



Designation: A 795 – 00

## Standard Specification for Black and Hot-Dipped Zinc-Coated (Galvanized) Welded and Seamless Steel Pipe for Fire Protection Use<sup>1</sup>

This standard is issued under the fixed designation A 795; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

### 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.*

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.09 on Steel Pipe.

Current edition approved Sept. 10, 2000. Published November 2000. Originally published as A 795 – 82. Last previous edition A 795 – 97<sup>\epsilon</sup>1.

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

#### 2.1 ASTM Standards:

A 90 Test Method for Weight (Mass) of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings<sup>2</sup>

A 700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment<sup>3</sup>

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products<sup>4</sup>

A 865 Specification for Threaded Couplings, Steel, Black or Zinc-Coated (Galvanized) Welded or Seamless, for Use in Steel Pipe Joints<sup>5</sup>

B 6 Specification for Zinc<sup>6</sup>

E 213 Practice for Ultrasonic Examination of Metal Pipe and Tubing<sup>7</sup>

E 309 Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation<sup>7</sup>

#### 2.2 ASME Standards:

B1.20.1 Pipe Threads, General Purpose, Inch<sup>8</sup>

B36.10 Welded and Seamless Wrought Steel Pipe<sup>8</sup>

B36.19 Stainless Steel Pipe<sup>8</sup>

#### 2.3 Federal Standard:

Fed. Std. No. 123 Marking for Shipments (Civil Agencies)<sup>9</sup>

#### 2.4 Military Standards:

MIL-STD-129 Marking for Shipment and Storage<sup>9</sup>

MIL-STD-163 Steel Mill Products, Preparation for Shipment and Storage<sup>9</sup>

### 3. Terminology

#### 3.1 Definitions of Terms Specific to This Standard:

<sup>2</sup> Annual Book of ASTM Standards, Vol 01.06.

<sup>3</sup> Annual Book of ASTM Standards, Vol 01.05.

<sup>4</sup> Annual Book of ASTM Standards, Vol 01.03.

<sup>5</sup> Annual Book of ASTM Standards, Vol 01.01.

<sup>6</sup> Annual Book of ASTM Standards, Vol 02.04.

<sup>7</sup> Annual Book of ASTM Standards, Vol 03.03.

<sup>8</sup> Available from ASME International, Three Park Avenue, New York, NY 10016-5990.

<sup>9</sup> Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.



**TABLE 1 Dimensions, Weights, and Test Pressure For Light-Weight Fire Protection Pipe—Schedule 10<sup>A</sup>**

NPS Designator	Outside Diameter		Nominal Wall Thickness		Weight Plain End		Test Pressure			
							Furnace-Welded		Seamless and Electric-Resistance-Welded	
							in.	mm	psi	MPa
3/4	1.050	(26.7)	0.083	(2.11)	0.86	(1.28)	500	(3.45)	700	(4.83)
1	1.315	(33.4)	0.109	(2.77)	1.41	(2.09)	500	(3.45)	700	(4.83)
1 1/4	1.660	(42.2)	0.109	(2.77)	1.81	(2.69)	500	(3.45)	1000	(6.89)
1 1/2	1.900	(48.3)	0.109	(2.77)	2.09	(3.11)	500	(3.45)	1000	(6.89)
2	2.375	(60.3)	0.109	(2.77)	2.64	(3.93)	500	(3.45)	1000	(6.89)
2 1/2	2.875	(73.0)	0.120	(3.05)	3.53	(5.26)	500	(3.45)	1000	(6.89)
3	3.500	(88.9)	0.120	(3.05)	4.34	(6.46)	500	(3.45)	1000	(6.89)
3 1/2	4.000	(101.6)	0.120	(3.05)	4.98	(7.41)	500	(3.45)	1200	(8.27)
4	4.500	(114.3)	0.120	(3.05)	5.62	(8.37)	500	(3.45)	1200	(8.27)
5	5.563	(141.3)	0.134	(3.40)	7.78	(11.58)	<sup>B</sup>	<sup>B</sup>	1200	(8.27)
6	6.625	(168.3)	0.134	(3.40)	9.30	(13.85)	<sup>B</sup>	<sup>B</sup>	1000	(6.89)
8	8.625	(219.1)	0.188 <sup>C</sup>	(4.78)	16.96	(25.26)	<sup>B</sup>	<sup>B</sup>	800	(5.51)
10	10.750	(273.1)	0.188 <sup>C</sup>	(4.78)	21.23	(31.62)	<sup>B</sup>	<sup>B</sup>	700	(4.83)

<sup>A</sup> Schedule 10 corresponds to Schedule 10S as listed in ANSI B 36.19 for NPS 3/4 through 6 only.

<sup>B</sup> Furnace-welded pipe is not made in sizes larger than NPS 4.

<sup>C</sup> Not Schedule 10.

