



Designation: B 744/B 744M – 99

Standard Specification for Aluminum Alloy Sheet for Corrugated Aluminum Pipe¹

This standard is issued under the fixed designation B 744/B 744M; 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.

1. Scope

1.1 This specification covers aluminum alloy sheets used in the fabrication of corrugated aluminum pipe intended for use for storm water drainage, underdrains, culverts, and similar uses. The material is furnished corrugated in cut lengths, and uncorrugated in coils and cut lengths.

1.2 This specification is applicable to orders in either inch-pound units (as B 744) or SI units (as B 744M). Inch-pound units and SI units are not necessarily equivalent. SI units are shown in brackets in the text; they are the applicable values when the material is ordered to B 744M.

2. Referenced Documents

2.1 ASTM Standards:

B 209 Specification for Aluminum and Aluminum-Alloy Sheet and Plate²

B 209M Specification for Aluminum and Aluminum-Alloy Sheet and Plate [Metric]²

B 666/B 666M Practice for Identification Marking of Aluminum and Magnesium Products²

2.2 American National Standards:²

H35.2 Dimensional Tolerances for Aluminum Mill Products

H35.2M Dimensional Tolerances for Aluminum Mill Products [Metric]

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *fabricator*—the producer of the pipe.

3.1.2 *manufacturer*—the producer of the sheet.

3.1.3 *purchaser*—the purchaser of the finished pipe.

4. Ordering Information

4.1 Orders for materials under this specification shall include the following information:

4.1.1 Name of material (aluminum alloy sheet for corrugated aluminum pipe),

4.1.2 This specification designation (including number, year, and revision letter if applicable), as B 744 – ____ for inch-pound units or B 744M – ____ for SI units, and

4.1.3 Specified sheet thickness, using only those thicknesses listed in Table 1.

4.1.4 For sheet ordered in coils:

4.1.4.1 Sheet width,

4.1.4.2 Coil size requirements (specify maximum outside diameter (OD), acceptable inside diameter (ID), and maximum weight), and

4.1.4.3 Total quantity (mass).

4.1.5 For sheet ordered flat in cut lengths:

4.1.5.1 Sheet width and length,

4.1.5.2 Total quantity (mass or number of sheets), and

4.1.5.3 Maximum mass or number of sheets in a lift.

4.1.6 For sheet ordered corrugated:

4.1.6.1 Sheet width (overall) and length,

4.1.6.2 Corrugation size (pitch and depth) (see 8.4),

4.1.6.3 Total quantity (mass or number of sheets), and

4.1.6.4 Maximum mass or number of sheets in a lift.

4.2 Additionally, orders for materials under this specification shall include the following information when requested by the purchaser:

4.2.1 Whether certification is required.

NOTE 1—Typical ordering descriptions are as follows: (1) Aluminum alloy sheet for corrugated aluminum pipe, conforming to ASTM B 744 – ____; 0.060-in. thickness; 1000 sheets, 25½ by 60 in., with 2⅔ by ½ in. corrugations; maximum 300 sheets per lift. (2) Aluminum alloy sheet for corrugated aluminum pipe, conforming to ASTM B 744M – ____; 2.67-mm thickness by 760-mm width; 25 000 kg total; coils 1200 mm OD max, 600 mm ID min, 5000 kg max each coil; certified with test report.

5. Chemical Composition

5.1 The sheet material shall conform to the chemical composition limits in Specifications B 209 [B 209M].

¹ This specification is under the jurisdiction of ASTM Committee B-7 on Light Metals and Alloys and is the direct responsibility of Subcommittee B07.08 on Aluminum Culvert.

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² Annual Book of ASTM Standards, Vol 02.02.