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## Specification A106-99e1 Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service

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### 1. Scope

1.1 This specification covers seamless carbon steel pipe for high-temperature service (Note 1) in NPS 1/8 to NPS 48 inclusive, with nominal (average) wall thickness as given in ANSI B36.10. Pipe having other dimensions may be furnished provided such pipe complies with all other requirements of this specification. Pipe ordered under this specification shall be suitable for bending, flanging, and similar forming operations, and for welding. When the steel is to be welded, it is presupposed that a welding procedure suitable to the grade of steel and intended use or service will be utilized (Note 2).

Note 1-Consideration should be given to possible graphitization of the material at the higher temperatures at which it may be used. Note 2-Grade A rather than Grade B or Grade C pipe should be used for close coiling, or cold bending. The purpose for which the pipe is to be used should be stated in the order. This note is not intended to prohibit the cold bending of Grade B seamless pipe.

1.2 Supplementary requirements (S1 to S7) of an optional nature are provided for seamless pipe intended for use in applications where a superior grade of pipe is required. These supplementary requirements call for additional tests to be made and when desired shall be so stated in the order.

1.3 When these products are to be used in applications conforming to ISO Recommendations for Boiler Construction, the requirements of Specification A520 (Mechanical Property Requirements Section) shall supplement and supersede the requirements of this specification.

1.4 The values stated in inch-pound units are to be regarded as the standard.

Note 3-The dimensionless designator NPS (nominal pipe size) has been substituted in this standard for such traditional terms as "nominal

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[A53A53M: Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless](#)

[A105A105M: Standard Specification for Carbon Steel Forgings for Piping Applications](#)

[A182A182M: Standard Specification for Forged or Rolled Alloy-Steel Pipe Flanges, Forged Fittings, and Valves and Parts for High-Temperature Service](#)

[A193A193M: Standard Specification for Alloy-Steel and Stainless Steel Bolting Materials for High-Temperature Service](#)

[A194A194M: Standard Specification for Carbon and Alloy Steel Nuts for Bolts for High-Pressure or High-Temperature Service, or Both](#)

diameter", "size", and "nominal size".

1.5 The following precautionary caveat pertains only to the test method portion, Sections 11, 12, 13, 14, and 15, of this specification: This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

## 2. Referenced Documents

A530/A530M Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe

E213 Practice for Ultrasonic Examination of Metal Pipe and Tubing

E309 Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation

E381 Method of Macroetch Testing, Inspection, and Rating Steel Products, Comprising Bars, Billets, Blooms, and Forgings

E570 Practice for Flux Leakage Examination of Ferromagnetic Steel Tubular Products

A 520 Specification for Supplementary Requirements for Seamless and Electric-Resistance-Welded Carbon Steel Tubular Products for High-Temperature Service Conforming to ISO Recommendations for Boiler Construction

ANSI B 36.10 Welded and Seamless Wrought Steel Pipe

Fed. Std. No. 123 Marking for Shipments (Civil Agencies)

Fed. Std. No. 183 Continuous Identification Marking of Iron and Steel Products

MIL-STD-129 Marking for Shipment and Storage

MIL-STD-163 Steel Mill Products, Preparation for Shipment and Storage

SSPC-SP 6 Surface Preparation Specification No. 6

### Index Terms

Carbon steel pipe; High temperature service applications-steel pipe; pipe, carbon steel, seamless, spec.



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### **Specification A53/A53M-01 Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless**

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## 1. Scope

1.1 This specification covers seamless and welded black and hot-dipped galvanized steel pipe in NPS 1/8 to NPS 26 [DN 6 to DN 650] (Note 1), inclusive, with nominal wall thickness (Note 2) as given in and Table X2.2 and Table X2.3. It shall be permissible to furnish pipe having other dimensions (Note 2) provided such pipe complies with all other requirements of this specification.

Note 1--The dimensionless designators NPS (nominal pipe size) [DN (diameter nominal)] have been substituted in this specification for such traditional terms as "nominal diameter," "size," and "nominal size."

Note 2--The term nominal wall thickness has been assigned for the purpose of convenient designation, existing in name only, and is used to distinguish it from the actual wall thickness, which may vary over or under the nominal wall thickness.

1.2 This specification covers the following types and grades:

1.2.1 *Type F*--Furnace-butt welded, continuous welded Grade A,

1.2.2 *Type E*--Electric-resistance welded, Grades A and B, and

1.2.3 *Type S*--Seamless, Grades A and B.

Note 3--See Appendix X1 for definitions of types of pipe.

1.3 Pipe ordered under this specification is intended for mechanical and pressure applications and is also acceptable for ordinary uses in steam, water, gas, and air lines. It is suitable for welding, and suitable for forming operations involving coiling, bending, and flanging, subject to the following qualifications:

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[A6A6M: Standard Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling](#)

[A36A36M: Standard Specification for Carbon Structural Steel](#)

[A106: Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service](#)

[A123A123M: Standard Specification for Zinc \(Hot-Dip Galvanized\) Coatings on Iron and Steel Products](#)

[A153A153M: Standard Specification for Zinc Coating \(Hot-Dip\) on Iron and Steel Hardware](#)

1.3.1 Type F is not intended for flanging.

1.3.2 When Types S and E are required for close coiling or cold bending, Grade A is the preferred grade. This provision is not intended to prohibit the cold bending of Grade B pipe.

