



Designation: **C547—19** C547 – 22

Standard Specification for Mineral Fiber Pipe Insulation¹

This standard is issued under the fixed designation C547; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers mineral fiber insulation produced to form hollow cylinders for standard pipe and tubing sizes. Use mineral fiber pipe insulation that has been either molded or precision v-grooved, with one or more walls split longitudinally for use on pipe temperatures up to 1400°F (760°C).

1.2 For satisfactory performance, use properly installed protective vapor retarders or barriers on sub-ambient temperature applications to reduce movement of moisture through or around the insulation to the colder surface. Failure to use a vapor barrier can lead to insulation and system damage. Refer to Practice **C921** to aid material selection.

1.3 Flexible mineral fiber wrap products such as perpendicular-oriented fiber insulation rolls, non-precision or manually scored block or board, or flexible boards or blankets used as pipe insulation, are not covered by this specification.

1.4 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.5 For Naval Sea Systems Command (NAVSEA) acceptance, materials must also comply with Supplemental Requirements. See **Annex A1** of this standard.

1.6 The following safety hazards caveat applies to the test methods portion, Section **11**, only: *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

- [C167 Test Methods for Thickness and Density of Blanket or Batt Thermal Insulations](#)
- [C168 Terminology Relating to Thermal Insulation](#)

¹ This specification is under the jurisdiction of ASTM Committee **C16** on Thermal Insulation and is the direct responsibility of Subcommittee **C16.20** on Homogeneous Inorganic Thermal Insulations.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

- C177 Test Method for Steady-State Heat Flux Measurements and Thermal Transmission Properties by Means of the Guarded-Hot-Plate Apparatus
- C302 Test Method for Density and Dimensions of Preformed Pipe-Covering-Type Thermal Insulation
- C335/C335M Test Method for Steady-State Heat Transfer Properties of Pipe Insulation
- C356 Test Method for Linear Shrinkage of Preformed High-Temperature Thermal Insulation Subjected to Soaking Heat
- C390 Practice for Sampling and Acceptance of Thermal Insulation Lots
- C411 Test Method for Hot-Surface Performance of High-Temperature Thermal Insulation
- C447 Practice for Estimating the Maximum Use Temperature of Thermal Insulations
- C585 Practice for Inner and Outer Diameters of Thermal Insulation for Nominal Sizes of Pipe and Tubing
- C665 Specification for Mineral-Fiber Blanket Thermal Insulation for Light Frame Construction and Manufactured Housing
- C680 Practice for Estimate of the Heat Gain or Loss and the Surface Temperatures of Insulated Flat, Cylindrical, and Spherical Systems by Use of Computer Programs
- C795 Specification for Thermal Insulation for Use in Contact with Austenitic Stainless Steel
- C921 Practice for Determining the Properties of Jacketing Materials for Thermal Insulation (Withdrawn 2021)³
- C1045 Practice for Calculating Thermal Transmission Properties Under Steady-State Conditions
- C1058/C1058M Practice for Selecting Temperatures for Evaluating and Reporting Thermal Properties of Thermal Insulation
- C1104/C1104M Test Method for Determining the Water Vapor Sorption of Unfaced Mineral Fiber Insulation
- C1335 Test Method for Measuring Non-Fibrous Content of Man-Made Rock and Slag Mineral Fiber Insulation
- C1617 Practice for Quantitative Accelerated Laboratory Evaluation of Extraction Solutions Containing Ions Leached from Thermal Insulation on Aqueous Corrosion of Metals
- E84 Test Method for Surface Burning Characteristics of Building Materials
- 2.2 *Other Standards:*
- UL 723 Tests for Surface Burning of Building Materials⁴
- CAN/ULC-S102 Standard Method of Test for Surface Burning Characteristics of Building Materials and Assemblies⁵

3. Terminology

3.1 The definitions in Terminology C168 shall apply to the terms used in this specification.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *molded*—refers to products preformed via a molding process to yield full-round cylindrical pipe insulation sections.

3.2.2 *precision v-groove*—refers to products fabricated from machined board via a precision cutting process. Machined segments are adhered to a backing to form a full-round cylindrical pipe insulation section. Due to the precision of the process, the product has no gaps when installed.

4. Classification

4.1 Products covered by this specification are classified according to maximum use temperature as follows:

4.1.1 *Type I*—Molded, for use to 850°F (454°C).

Grade A—Requires no heat-up schedule

Grade B—Heat-up schedule is required

4.1.2 *Type II*—Molded, for use to 1200°F (650°C).

Grade A—Requires no heat-up schedule

Grade B—Heat-up schedule is required

4.1.3 *Type III*—Precision v-groove, for use to 1200°F (650°C).

Grade A—Requires no heat-up schedule

Grade B—Heat-up schedule is required

4.1.4 *Type IV*—Molded, for use to 1000°F (538°C).

