016 inch
- Pipe Diameter NPS 2" and over: ±1%
- Pipe weight per foot shall not vary more than ±10% from the standard specified