1.3.3 Type E is furnished either nonexpanded or cold expanded at the option of the manufacturer.

1.4 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.5 The following precautionary caveat pertains only to the test method portion, Sections 9, 10, 11, 15, 16, and 17 of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

1.6 The text of this specification contains notes or footnotes, or both, that provide explanatory material. Such notes and footnotes, excluding those in tables and figures, do not contain any mandatory requirements.

## 2. Referenced Documents

A370 Test Methods and Definitions for Mechanical Testing of Steel Products "

A530/A530M Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe

A700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment

A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products "

A865 Specification for Threaded Couplings, Steel, Black and Zinc-Coated (Galvanized) Welded or Seamless, for Use in Steel Pipe Joints

A90/A90M Test Method for Weight [Mass] of Coating on Iron or Steel Articles with Zinc or Zinc-Alloy Coatings

B6 Specification for Zinc

E213 Practice for Ultrasonic Examination of Metal Pipe and Tubing

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E309 Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation

E570 Practice for Flux Leakage Examination of Ferromagnetic Steel Tubular Products

5L Specification for Line Pipe

ASC X12

B1.20.1 Pipe Threads, General Purpose

B36.10 Welded and Seamless Wrought Steel Pipe

E 59 Practice for Sampling Steel and Iron for Determination of Chemical Composition

Fed. Std. No 183 Continuous Identification Marking of Iron and Steel Products

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)

MIL-STD-129 Marking for Shipment and Storage

MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage

### **Index Terms**

black steel pipe; seamless steel pipe; steel pipe; welded steel pipe; zinc coated steel pipe



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### Specification A795-00 Standard Specification for Black and Hot-Dipped Zinc-Coated (Galvanized) Welded and Seamless Steel Pipe for Fire Protection Use

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## 1. Scope

1.1 This specification covers black and hot-dipped galvanized welded and seamless steel pipe in sizes NPS 1/2 (Note 1) to NPS 10 inclusive, with wall thicknesses as given in Table 1 and Table 2. Pipe having other wall thicknesses may be furnished provided such pipe complies with all other requirements of this specification and the outside diameter is as given in Table 2. Pipe ordered under this specification is intended for use in fire protection systems. The pipe may be bent, but it is not intended for bending made at ambient temperature wherein the inside diameter of the bend is less than twelve times the outside diameter of the pipe being bent (Note 2).

Note 1--The dimensionless designator NPS (nominal pipe size) has been substituted in this standard for such traditional terms as "nominal diameter," "size," and "nominal size."

Note 2--Successful bending of pipe is a function of equipment and technique as well as pipe properties.

1.2 This pipe is suitable for joining by the following methods:

1.2.1 *Light-Weight Fire Protection Pipe*-- Rolled groove, welding, and fittings for plain end pipe. See Table 1 for dimensions.

1.2.2 *Standard-Weight Fire Protection Pipe*-- Cut or rolled groove, threading, welding, and fittings for plain end pipe. See Table 2 for dimensions.

1.2.3 For pipe having dimensions other than those of Table 1 and Table 2, the joining method must be compatible with the pipe dimensions. A complete listing of standard light weight dimensions appears in ASME B36.10 and B36.19.

1.3 The following precautionary caveat pertains only to the test method portion, Sections 8, 9, and 10, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

1.4 The values stated in inch-pound units are to be regarded as the standard. The SI equivalents may be approximate.

## **2. Referenced Documents**

A700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment  
A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products  
A865 Specification for Threaded Couplings, Steel, Black or Zinc-Coated (Galvanized) Welded or Seamless, for Use in Steel Pipe Joints  
B6 Specification for Zinc  
E213 Practice for Ultrasonic Examination of Metal Pipe and Tubing  
E309 Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation  
A 90 Test Method for Weight (Mass) of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings  
B1.20.1 Pipe Threads, General Purpose  
B36.10 Welded and Seamless Wrought Steel Pipe  
B36.19 Stainless Steel Pipe  
Fed. Std. No. 123 Marking for Shipments (Civil Agencies)  
MIL-STD-129 Marking for Shipment and Storage  
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### **Index Terms**

black steel pipe; seamless steel pipe; steel pipe; welded steel pipe; zinc-coated steel pipe



# Sawhill Tubular Products

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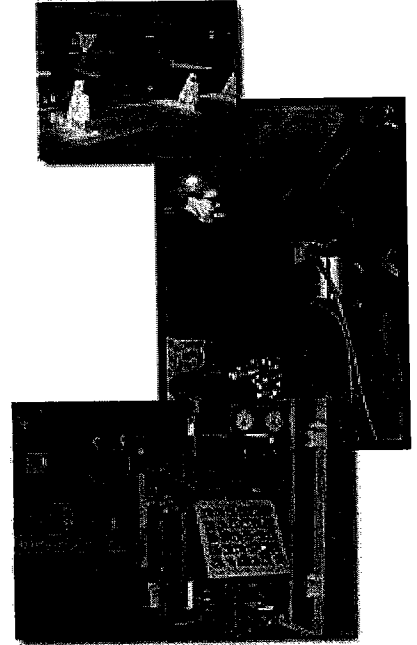
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## ASTM A 106 Seamless - General Information

This specification covers seamless carbon steel pipe for high temperature service in Grades B, and C. Pipe shall be suitable for welding.

Grade B pipe is more suitable for bending, flanging and similar forming operations. Pipe NPS 1-1/2 and under may be either hot-finished, or cold drawn. Pipe NPS 2 and over shall be furnished hot finished unless otherwise specified.

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