Grade A—Requires no heat-up schedule

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from Underwriters Laboratories (UL), 2600 N.W. Lake Rd., Camas, WA 98607-8542, <http://www.ul.com>.

⁵ Available from Underwriters Laboratories of Canada, 7 Crouse Road, Scarborough, Ontario M1R3A9.

Grade B—Heat-up schedule is required

4.1.5 *Type V*—Molded, for use to 1400°F (760°C)

- Grade A—Requires no heat-up schedule
- Grade B—Heat-up schedule is required

NOTE 1—**Warning:** Grade B may not be suitable for applications requiring hot installation capability at the maximum temperature indicated. Products having a Grade B designation are designed to be used with a heat-up schedule. Failure to use a heat-up schedule with Grade B products may lead to an exothermic reaction. This is dependent on thickness and temperature. Consult the manufacturer or manufacturer’s literature for special heat rate considerations.

4.2 It is possible that binder decomposition at elevated temperature will be a limiting factor in certain applications. Consult the manufacturer regarding special heat rate considerations.

5. Materials and Manufacturer

5.1 *Composition*—The mineral fiber insulation for pipes shall be manufactured from mineral substance such as rock, slag, or glass, processed from a molten state into fibrous form with binder. Asbestos shall not be used as an ingredient or component part. It is possible that some products will also contain adhesive.

5.2 *Jackets (Facings)*—The user of this specification has the option to specify that the insulation be jacketed.

NOTE 2—The user is advised that the maximum use temperature of factory-applied facings and adhesives may be lower than the maximum use temperature of the insulation. The specifier shall ensure that sufficient insulation thickness is installed so none of these accessory items (facings and adhesives) are exposed to temperatures above their maximum use temperature. The products covered by this standard are predominantly inorganic in nature. Organic facings, adhesives and binders are also used in the construction of these products. The resulting composite therefore could have increased combustibility.

6. Physical Requirements

6.1 The product shall conform to the following requirements in addition to those specified in **Table 1**.

6.2 *Hot Surface Performance:*

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TABLE 1 Requirements of Mineral Fiber Pipe Insulation (Grades A & B)

Property	Type I (Grades A and B)	Type II (Grades A and B)	Type III (Grades A and B)	Type IV (Grades A and B)	Type V (Grades A and B)
Use temperature, max, °F (°C)	850 (454)	1200 (650)	1200 (650)	1000 (538)	1400 (760)
Sag resistance, max, % thickness change	5	5	5	5	5
Linear shrinkage (length), max, % change after change after soaking heat at maximum use temperature	2	2	2	2	2
Water vapor sorption, max, % by weight	5	5	5	5	5
Surface burning characteristics, max					
Flame spread index	25	25	25	25	25
Smoke developed index	50	50	50	50	50
Apparent thermal conductivity, max, Btu.in./h.ft ² , °F(W/m.K)					
Mean temperature ^A °F (°C)					
100 (38)	0.25 (0.036)	0.25 (0.036)	0.25 (0.036)	0.25 (0.036)	0.25 (0.036)
200 (93)	0.31 (0.045)	0.31 (0.045)	0.31 (0.045)	0.31 (0.045)	0.31 (0.045)
300 (149)	0.40 (0.058)	0.37 (0.053)	0.37 (0.053)	0.37 (0.053)	0.37 (0.053)
400 (204)	0.51 (0.074)	0.45 (0.065)	0.45 (0.065)	0.45 (0.065)	0.45 (0.065)
500 (260)	0.64 (0.092)	0.54 (0.078)	0.54 (0.078)	0.54 (0.078)	0.54 (0.078)
600 (316)		0.65 (0.094)	0.65 (0.094)	0.65 (0.094)	0.65 (0.094)
700 (371)		0.77 (0.111)	0.77 (0.111)	0.77 (0.111)	0.77 (0.111)

^A The user is advised that retrofit applications (where new insulation is being applied over existing) could require knowing the thermal conductivity of the existing layer at mean temperatures above those shown. Consult a manufacturer for data at mean temperatures exceeding those listed.

6.2.1 The product shall not crack, warp, flame, or glow during hot surface exposure. No evidence of melting or fiber degradation shall be evident upon post test inspection.

6.2.2 For Grade A products the insulation's internal temperature rise (exotherm) shall not exceed the pipe temperature by more than 200°F (111°C).

6.3 *Non-fibrous (Shot) Content:*

6.3.1 The non-fibrous content of a rock- or slag-based product shall not exceed 25 % by weight.

6.4 For Naval Sea Systems Command (NAVSEA) acceptance, materials must also comply with Supplemental Requirements. See [Annex A1](#) of this standard.

