BORUSAN PIPE

# Specification for Standard Sizes for Domestic

# ASTM A53 Grade A SRM Sch40 Black Pipe

## Scope
Covers Electric Resistance Welded Grade A Pipe with nominal wall thickness as shown in Table X2.2 and Table X2.3. Pipe is suitable for welding and suitable for forming operations involving coiling, bending, and flanging.

Produced to the latest revision of ASTM A53A/A53M ASME B36.10M. Pipe is UL listed and FM approved.

## Bend Test
For NPS 2" and smaller a length of pipe shall be capable of being bent cold through 90° around a cylindrical mandrel twelve times the size of the outside diameter without developing cracks or opening the weld.

## Product Marking
Each length of pipe shall be legibly marked by stencil to show name or brand of manufacturer, the kind of pipe, that is, ERW Grade A or B, the Heat Number, wall thickness or schedule, and length.

All bundles will have tags indicating footage per bundle, run number, and dimensions.

## Hydrostatic & Nondestructive Testing
Each length of plain end pipe shall be hydrostatically tested to the pressures described in Table X2.2 of the ASTM A53M specification.

Each pipe undergoes nondestructive electric testing.

## Frequency of Tests
Tensile tests are required for 1 length of pipe from each lot (not to exceed 500 lengths per size).

## Permissible Variations in Wall Thickness
The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified.

## Permissible Variations in Outside Diameter
The Pipe shall not vary more than +/- 1/64" ( 0.016") from the standard specified.

## Permissible Variations in Weight per Foot
The weight of pipe shall not vary by more than +/- 10% from the standard specified.

## Pure Shield Antimicrobial Coating
Borusan Pipe USA applies our Pure Shield coating to all pipe that we manufacture. This coating is designed to inhibit the initial onset of corrosion due to microbiological bacteria.

| Size | OD Min | OD Max | Wall Thickness | Weight Per Foot | Pieces Per Bundle |
|---|---|---|---|---|---|
| NPS | Inch | Inch | Inch | Lbs/Ft | |
| 1/2" | 0.824 | 0.856 | 0.109 | 0.85 | 127 |
| 3/4" | 1.034 | 1.066 | 0.113 | 1.13 | 91 |
| 1" | 1.299 | 1.331 | 0.133 | 1.68 | 70 |
| 1 1/4" | 1.644 | 1.676 | 0.140 | 2.27 | 51 |
| 1 1/2" | 1.881 | 1.919 | 0.145 | 2.72 | 44 |
| 2" | 2.35 | 2.399 | 0.154 | 3.66 | 29 |
| 2 1/2" | 2.846 | 2.904 | 0.203 | 5.8 | 20 |
| 3" | 3.465 | 3.535 | 0.216 | 7.58 | 13 |

| Chemical Compositon A53 Grade A | |
|---|---|
| Element | Max % |
| C | 0.25 |
| Mn | 0.95 |
| P | 0.05 |
| S | 0.045 |
| Cu | 0.4 |
| Ni | 0.4 |
| Cr | 0.4 |
| Mo | 0.15 |
| V | 0.08 |

| Mechanical Properties A53 Grade A | |
|---|---|
| | Min |
| Yield Strength | 30ksi |
| Tensile Strength | 48ksi |
| Elongation | Per ASTM A53 |


**Borusan Pipe USA**

**Houston Office**
363 N. Sam Houston Parkway E.
Ste. 500, Houston, TX 77060

**Baytown Mill**
4949 Borusan Road
Baytown, Texas 77523

borusanpipeusa.com

standardpipe@borusan.com

BORUSAN PIPE

# Specification for Standard Sizes for Domestic

# ASTM Grade B SRM Sch40 Black Pipe

## Scope
Covers Electric Resistance Welded Grade B Pipe with nominal wall thickness as shown in Table X2.2 and Table X2.3. Pipe is suitable for welding and suitable for forming operations involving coiling, bending, and flanging.

Produced to the latest revision of ASTM A53A/A53M ASME B36.10M. Pipe is UL listed and FM approved.

## Bend Test
For NPS 2" and smaller a length of pipe shall be capable of being bent cold through 90° around a cylindrical mandrel twelve times the size of the outside diameter without developing cracks or opening the weld.