**TABLE 2 Dimensions, Weights, Test Pressures For Standard-Weight Fire Protection Pipe—Schedule 30 and Schedule 40**

NPS Designator	Outside Diameter		Nominal Wall Thickness <sup>A</sup>		Weight Plain End		Weight Thread And Couplings <sup>B</sup>		Test Pressure			
									Furnace-Welded		Seamless and Electric-Resistance-Welded	
									in.	mm	psi	MPa
1/2	0.840	(21.3)	0.109	(2.77)	0.85	(1.27)	0.85	(1.27)	700	(4.83)	700	(4.83)
3/4	1.050	(26.7)	0.113	(2.87)	1.13	(1.69)	1.13	(1.68)	700	(4.83)	700	(4.83)
1	1.315	(33.4)	0.133	(3.38)	1.68	(2.50)	1.68	(2.50)	700	(4.83)	700	(4.83)
1 1/4	1.660	(42.2)	0.140	(3.56)	2.27	(3.39)	2.28	(3.40)	1000	(6.89)	1000	(6.89)
1 1/2	1.900	(48.3)	0.145	(3.68)	2.72	(4.05)	2.73	(4.07)	1000	(6.89)	1000	(6.89)
2	2.375	(60.3)	0.154	(3.91)	3.66	(5.45)	3.69	(5.50)	1000	(6.89)	1000	(6.89)
2 1/2	2.875	(73.0)	0.203	(5.16)	5.80	(8.64)	5.83	(8.68)	1000	(6.89)	1000	(6.89)
3	3.500	(88.9)	0.216	(5.49)	7.58	(11.29)	7.62	(11.35)	1000	(6.89)	1000	(6.89)
3 1/2	4.000	(101.6)	0.226	(5.74)	9.12	(13.58)	9.21	(13.71)	1200	(8.27)	1200	(8.27)
4	4.500	(114.3)	0.237	(6.02)	10.80	(16.09)	10.91	(16.25)	1200	(8.27)	1200	(8.27)
5	5.563	(141.3)	0.258	(6.55)	14.63	(21.79)	14.82	(22.07)	<sup>C</sup>	<sup>C</sup>	1200	(8.27)
6	6.625	(168.3)	0.280	(7.11)	18.99	(28.29)	19.20	(28.60)	<sup>C</sup>	<sup>C</sup>	1200	(8.27)
8	8.625	(219.1)	0.277 <sup>A</sup>	(7.04)	24.72	(36.82)	25.57	(38.09)	<sup>C</sup>	<sup>C</sup>	1200	(8.27)
10	10.750	(273.1)	0.307 <sup>A</sup>	(7.80)	34.27	(51.05)	35.78	(53.29)	<sup>C</sup>	<sup>C</sup>	1000	(6.89)

<sup>A</sup> NPS 1/2 through 6—Schedule 40; NPS 8 and 10—Schedule 30.

<sup>B</sup> Based on 20-ft (6.1-m) lengths.

<sup>C</sup> Furnace-welded pipe is not made in sizes larger than NPS 4.

3.1.1 *imperfection*—any discontinuity or irregularity found in the pipe.

3.1.2 *defect*—an imperfection of sufficient size or magnitude to be cause for rejection.

#### 4. Classification

4.1 Pipe may be furnished in the following types (Note 3):

4.1.1 *Type F*—Furnace-butt welded, continuous welded,

4.1.2 *Type E*—Electric-resistance-welded, or

4.1.3 *Type S*—Seamless.

NOTE 3—See Annex A1 for definitions of the types of pipe.

#### 5. Ordering Information

5.1 Orders for material under this specification should include the following, as required, to describe the desired material adequately:

5.1.1 Quantity (feet or number of lengths),

5.1.2 Name of material (steel pipe),

5.1.3 Type (seamless, electric-resistance-welded, or furnace-welded),

5.1.4 Grade (seamless and electric-resistance-welded only),

5.1.5 Size (NPS designator and weight class; standard weight or light weight; or outside diameter and nominal wall) and wall thickness (Table 1 and Table 2),

5.1.6 Finish (black, galvanized, or other type of coating as specified by the purchaser),

5.1.7 Length (specific or random),

5.1.7.1 Grade for Type E and Type S,

5.1.8 End finish,

5.1.8.1 Plain end, square cut,

5.1.8.2 Plain end, beveled,

5.1.8.3 Cut groove (Note 4),

5.1.8.4 Rolled groove (Note 4),

5.1.8.5 Threads only,

5.1.8.6 Threaded and coupled, and

5.1.8.7 Couplings power tight.

NOTE 4—Type of groove specified by the purchaser.

5.1.9 ASTM designation.

## 6. Materials and Manufacture

6.1 The steel for both welded and seamless pipe shall be made by one or more of the following processes: open-hearth, electric-furnace, or basic-oxygen.

6.2 Welded pipe NPS 4 and under may be furnace-welded or electric-resistance welded. Welded pipe over NPS 4 shall be electric-resistance-welded.

