



**Columbia Specialty Company, Inc.**

Distributor of Mechanical and Industrial Piping Products

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**Company:** \_\_\_\_\_

**Project:** \_\_\_\_\_

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**Pipe Specification A795**

<b>Spec</b>	<b>A795</b> NPS 1/2 -- 10" Schedule 10 and Schedule 40																														
<b>Scope</b>	Covers seamless and welded, black and hot dipped galvanized nominal wall pipe. For coiling, bending, flanging and is suitable for welding. Pipe ordered for this specification is intended for use in free protection system.																														
<b>Kinds of Steel Permitted for Pipe Material</b>	Open-hearth Basic-oxygen Electric-furnace																														
<b>Hot-Dipped Galvanizing</b>	Sets standards for coating of pipe with zinc inside and outside by the hot-dipped process. Weight of coating must not average less than 1.8oz per square ft and not less than 1.6oz per sq. ft.																														
<b>Permissible Variations in Wall Thickness</b>	The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified.																														
<b>Chemical Requirements</b>	<table border="1"> <thead> <tr> <th></th> <th><u>C max %</u></th> <th><u>Mn max %</u></th> <th><u>P max %</u></th> <th><u>S max %</u></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> <tr> <td>Furnace-weld Pipe</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Type F</td> <td>---</td> <td>---</td> <td>0.08</td> <td>0.08</td> </tr> </tbody> </table>		<u>C max %</u>	<u>Mn max %</u>	<u>P max %</u>	<u>S max %</u>	Seamless or ERW					Grade A	0.25	0.95	0.05	0.06	Grade B	0.30	1.20	0.05	0.06	Furnace-weld Pipe					Type F	---	---	0.08	0.08
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<b>NDE &amp; Hydrostatic Testing</b>	Hydrostatic inspection test pressures for plain end and threaded are specified. Hydrostatic pressure shall be maintained for not less than 5 second for all sizes of seamless electric resistance weld pipe. Non destructive electric test in accordance with practice E 213 or E 309 for the larger sizes. Pressure is maintained for not less than 5 seconds.																														
<b>Permissible Variations in Weights per Foot</b>	Plus or minus 5%																														
<b>Permissible Variations in Outside Diameter</b>	<b>Outside Diameter</b> at any point shall not vary from standard specified more than-- <table border="1"> <thead> <tr> <th><u>For NPS 1 1/2 and Smaller Sizes</u></th> <th><u>For NPS 2 and Larger Sizes</u></th> </tr> </thead> <tbody> <tr> <td>1/64" over 1/32" under</td> <td>1% over 1% under</td> </tr> </tbody> </table>	<u>For NPS 1 1/2 and Smaller Sizes</u>	<u>For NPS 2 and Larger Sizes</u>	1/64" over 1/32" under	1% over 1% under																										
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<b>Number of Tests Required</b>	<b>Flattening</b> -- Tests are to be performed on electric-resistance welded pipe, and furnace welded pipe.																														
<b>Lengths</b>	Unless specified, pipe shall be furnished on single random lengths or 16 to 22ft.																														
<b>Required Markings on Each Length (On Tags attached to each Bundle in case of Bundled Pipe)</b>	Rolled, Stamped or Stenciled (Mfgs. Option)  Manufacturer's name or brand.  Electric-resistance welded A, Electric-resistance welded B, Seamless A, Seamless B,  Grade A or B for type E or S pipe, wall thickness schedule ASTM A795, the letters NH if not hydrstatically tested. The length of pipe.																														
<b>General Information</b>	End finish may be plain end beveled or plain end square cut.																														