## Product Marking
Each length of pipe shall be legibly marked by stencil to show name or brand of manufacturer, the kind of pipe, that is, ERW Grade A or B, the Heat Number, wall thickness or schedule, and length.

All bundles will have tags indicating footage per bundle, run number, and dimensions.

## Hydrostatic & Nondestructive Testing
Hydrostatic inspection test pressures for plain-end pipe are listed in Table X 2.2 of the A53/A53M specification. Test pressures shall be maintained for a minimum of five seconds.

Nondestructive testing of the weld seam is performed on all sizes of pipe.

## Frequency of Tests
Tensile tests are required for 1 length of pipe from each lot (not to exceed 500 lengths per size).

## Permissible Variations in Wall Thickness
The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified.

## Permissible Variations in Outside Diameter
The Pipe shall not vary more than +/- 1/64" ( 0.016") from the standard specified.

## Permissible Variations in Weight per Foot
The weight of pipe shall not vary by more than +/- 10% from the standard specified.

## Pure Shield Antimicrobial Coating
Borusan Pipe USA applies our Pure Shield coating to all pipe that we manufacture. This coating is designed to inhibit the initial onset of corrosion due to microbiological bacteria.

| Size | OD Min | OD Max | Wall Thickness | Weight Per Foot | Pieces Per Bundle |
|---|---|---|---|---|---|
| NPS | Inch | Inch | Inch | Lbs/Ft | |
| 1/2" | 0.824 | 0.856 | 0.109 | 0.85 | 127 |
| 3/4" | 1.034 | 1.066 | 0.113 | 1.13 | 91 |
| 1" | 1.299 | 1.331 | 0.133 | 1.68 | 70 |
| 1 1/4" | 1.644 | 1.676 | 0.140 | 2.27 | 51 |
| 1 1/2" | 1.881 | 1.919 | 0.145 | 2.72 | 44 |
| 2" | 2.35 | 2.399 | 0.154 | 3.66 | 29 |
| 2 1/2" | 2.846 | 2.904 | 0.203 | 5.8 | 20 |
| 3" | 3.465 | 3.535 | 0.216 | 7.58 | 13 |

| Chemical Compositon A53 Grade B | |
|---|---|
| Element | Max % |
| C | 0.3 |
| Mn | 1.2 |
| P | 0.05 |
| S | 0.045 |
| Cu | 0.4 |
| Ni | 0.4 |
| Cr | 0.4 |
| Mo | 0.15 |
| V | 0.08 |

| Mechanical Properties A53 Grade B | |
|---|---|
| | Min |
| Yield Strength | 35ksi |
| Tensile Strength | 60ksi |
| Elongation | Per ASTM A53 |


**Borusan Pipe USA**

**Houston Office**
363 N. Sam Houston Parkway E.
Ste. 500, Houston, TX 77060

**Baytown Mill**
4949 Borusan Road
Baytown, Texas 77523

borusanpipeusa.com

standardpipe@borusan.com

BORUSAN PIPE

# Specification for Standard Sizes for Domestic

# ASTM Grade A SRM Sch80 Black Pipe

## Scope
Covers Electric Resistance Welded Grade A Pipe with nominal wall thickness as shown in Table X2.2 and Table X2.3. Pipe is suitable for welding and suitable for forming operations involving coiling, bending, and flanging.

Produced to the latest revision of ASTM A53A/A53M ASME B36.10M. Pipe is UL listed and FM approved.

## Bend Test
For NPS 2" and smaller a length of pipe shall be capable of being bent cold through 90° around a cylindrical mandrel twelve times the size of the outside diameter without developing cracks or opening the weld.

## Product Marking
Each length of pipe shall be legibly marked by stencil to show name or brand of manufacturer, the kind of pipe, that is, ERW Grade A or B, the Heat Number, wall thickness or schedule, and length.

All bundles will have tags indicating footage per bundle, run number, and dimensions.

## Hydrostatic & Nondestructive Testing
Hydrostatic inspection test pressures for plain-end pipe are listed in Table X 2.2 of the A53/A53M specification. Test pressures shall be maintained for a minimum of five seconds.

