



Standard Specification for Ductile Iron Culvert Pipe¹

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1. Scope

1.1 This specification covers 14 to 64-in. ductile-iron culvert pipe centrifugally cast.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 The following safety hazards caveat pertains only to the test methods portions, Sections 6 and 7, 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

2.1 ASTM Standards:

- E 8 Test Methods for Tension Testing of Metallic Materials²
- E 23 Test Methods for Notched Bar Impact Testing of Metallic Materials²

2.2 ANSI/AWWA Standards:

- C 150/A21.50 Thickness Design of Ductile-Iron Pipe³
- C 151/A21.51 Ductile-Iron Pipe Centrifugally Cast, for Water³

2.3 AASHTO Standard:

- AASHTO T-99 Moisture Density Relations of Soils Using a 5.5-lb (2.5-kg) Rammer 12-in. (305-mm) Drop⁴

3. General Requirements

3.1 The pipe shall be manufactured of ductile iron that meets the requirements of Sections 6 and 7. See Table 1 for pipe thicknesses and weights; see also Fig. 1.

3.2 The pipe shall be provided with suitable joints, such as push-on or other types of joints that prevent lateral displacement. Plain-end pipe for use with suitable couplings may be furnished.

3.3 Unless otherwise specified, pipe shall have a nominal

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² Annual Book of ASTM Standards, Vol 03.01.

³ Available from American National Standards Institute, 11 West 42nd Street, 13th Floor, New York, NY 10036.

⁴ Available from the American Association of State Highway and Transportation Officials, 444 N. Capitol, Washington, DC 20001.

TABLE 1 Standard Wall Thickness^A and Weight of Push-On Joint Ductile-Iron Culvert Pipe

Nominal Diam., in.	Pressure Class	Nominal Thickness, in. (mm)	Maximum Depth of Cover, Ft. (m)	18-ft (5.5m) Laying Length, Weight per, Length, lb (kg)	20-ft (6.1 mm) Laying Length, Weight per, Length, lb (kg)
14	250	0.28 (7.1)	41 (12.5)	770 (349)	855 (388)
16	250	0.30 (7.6)	41 (12.5)	940 (426)	1040 (472)
18	250	0.31 (7.9)	40 (12.2)	1090 (494)	1205 (547)
20	250	0.33 (8.4)	40 (12.2)	1290 (585)	1425 (646)
24	200	0.33 (8.4)	37 (11.3)	1550 (703)	1710 (776)
30	150	0.34 (8.6)	33 (10.1)	2000 (907)	2210 (1002)
36	150	0.38 (9.7)	33 (10.1)	2675 (1213)	2955 (1340)
42	150	0.41 (10.4)	32 (9.8)	3415 (1549)	3765 (1708)
48	150	0.46 (12.4)	33 (10.1)		4805 (2180)
54	150	0.51 (13.0)	33 (10.1)		6035 (2737)
60	150	0.54 (13.7)	33 (10.1)		6930 (3143)
64	150	0.56 (14.2)	33 (10.1)		7680 (3484)

^A Nominal thickness is based on the minimum Pressure Class ductile iron pipe available installed in Type 5 trench condition in accordance with ANSI/AWWA C150/A21.50, as shown in Fig. 1, with a maximum ring deflection of 5% and maximum ring stress of 48,000 psi (331 MPa). Wall thickness of pipe to serve at other depths of cover may be calculated in accordance with ANSI/AWWA C150/A21.50, allowing 5% maximum ring deflection.

length of 18 or 20 ft (5.5 or 6.1 m). A maximum of 20% of the total number of pipe of each size specified in an order may be furnished as much as 24 in. (610 mm) shorter than the nominal laying length, and an additional 10% may be furnished as much as 6 in. (152 mm) shorter than the nominal laying length.

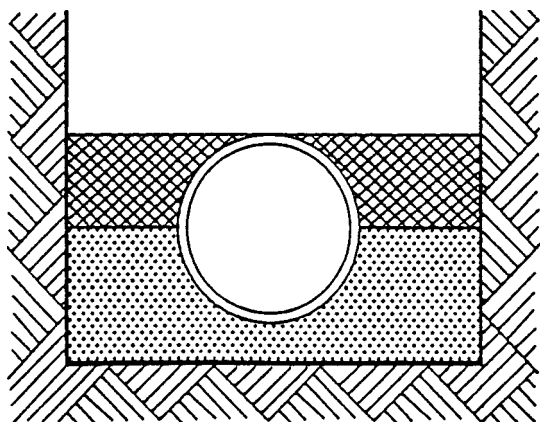
4. Tolerances or Permitted Variations

4.1 *Dimensions*—The spigot end, bell, and socket of the pipe and the accessories shall be gaged with suitable gages at sufficiently frequent intervals to assure that the dimensions comply with the requirements of this specification. The smallest inside diameter (ID) of the sockets and the outside diameter (OD) of the spigot ends shall be tested with circular gages. Other socket dimensions shall be gauged as may be appropriate.