6.5 *Corrosiveness to Steel*—When tested and evaluated in accordance with [11.1.10](#), the corrosion resulting from insulation in contact with steel plates shall be judged to be no greater than for comparative plates in contact with sterile cotton. Test the composite insulation material (with facing and adhesive) when a facing is factory adhered by the manufacturer or fabricator. (**Warning**—There are adhesives that can cause corrosion to steel when they are in contact with water or water vapor and the steel. Currently there is not a test method available to satisfy all potential causes of corrosion).

6.5.1 The use of Practice [C1617](#) is an acceptable alternative to the test procedure in [11.1.10](#), with the mass loss corrosion rate of the steel test sample exposed to the unfaced or faced insulation extract not to exceed that of the 5 ppm chloride solution.

7. Standard Shapes, Sizes, and Dimensions

7.1 The basic shape of mineral fiber pipe insulation forms a right annular cylinder, which is radially slit on at least one side of the cylinder axis. It is furnished in sections or segments designed to fit standard sizes of pipe and tubing.

7.2 Typical available thicknesses range from nominal ½-in. (13 mm) to nominal 6-in. (152 mm), single or double layer, in ½-in. increments for most pipe and tubing sizes.

7.3 Individual dimensions for inner diameter and wall thickness shall conform to Practice [C585](#).

7.4 Standard section or segment length shall be 3 ft (0.91m) or as agreed upon between the buyer and seller.

8. Dimensional Tolerances

8.1 Length equals $\pm 1/8$ -in. (3 mm).

8.2 When installed on a nominal pipe or tubing size as defined in Practice [C585](#), the insulation shall fit snugly and have tight longitudinal and circumferential joints.

8.3 The inner and outer bore of the insulation shall be concentric to the outer surface. The deviation from concentricity shall not exceed $3/16$ in. (5 mm).

9. Workmanship

9.1 The insulation shall not have defects that will adversely affect installation or service quality.

10. Sampling

10.1 When specified in the purchase order or contract, sampling and acceptance shall be in accordance with Practice [C390](#).

11. Test Methods

11.1 The properties in this specification shall be determined in accordance with the following test methods, with jacketing excluded unless stated otherwise.

11.1.1 *Density and Dimensions*—Test Method C302.

11.1.2 *Linear Shrinkage*—Test Method C356.

11.1.3 *Thermal Conductivity*—Test Method C335/C335M.

11.1.3.1 Thermal performance shall be characterized on a 3-in. NPS × 2-in. pipe insulation size. Thermal performance must be assessed on actual pipe insulation sections. Product density of test specimen shall be recorded and reported per Test Method C302. Data obtained on flat samples, using Test Method C177, shall not be used to state compliance with this specification.

11.1.3.2 Practice C1058/C1058M is acceptable for use to obtain recommended test temperature combinations for testing purposes.

11.1.3.3 As specified in Practice C1045, the range of test conditions must include at least one test where the hot surface temperature is greater than, or equal to, the hot limit of the temperature range of desired data and at least one test where the cold surface temperature is less than, or equal to, the cold limit of the temperature range desired. At least two additional tests shall be distributed somewhat evenly over the rest of the temperature range.

11.1.3.4 Final analysis of the thermal data shall be conducted in accordance with Practice C1045 to generate a thermal conductivity versus temperature relationship for the specimen.

11.1.3.5 The final step of Practice C1045 analysis is to calculate the thermal conductivity using the equations generated at a set of mean temperatures for comparison to the specification.

(1) **Warning**—While it is recommended that the specification data be presented as thermal conductivity versus temperature, it is possible that several existing specifications contain mean temperature data from tests conducted at specific hot and cold surface temperatures. In these cases, it is possible that the conductivity as a function of temperature from the Practice C1045 analysis will provide different results. To ensure that the data is compatible, a Practice C680 analysis, using the thermal conductivity versus temperature relationship from Practice C1045 and the specific hot and cold surface temperatures, is required to determine the effective thermal conductivity for comparison to the specification requirements.

11.1.4 *Water Vapor Sorption*—Test Method C1104/C1104M.

11.1.5 *Surface Burning Characteristics*—Test Method E84.

11.1.5.1 Flat specimens otherwise identical in composition to pipe insulation shall be used. This applies to plain and factory-jacketed products, with and without self-sealing longitudinal lap closure systems.

11.1.5.2 Test Method UL 723 is an acceptable substitute for Test Method E84. These methods are largely considered synonymous by most building officials.

11.1.5.3 For Canada, test in accordance with Test Method CAN/ULC-S102. When the referenced Canadian document in this specification is referred to in applicable Canadian building codes, the editions, referenced by those building codes, shall govern.

11.1.6 *Hot Surface Performance*—Test Method C411 and Practice C447.

