

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 Composition 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