4.2 *Thickness*—Minus thickness tolerances of pipe shall not exceed those shown below:

Nominal Size, in.	Minus Tolerance, in. (mm)
14 to 42	0.07 (1.8)
48	0.08 (2.0)
54 to 64	0.09 (2.3)

NOTE 1—An additional minus tolerance of 0.02 in. (0.05 mm) shall be permitted along the barrel of the pipe for a distance not to exceed 12 in. (305 mm).



NOTE 1—Pipe is bedded to its centerline in compacted granular material with a minimum of 4 in. (102 mm) under the pipe. Compacted granular or select^A material is used to the top of the pipe. (Material is compacted to approximately 90 % Standard Proctor in accordance with AASHTO Standard T-99.)

^A Loose soil or select material is defined as native soil excavated from the trench, free of rocks, foreign material, and frozen earth.

FIG. 1 Type 5 Trench

4.3 *Weight*—The weight of any single pipe shall not be less than the tabulated weight by more than 5 %.

5. Coating

5.1 All pipe shall be coated inside and outside with an asphaltic material approximately 1 mil (0.025 mm) thick. The finished coating shall be continuous and smooth, neither brittle when cold, nor sticky when exposed to the sun, and shall be strongly adherent to the pipe.

6. Acceptance Tests

6.1 The standard acceptance tests for the physical characteristics of the pipe shall be as follows:

6.2 *Tension Test*—Unless otherwise specified by the purchaser, a tension test specimen shall be cut longitudinally or circumferentially from the midsection of the pipe wall. In case of dispute, the specimen shall be cut longitudinally. This specimen shall be machined and tested in accordance with Fig. 2 and Test Methods E 8. The yield strength shall be determined by the 0.2 % offset, half-of-pointer, or extension-under-load methods. If check tests are to be made, the 0.2 % offset method shall be used. All specimens shall be tested at room temperature 70 ± 10°F (21 ± 6°C).

6.2.1 *Acceptable Values*—The acceptance values for test specimens shall be as follows:

Grade of iron	60-42-10
Minimum tensile strength, psi (MPa)	60 000 (413.7)
Minimum yield strength, psi (MPa)	42 000 (289.6)
Minimum elongation, %	10

6.3 *Impact Test*—Tests shall be made in accordance with Test Methods E 23, except that dimensions of the specimens shall be 0.500 in. (12.70 mm) by full thickness of pipe wall. Unless otherwise specified by the purchaser, the notched impact test specimen shall be in accordance with Fig. 3, except that it may be cut circumferentially. In case of dispute, the specimen shall be cut in accordance with Fig. 3. If the pipe wall

thickness exceeds 0.40 in. (10.2 mm), the impact specimen may be machined to a nominal thickness of 0.40 in. (10.2 mm). In all tests, impact values are to be corrected to a standard wall thickness, $t_s = 0.40$ in. (10.2 mm), by calculation as follows:

$$\text{Impact value (corrected)} = \frac{t_s}{t} \times \text{impact value (actual)}$$

where:

t = the thickness of the specimen, in. (mm).

The Charpy test machine anvil shall not be moved to compensate for the variation of cross-section dimensions of the test specimen.

6.3.1 *Acceptance Value*—The corrected acceptance value for notched impact test specimens shall be a minimum of 7 ft-lbf (9.49 J) for tests conducted at 70 ± 10°F (21 ± 6°C).

6.4 *Sampling*—At least one tension specimen shall be taken during each casting period of approximately 3 h. At least one 70 ± 10°F (21 ± 6°C) Charpy impact specimen shall be taken during each operating hour. Specimens shall be selected to properly represent extremes of pipe diameters and wall thicknesses.

7. Additional Control Tests by Manufacturer

7.1 An additional low-temperature impact test shall be made from at least 10 % of the sample coupons taken for the required 70 ± 10°F (21 ± 6°C) Charpy impact test specified in 6.4 to check compliance with a minimum corrected value of 3 ft-lbf (4.07 J) for tests conducted at -40°F (-40°C). Test specimens shall be prepared and tested in accordance with 6.3.

7.2 In addition, the manufacturer shall conduct such other tests as may be necessary to ensure compliance with this specification.

8. Additional Tests Required by Purchaser

8.1 When tests other than those required in this specification are required by the purchaser, such tests shall be specified in the purchaser's specifications.

9. Inspection and Certification by Manufacturer

9.1 Unless otherwise provided in the purchaser's specifications, the manufacturer shall establish the necessary quality-control and inspection practice to ensure compliance with this specification.

9.2 The manufacturer shall, if required by the purchaser's specifications, furnish a sworn statement that the inspection and all of the specified tests have been made and that all results thereof comply with the requirements of this specification.

9.3 All pipes shall be clean and sound without defects that could impair service. Repairing of defects by welding or other methods shall not be allowed if such repairs could adversely affect the serviceability of the pipe or its capability to meet strength requirements of this specification.

10. Inspection by Purchaser

10.1 If the purchaser desires to inspect pipe at the manufacturer's plant, the purchaser shall so state in the purchaser's specifications and describe the conditions (such as time and the extent of inspection) under which the inspection shall be made.

10.2 The purchaser's representative shall have free access to those areas of the manufacturer's plant that are necessary to