11.1.6.1 A 3-in. (75-mm) nominal pipe size or larger shall be used. A test specimen shall be at least 36-in. (914-mm) in length. All types shall be tested at 6-in. (150-mm) nominal thickness, in either single or multiple layer configurations.

11.1.6.2 All products shall be tested without jacketing, with the exception of products where the jacket is an integral part necessary to hold the insulation together such as precision v-groove. The test pipe shall be at the Type I, Type II, Type III, or Type IV temperature specified in 4.1, when the insulation is applied. For Class B material any special requirement for heat-up shall be specified by the manufacturer shall be used.

11.1.6.3 Immediately upon application to the pipe, the internal temperature rise shall be measured as prescribed in the Hot Surface Performance section of Practice **C447**.

11.1.7 *Sag Resistance—Test Method C411:*

11.1.7.1 Sag Resistance shall be tested at the maximum use temperature of the product.

11.1.7.2 Testing shall be conducted at a nominal thickness of 6 in. It is acceptable to nest products to attain the 6 in. thickness.

11.1.7.3 Sag resistance testing shall begin at ambient conditions.

11.1.8 *Non-fibrous Content (Shot)*—For rock or slag based products non-fibrous content shall be determined in accordance with Test Method **C1335**.

11.1.9 *Stress Corrosion Performance*—Compliance with Specification **C795** is necessary only when requested to assess corrosivity when the insulation is applied to austenitic stainless steel pipe.

11.1.10 *Corrosiveness to Steel*—Test in accordance with the corrosiveness test in 13.8 of Specification **C665** or Practice **C1617**.

12. Qualification Requirements

12.1 The following requirements shall be employed for the purpose of product qualification:

12.1.1 Density and dimensions,

12.1.2 Linear shrinkage,

12.1.3 Apparent thermal conductivity,

12.1.4 Surface burning characteristics,

12.1.5 Hot surface performance,

12.1.6 Sag resistance, [is.iteh.ai/catalog/standards/sist/81dda7bf-c27f-4340-ad11-3a797d9fb327/astm-c547-22](https://standards.iteh.ai/catalog/standards/sist/81dda7bf-c27f-4340-ad11-3a797d9fb327/astm-c547-22)

12.1.7 Water vapor sorption,

12.1.8 Non-fibrous content (shot), and

12.1.9 Corrosiveness to steel.

13. Inspection

13.1 When agreed upon between the purchaser and manufacturer or supplier, the inspection of material shall be made at either the point of shipment or the point of delivery. The following requirements are generally employed for the purposes of acceptance and sampling of lots, on shipments of qualified insulation:

13.1.1 Dimensional tolerances, and Workmanship.

13.2 *Rejection*—It is acceptable to reject material that fails to conform to the requirements of this specification. Rejection needs to be reported to the manufacturer or supplier promptly and in writing. The manufacturer and supplier have the right to verify rejected products.

14. Packaging and Package Marking

14.1 *Packaging*—Mineral fiber preformed pipe insulation shall be packaged in the manufacturer's standard commercial container unless otherwise agreed upon between the buyer, seller, and the manufacturer.

14.2 Unless otherwise specified, each container shall be marked with the manufacturer's lot or date code identification, and facing, if any, on the material in the container. When specified in the purchase order or contract, each container shall also be marked with the appropriate Specification C547 type and maximum use temperature.

15. Keywords

15.1 mineral fiber thermal insulation; molded; physical properties; pipe insulation; precision v-groove; thermal properties

ANNEX

(Mandatory Information)

A1. MINERAL FIBER PIPE INSULATION COMPRESSION RESILIENCY FOR NAVSEA

A1.1 Scope

A1.1.1 In addition to the requirements of this standard, additional compression resiliency testing is required for Naval Sea System Command (NAVSEA) acceptance.

A1.2 Background

A1.2.1 NAVSEA engineers, builds and supports America's Fleet of ships and combat systems. This test is only required if NAVSEA acceptance is desired.

[ASTM C547-22](https://standards.iteh.ai/catalog/standards/sist/81dda7bf-c27f-4340-ad11-3a797d9fb327/astm-c547-22)

<https://standards.iteh.ai/catalog/standards/sist/81dda7bf-c27f-4340-ad11-3a797d9fb327/astm-c547-22>

A1.3 Test Overview

A1.3.1 Three 12-in. segments of half-round 3 by 2 in. (80 by 50 mm) thick mineral fiber pipe insulation are measured for initial thickness, then compressed 10 times to a maximum load of 200 lb, then re-measured for thickness recovery after compression.

A1.4 Apparatus

A1.4.1 Universal testing machine,

A1.4.2 Pin gauge as specified in Test Methods **C167**,

A1.4.3 Steel rule graduated in $\frac{1}{32}$ in. (1 mm),

A1.4.4 A 12 in. (305 mm) length of schedule 40, 3-in. (80 mm) nominal pipe size (NPS),