

## Pipe Specification A135

<b>Specification</b>	<b>A135 NPS 1/4 -- 30", Schedules 10, 40 and XL THD, Lightwall</b>				
<b>Scope</b>	Covers two grades of electric resistance welded steel pipe. Grade A is adapted for flanging and bending and is suitable for welding. Purpose for which pipe is intended should be stated on order.				
<b>Kinds of Steel Permitted For Pipe Material</b>	Open-hearth                      Basic-oxygen Electric-furnace				
<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. Threadable, lightwall (XL) must meet manufacturers minimums.				
<b>Chemical Requirements</b>		<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
<b>Tensile Requirements</b>			<u>Grade A</u>		<u>Grade B</u>
	Tensile Strength, min., psi		48,000		60,000
	Yield Strength, min., psi		30,000		35,000
<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 seconds for all sizes of electric resistance weld pipe. Non-destructive electric test should be in accordance with practices E213, method E227 or practice E213.				
<b>Permissible Variations in Weights per Foot</b>	Plus or Minus 10% schedule 10 Plus 10% minus 3 1/2% schedule 40				
<b>Permissible Variations in Outside Diameter</b>	Plus or minus 1%				
<b>Mechanical Tests Specified</b>	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.				
<b>Number of Tests Required</b>	Flattening and tensile on one length of pipe from each lot of 400 lengths or less of a style.				
<b>Lengths</b>	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.				
<b>Required Markings on Each Length (On Tags attached to each Bundle in case of Bundled Pipe)</b>	Rolled, Stamped or Stenciled (Mfrs. Option) Name or brand of manufacturer. Kind of pipe, that is, electric-resistance welded A, electric welded B, same schedule wall thickness, schedule 10 or 40, NL ASTM A135 Length of pipe.				
<b>General Information</b>	End finish may be plain end beveled or plain end square cut.				