6.3 The weld seam of electric-resistance-welded pipe in Grade B shall be heat treated after welding to a minimum of 1000°F (540°C) so that no untempered martensite remains, or otherwise processed in such a manner that no untempered martensite remains.

## 7. Chemical Composition

7.1 The steel shall conform to the requirements as to chemical composition specified in **Table 3**.

7.2 An analysis of two pipes from each lot of 500 lengths, or fraction thereof, may be made by the purchaser. The chemical composition thus determined shall conform to the requirements specified in **Table 3**.

7.3 Methods, practices, and definitions for chemical analysis shall be in accordance with Test Methods, Practices, and Terminology **A 751**.

7.4 If the analysis of either pipe does not conform to the requirements specified in **Table 3**, analyses shall be made on additional pipes of double the original number from the same lot, each of which shall conform to the requirements specified in **Table 3**.

## 8. Hydrotest

8.1 Each length of pipe shall be subjected to a hydrostatic test by the manufacturer. The minimum test pressure shall be as prescribed in **Table 1** and **Table 2**. This does not prohibit testing at a higher pressure at the manufacturer's option. The manufacturer may apply the hydrostatic test to pipe with plain ends, with threads only, or with threads and couplings. The hydrostatic test may be applied to single or multiple lengths.

8.2 The hydrostatic test shall be applied, without leakage through the pipe wall, to each length of pipe.

NOTE 5—The hydrostatic test pressures given herein are inspection test pressures. They are not intended as a basis for design and do not have any direct relationship to working pressures.

## 9. Nondestructive Electric Test

9.1 As an alternative to the hydrostatic test, and when accepted by the purchaser, test each pipe with a nondestructive

electric test in accordance with Practice **E 213** or Practice **E 309**. It is the intent of this test to reject pipe containing defects.

9.2 The following information is for the benefit of the user of this specification:

9.2.1 The ultrasonic examination referred to in this specification is intended to detect longitudinal discontinuities having a reflective area similar to or larger than the reference notch. The examination may not detect circumferentially oriented imperfections or short, deep defects.

9.2.2 The eddy-current examination referenced in this specification has the capability of detecting significant discontinuities, especially of the short, abrupt type.

9.2.3 The hydrostatic test referred to in Section **8** is a test method provided for in many product specifications. This test has the capability of finding defects of a size permitting the test fluid to leak through the tube wall and may be either visually seen or detected by a loss of pressure. This test may not detect very tight, through-the-wall defects or defects that extend an appreciable distance into the wall without complete penetration.

9.2.4 A purchaser interested in ascertaining the nature (type, size, location, and orientation) of discontinuities that can be detected in the specific application of these examinations should discuss this with the manufacturer of the tubular product.

9.3 In order to accommodate the various types of nondestructive electric testing equipment and techniques in use, the calibration tube shall contain, at the option of the producer, any one or more of the following discontinuities to establish a minimum sensitivity level for rejection.

9.3.1 *Drilled Hole*—Drill a hole radially and completely through the pipe wall, care being taken to avoid distortion of the pipe while drilling. The diameter of the hole shall not be larger than 0.031 in. (0.79 mm) for pipe under 0.125 in. (3.18 mm) in wall thickness, not larger than 0.0625 in. (1.59 mm) for pipe between 0.125 in. (3.18 mm) and 0.200 in. (5.08 mm) in wall thickness, and not larger than 0.125 in. (3.18 mm) for pipe over 0.200 in. (5.08 mm) in wall thickness.

9.3.2 *Transverse Tangential Notch*—Using a round tool or file with a ¼-in. (6.4-mm) diameter, file or mill a notch tangential to the surface and transverse to the longitudinal axis of the pipe. The notch shall have a depth not exceeding 12½ % of the specified wall thickness of the pipe.

9.3.3 *Longitudinal Notch*—Machine a notch 0.031 in. (0.79 mm) or less in width in a radial plane parallel to the pipe axis on the outside surface of the pipe, to have a depth not exceeding 12½ % of the specified wall thickness of the pipe. The length of the notch shall be compatible with the testing method.

9.3.4 *Compatibility*—The discontinuity in the calibration pipe shall be compatible with the testing equipment and method being used.

9.4 Reject pipe producing a signal equal to or greater than the calibration discontinuity.

## 10. Flattening Test

10.1 Perform the flattening test on pipe in accordance with the following:

**TABLE 3 Chemical Requirements**

	Composition, max, %			
	C	Mn	P	S
Type E (electric-resistance-welded pipe) & Type S (seamless pipe)				
Open-hearth, electric-furnace or basic-oxygen:				
Grade A	0.25	0.95	0.035	0.035
Grade B	0.30	1.20	0.035	0.035
Type F (furnace-welded pipe)				
Open-hearth, electric-furnace, or basic oxygen			0.050	0.045