



Mittal Canada Pipe Mill

SUBMITTAL DATA

ASTM A795 Type E, Grade A Pipe

SCOPE

Covers black and hot-dipped galvanized electric-resistance welded Grade A pipe. Pipe is intended for use in fire protection systems. Mittal's ASTM A795 is UL, ULC listed and FM approved, sizes 2" to 6" S10, and 2 to 4" S40, for use in Fire Sprinkler Pipe applications. Light-weight pipe is suitable for joining by welding and by rolled grooving, while the standard-weight pipe is suitable cut or rolled groove, threading, and welding. Produced to latest revisions of ASTM A795/A 795M, and ASME B36.10M

HOT-DIPPED GALVANIZED

The average weight of zinc coating shall be not less than 1.5 oz. Per sq. ft. of surface (inside and outside)
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.

HYDROSTATIC TESTING and NONDESTRUCTIVE ELECTRIC TESTING

Hydrostatic test pressures for plain-end pipe are indicated below. (in PSI). Test pressures shall be maintained for a minimum of 5 seconds.

NPS	S10	S40
2	1000	1000
2 1/2	1000	1000
3	1000	1000
3 1/2	1200	1200
4	1200	1200
6	1000	1200

As an alternative to the hydrostatic test, each length of ERW pipe can be tested with a nondestructive electric test .

END FINISH

Plain end:

NPS 2 and larger: ends are beveled top a angle of 30°, + 5° - 0° with a root face of 1/16 ± 1/32

Threaded: To ANSI Standard B1.20.1

Roll groove: To the roll groove specifications of Victaulic

Couplings: To ASTM Standard A865

CHEMICAL REQUIREMENTS

Composition, max %

Carbon: 0.25, Manganese: 0.95, Phosphorus: .035, Sulfur: .035

TENSILE REQUIREMENTS

Not required

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 2/3 of the original outside diameter. No cracks shall occur along the inside or outside surface of the weld.

DIMENSIONS AND WEIGHTS (Black plain end)

NPS	OD inches	S10 wall inches	S10 weight Lb/Ft	S40 wall inches	S40 weight Lb/Ft
2	2.375	.109	2.64	.154	3.66
2 1/2	2.875	.120	3.53	.203	5.80
3	3.500	.120	4.34	.216	7.58
3 1/2	4.000	.120	4.98	.226	9.12
4	4.500	.120	5.62	.237	10.80
5	5.563	.134	7.78	.258	14.63
6	6.625	.134	9.30	.280	18.99

PERMISSIBLE VARIATIONS IN WALL THICKNESS

Minimum wall thickness at any point shall not be more than 12.5% under nominal wall thickness specified.

PERMISSIBLE VARIATIONS IN OUTSIDE DIAMETER

Pipe NPS 2 and over: ± 1%

PERMISSIBLE VARIATIONS IN WEIGHT PER FOOT

Pipe shall not vary more than ± 5% from the standard specified

PRODUCT MARKING

Each length of pipe 2 NPS and larger is continuously stenciled to show the manufacturer, the grade of pipe (ASTM A795), the kind of pipe (E for electric-resistance welded, A for Grade A), the size (S10 for light wall, S40 for nominal), length, the letters " NH " if not hydrostatically tested, and lot number. Stencil markings indicate UL, ULC listing and FM approved for sizes 2 inch to 6 inch for use in Fire Sprinkler Pipe applications. Bar coding is acceptable as a supplementary identification number.

All information contained herein is accurate as know at the time of publication. Mittal reserves the right to change product specifications without notice and without incurring obligations (February 26, 2007)

Prepared by: Raphaël Cicciariello, eng.

MITTAL Canada Inc.
3900 route des Acérières
Contrecoeur, P.Q.
Canada, J0L 1C0

Tel : +1 450 392-3200
Fax : +1 450 587-8740