Nondestructive testing of the weld seam is performed on all sizes of pipe.

## Frequency of Tests
Tensile tests are required for 1 length of pipe from each lot (not to exceed 500 lengths per size).

## Permissible Variations in Wall Thickness
The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified.

## Permissible Variations in Outside Diameter
The Pipe shall not vary more than +/- 1/64" ( 0.016") from the standard specified.

## Permissible Variations in Weight per Foot
The weight of pipe shall not vary by more than +/- 10% from the standard specified.

## Pure Shield Antimicrobial Coating
Borusan Pipe USA applies our Pure Shield coating to all pipe that we manufacture. This coating is designed to inhibit the initial onset of corrosion due to microbiological bacteria.

| Size | OD Min | OD Max | Wall Thickness | Weight Per Foot | Pieces Per Bundle |
|---|---|---|---|---|---|
| NPS | Inch | Inch | Inch | Lbs/Ft | |
| 1/2" | 0.84 | 0.856 | 0.147 | 1.09 | 91 |
| 3/4" | 1.05 | 1.066 | 0.154 | 1.48 | 79 |
| 1" | 1.315 | 1.331 | 0.179 | 2.17 | 44 |
| 1 1/4" | 1.66 | 1.676 | 0.191 | 3 | 34 |
| 1 1/2" | 1.9 | 1.919 | 0.200 | 3.63 | 29 |
| 2" | 2.375 | 2.399 | 0.218 | 5.03 | 24 |
| 2 1/2" | 2.875 | 2.904 | 0.276 | 7.67 | 20 |
| 3" | 3.5 | 3.535 | 0.300 | 10.26 | 13 |

| Chemical Compositon A53 Grade A | |
|---|---|
| Element | Max % |
| C | 0.25 |
| Mn | 0.95 |
| P | 0.05 |
| S | 0.045 |
| Cu | 0.4 |
| Ni | 0.4 |
| Cr | 0.4 |
| Mo | 0.15 |
| V | 0.08 |

| Mechanical Properties A53 Grade A | |
|---|---|
| | Min |
| Yield Strength | 30ksi |
| Tensile Strength | 48ksi |
| Elongation | Per ASTM A53 |


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**Houston Office**
363 N. Sam Houston Parkway E.
Ste. 500, Houston, TX 77060

**Baytown Mill**
4949 Borusan Road
Baytown, Texas 77523

borusanpipeusa.com

standardpipe@borusan.com

BORUSAN PIPE

# Specification for Standard Sizes for Domestic

# ASTM Grade B SRM Sch80 Black Pipe

## Scope
Covers Electric Resistance Welded Grade B Pipe with nominal wall thickness as shown in Table X2.2 and Table X2.3. Pipe is suitable for welding and suitable for forming operations involving coiling, bending, and flanging.

Produced to the latest revision of ASTM A53A/A53M ASME B36.10M. Pipe is UL listed and FM approved.

## Bend Test
For NPS 2" and smaller a length of pipe shall be capable of being bent cold through 90° around a cylindrical mandrel twelve times the size of the outside diameter without developing cracks or opening the weld.

## Product Marking
Each length of pipe shall be legibly marked by stencil to show name or brand of manufacturer, the kind of pipe, that is, ERW Grade A or B, the Heat Number, wall thickness or schedule, and length.

All bundles will have tags indicating footage per bundle, run number, and dimensions.

## Hydrostatic & Nondestructive Testing
Hydrostatic inspection test pressures for plain-end pipe are listed in Table X 2.2 of the A53/A53M specification. Test pressures shall be maintained for a minimum of five seconds.

Nondestructive testing of the weld seam is performed on all sizes of pipe.

## Frequency of Tests
Tensile tests are required for 1 length of pipe from each lot (not to exceed 500 lengths per size).

## Permissible Variations in Wall Thickness
The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified.

## Permissible Variations in Outside Diameter
The Pipe shall not vary more than +/- 1/64" ( 0.016") from the standard specified.

## Permissible Variations in Weight per Foot
The weight of pipe shall not vary by more than +/- 10% from the standard specified.

