



Columbia Specialty Company, Inc.

Distributor of Mechanical and Industrial Piping Products

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Company: _____

Project: _____

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Pipe Specification A135

Specification	A135 NPS 1/4 -- 30", Schedules 10, 40 and XL THD, light wall																				
Scope	Covers two grades of electric resistance welded steel pipe. Grade A is adapter for flanging and bending and is suitable for welding. Purpose for which pipe is intended should on order.																				
Kinds of Steel Permitted for Pipe Material	Open-hearth Basic Oxygen Electric-furnace																				
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. Thread able, light wall (XL) must meet manufacturers minimums.																				
Chemical Requirements	<table border="1"> <thead> <tr> <th></th> <th>C max %</th> <th>Mn max %</th> <th>P max %</th> <th>S max %</th> </tr> </thead> <tbody> <tr> <td>Seamless or ERW</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Grade A</td> <td>0.25</td> <td>0.95</td> <td>0.05</td> <td>0.06</td> </tr> <tr> <td>Grade B</td> <td>0.30</td> <td>1.20</td> <td>0.05</td> <td>0.06</td> </tr> </tbody> </table>		C max %	Mn max %	P max %	S max %	Seamless or ERW					Grade A	0.25	0.95	0.05	0.06	Grade B	0.30	1.20	0.05	0.06
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NDE & Hydrostatic Testing	Hydrostatic inspection test pressures for plain end and threaded are specified. Hydrostatic pressure shall be maintained for not less than 5 seconds for all sizes of electric resistance-weld pipe. Non-destructive electric test should be in accordance with practice E213, method E227 or practice E213.																				
Permissible Variations in Weights per Foot	Plus or Minus 10% schedule 10 Plus 10% minus 3 1/2% schedule 40																				
Permissible Variations in Outside Diameter	Plus or minus 1%																				
Mechanical Tests Specified	Tensile Test -- Transverse returned on pipe NPS 8 and larger Flattening Test -- Three steps required with weld located 0* or 90* from the line of direction of force required																				
Number of Tests Required	Flattening and tensile on one length of pipe from each lot of 400 lengths or less of a style.																				
Lengths	Pipe shall be furnished in 38' with a minimum of 20 ft. Pipe furnished to schedule 10 shall be in a specified length between 16 and 22 ft.																				
Required Markings on Each Length (On Tags attached to each Bundle in case of Bundled Pipe)	Rolled, Stamped or Stenciled (Mfgs. Option) Name or brand of manufacturer. Kind of pipe, that is, electric-resistance welded A, electric-resistance weld B, same schedule wall thickness, schedule 10 or 40, NL ASTM A53 Length of pipe.																				
General Information	End finish may be plain end beveled or plain end square cut.																				