## Pure Shield Antimicrobial Coating
Borusan Pipe USA applies our Pure Shield coating to all pipe that we manufacture. This coating is designed to inhibit the initial onset of corrosion due to microbiological bacteria.

| Size | OD Min | OD Max | Wall Thickness | Weight Per Foot | Pieces Per Bundle |
|---|---|---|---|---|---|
| NPS | Inch | Inch | Inch | Lbs/Ft | |
| 1/2" | 0.84 | 0.856 | 0.147 | 1.09 | 91 |
| 3/4" | 1.05 | 1.066 | 0.154 | 1.48 | 79 |
| 1" | 1.315 | 1.331 | 0.179 | 2.17 | 44 |
| 1 1/4" | 1.66 | 1.676 | 0.191 | 3 | 34 |
| 1 1/2" | 1.9 | 1.919 | 0.200 | 3.63 | 29 |
| 2" | 2.375 | 2.399 | 0.218 | 5.03 | 24 |
| 2 1/2" | 2.875 | 2.904 | 0.276 | 7.67 | 20 |
| 3" | 3.5 | 3.535 | 0.300 | 10.26 | 13 |

| Chemical Compositon A53 Grade B | |
|---|---|
| Element | Max % |
| C | 0.3 |
| Mn | 1.2 |
| P | 0.05 |
| S | 0.045 |
| Cu | 0.4 |
| Ni | 0.4 |
| Cr | 0.4 |
| Mo | 0.15 |
| V | 0.08 |

| Mechanical Properties A53 Grade B | |
|---|---|
| | Min |
| Yield Strength | 35ksi |
| Tensile Strength | 60ksi |
| Elongation | Per ASTM A53 |


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**Houston Office**
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Ste. 500, Houston, TX 77060

**Baytown Mill**
4949 Borusan Road
Baytown, Texas 77523

borusanpipeusa.com

standardpipe@borusan.com

BORUSAN PIPE

# Specification for Standard Sizes for Domestic

# ASTM A795 Grade A SRM Sch7 Black Pipe

## Scope
Covers Electric Resistance Welded Grade B Pipe with nominal wall thickness as shown in Table X2.2 and Table X2.3. Pipe is suitable for welding and suitable for forming operations involving coiling, bending, and flanging.

Produced to the latest revision of ASTM A53A/A53M ASME B36.10M. Pipe is UL listed and FM approved.

## Bend Test
For NPS 2" and smaller a length of pipe shall be capable of being bent cold through 90° around a cylindrical mandrel twelve times the size of the outside diameter without developing cracks or opening the weld.

## Product Marking
Each length of pipe shall be legibly marked by stencil to show name or brand of manufacturer, the kind of pipe, that is, ERW Grade A or B, the Heat Number, wall thickness or schedule, and length.

All bundles will have tags indicating footage per bundle, run number, and dimensions.

## Hydrostatic & Nondestructive Testing
Hydrostatic inspection test pressures for plain-end pipe are listed in Table X 2.2 of the A53/A53M specification. Test pressures shall be maintained for a minimum of five seconds.

Nondestructive testing of the weld seam is performed on all sizes of pipe.

## Frequency of Tests
Tensile tests are required for 1 length of pipe from each lot (not to exceed 500 lengths per size).

## Permissible Variations in Wall Thickness
The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified.

## Permissible Variations in Outside Diameter
The Pipe shall not vary more than +/- 1/64" ( 0.016") from the standard specified.

## Permissible Variations in Weight per Foot
The weight of pipe shall not vary by more than +/- 10% from the standard specified.

## Pure Shield Antimicrobial Coating
Borusan Pipe USA applies our Pure Shield coating to all pipe that we manufacture. This coating is designed to inhibit the initial onset of corrosion due to microbiological bacteria.

| Size | OD Min | OD Max | Wall Thickness | Weight Per Foot | ULCRR* | Pieces Per Bundle |
|---|---|---|---|---|---|---|
| NPS | Inch | Inch | Inch | Lbs/Ft | | |
| 1 1/4" | 1.66 | 1.68 | 0.079 | 1.34 | 1.80 | 61 |
| 1 1/2" | 1.9 | 1.92 | 0.084 | 1.62 | 2.64 | 61 |
| 2" | 2.375 | 2.39 | 0.084 | 2.05 | 2.14 | 37 |
| 2 1/2" | 2.875 | 2.89 | 0.086 | 2.55 | 1.43 | 30 |
| 3" | 3.5 | 3.52 | 0.093 | 3.38 | 1.34 | 19 |

*The CRR is a ratio value used to measure the ability of pipe to withstand corrosion. This number is calculated using Standard UL CRR formula, UL Fire Protection Directory, Category VIZY.

| Chemical Compositon A53 Grade A | |
|---|---|
| Element | Max % |
| C | 0.25 |
| Mn | 0.95 |
| P | 0.05 |
| S | 0.045 |
| Cu | 0.4 |
| Ni | 0.4 |
| Cr | 0.4 |
| Mo | 0.15 |
| V | 0.08 |

| Mechanical Properties A53 Grade A | |
|---|---|
| | Min |
| Yield Strength | 30ksi |
| Tensile Strength | 48ksi |
| Elongation | Per ASTM A53 |

**Borusan Pipe USA**

**Houston Office**
363 N. Sam Houston Parkway E.
Ste. 500, Houston, TX 77060

**Baytown Mill**
4949 Borusan Road
Baytown, Texas 77523

borusanpipeusa.com

standardpipe@borusan.com

BORUSAN PIPE

# Specification for Standard Sizes for Domestic

# ASTM A795 Grade A SRM Sch10 Black Pipe

## Scope
Covers Electric Resistance Welded Grade B Pipe with nominal wall thickness as shown in Table X2.2 and Table X2.3. Pipe is suitable for welding and suitable for forming operations involving coiling, bending, and flanging.

Produced to the latest revision of ASTM A53A/A53M ASME B36.10M. Pipe is UL listed and FM approved.

## Bend Test
For NPS 2" and smaller a length of pipe shall be capable of being bent cold through 90° around a cylindrical mandrel twelve times the size of the outside diameter without developing cracks or opening the weld.

## Product Marking
Each length of pipe shall be legibly marked by stencil to show name or brand of manufacturer, the kind of pipe, that is, ERW Grade A or B, the Heat Number, wall thickness or schedule, and length.

All bundles will have tags indicating footage per bundle, run number, and dimensions.

## Hydrostatic & Nondestructive Testing
Hydrostatic inspection test pressures for plain-end pipe are listed in Table X 2.2 of the A53/A53M specification. Test pressures shall be maintained for a minimum of five seconds.

Nondestructive testing of the weld seam is performed on all sizes of pipe.

## Frequency of Tests
Tensile tests are required for 1 length of pipe from each lot (not to exceed 500 lengths per size).

## Permissible Variations in Wall Thickness
The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified.

## Permissible Variations in Outside Diameter
The Pipe shall not vary more than +/- 1/64" ( 0.016") from the standard specified.

## Permissible Variations in Weight per Foot
The weight of pipe shall not vary by more than +/- 10% from the standard specified.

## Pure Shield Antimicrobial Coating
Borusan Pipe USA applies our Pure Shield coating to all pipe that we manufacture. This coating is designed to inhibit the initial onset of corrosion due to microbiological bacteria.

| Size | OD Min | OD Max | Wall Thickness | Weight Per Foot | C.R.R.* | Pieces Per Bundle |
|---|---|---|---|---|---|---|
| NPS | Inch | Inch | Inch | Lbs/Ft | | |
| 1" | 1.315 | 1.331 | 0.109 | 1.41 | 11.4 | 60 |
| 1 1/4" | 1.66 | 1.676 | 0.109 | 1.81 | 7.3 | 61 |
| 1 1/2" | 1.9 | 1.919 | 0.109 | 2.09 | 5.8 | 61 |
| 2" | 2.375 | 2.399 | 0.109 | 2.64 | 4.7 | 37 |
| 2 1/2" | 2.875 | 2.904 | 0.120 | 3.53 | 3.5 | 30 |
| 3" | 3.5 | 3.535 | 0.120 | 4.34 | 2.6 | 19 |

*Calculated using Standard UL CCR formula, UL Fire Protection Directory, Category VIZY

| Chemical Compositon A53 Grade A | |
|---|---|
| Element | Max % |
| C | 0.25 |
| Mn | 0.95 |
| P | 0.05 |
| S | 0.045 |
| Cu | 0.4 |
| Ni | 0.4 |
| Cr | 0.4 |
| Mo | 0.15 |
| V | 0.08 |

| Mechanical Properties A53 Grade A | |
|---|---|
| | Min |
| Yield Strength | 30ksi |
| Tensile Strength | 48ksi |
| Elongation | Per ASTM A53 |


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**Houston Office**
363 N. Sam Houston Parkway E.
Ste. 500, Houston, TX 77060

**Baytown Mill**
4949 Borusan Road
Baytown, Texas 77523

borusanpipeusa.com

standardpipe@borusan.com

BORUSAN PIPE

# Specification for Standard Sizes for Domestic

# ASTM A53 Type E Grade B Steel Pipe

## Scope
Covers Electric Resistance Welded Grade B Pipe with nominal wall thickness as shown in Table X2.2 and Table X2.3. Pipe is suitable for welding and suitable for forming operations involving coiling, bending, and flanging.

Produced to the latest revision of ASTM A53A/A53M ASME B36.10M. Pipe is UL listed and FM approved.

## Hydrostatic & Nondestructive Testing
Hydrostatic inspection test pressures for plain-end pipe are listed in Table X 2.2 of the A53/A53M specification. Test pressures shall be maintained for a minimum of five seconds.

Nondestructive testing of the weld seam is performed on all sizes of pipe.

## Product Marking
Each length of pipe shall be legibly marked by stencil to show name or brand of manufac-turer, the kind of pipe, that is, ERW Grade A or B, the Heat Number, wall thickness or schedule, and length.

All bundles will have tags indicating footage per bundle, run number, and dimensions.

## End Finish
Plain End: NPS 2 and larger, STD and XS weights: ends beveled to angle of 30°, +5°, -0° with a root face of 1/16"± 1/32

## Frequency of Tests
Tensile tests are required for 1 length of pipe from each lot (not to exceed 500 lengths per size).

## Permissible Variations in Wall Thickness
The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified.

## Permissible Variations in Outside Diameter
Pipe NPS 2 and larger shall not vary more than +1% from the standard specified.

## Permissible Variations in Weight per Foot
The weight of pipe shall not vary by more than +/- 10% from the standard specified.

## Flattening Test
As a test for ductility of the weld for pipe 2 1/2" NPS and larger position the weld at 0" and alternately at 90° to 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.

| NPS | SCH | OD (inch) | Wall Thickness | LB/FT |
|---|---|---|---|---|
| 4" | SCH40 | 4.5 | 0.237 | 10.8 |
| 6" | SCH40 | 6.625 | 0.28 | 18.99 |
| 8" | SCH40 | 8.625 | 0.322 | 28.58 |
| 10" | SCH40 | 10.75 | 0.365 | 40.52 |
| 12" | STD | 12.75 | 0.375 | 49.61 |

| Chemical Compositon A53 Grade B | |
|---|---|
| **Element** | **Max %** |
| C | 0.3 |
| Mn | 1.2 |
| P | 0.05 |
| S | 0.045 |
| Cu | 0.4 |
| Ni | 0.4 |
| Cr | 0.4 |
| Mo | 0.15 |
| V | 0.08 |

| Mechanical Properties A53 Grade B | |
|---|---|
| | **Min** |
| Yield Strength | 35ksi |
| Tensile Strength | 60ksi |
| Elongation | Per ASTM A53 |

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Baytown, Texas 77523

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standardpipe@borusan.com

BORUSAN PIPE

# SUBMITTAL INFORMATION FORM

**Project**

**Contractor**

**Date**

**Engineer**

**Specific Reference**

**System Type**

**Locations**

**Pipe**

- ☐ Schedule 40 Grade A
- ☐ Schedule 40 Grade B
- ☐ Schedule 80 Grade A
- ☐ Schedule 80 Grade B
- ☐ Schedule 7 Grade A
- ☐ Schedule 10 Grade A
- ☐ Type E Grade B

**Comments**

**Borusan Pipe USA**

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