



Standard Specification for Pipe, Steel, Electric-Fusion (Arc)-Welded (Sizes NPS 16 and Over)¹

This standard is issued under the fixed designation A 134; 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 electric-fusion (arc)-welded straight seam or spiral seam steel pipe NPS 16 and over in diameter (inside or outside as specified by purchaser), with wall thicknesses up to $\frac{3}{4}$ in. (19.0 mm), inclusive. Pipe having other dimensions may be furnished provided such pipe complies with all other requirements of this specification.

NOTE 1—Acceptability for many services may be controlled by codes or standards such as those published by the American National Standards Institute and American Society of Mechanical Engineers.

NOTE 2—For testing methods not specifically covered in this specification, reference can be made to Test Methods and Definitions A 370, with particular reference to Annex A 2 on Steel Tubular Products.

NOTE 3—A comprehensive listing of standardized pipe dimensions is contained in ANSI B 36.10.

1.2 The values stated in inch-pound units are to be regarded as the standard.

NOTE 4—The dimensionless designator NPS (nominal pipe size) has been substituted in this standard for such traditional terms as “nominal diameter”, “size”, and “nominal size”.

1.3 The following precautionary caveat pertains specifically to Section 5 of this specification. *This standard does not purport to address all of the safety problems, 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:

- A 36/A 36M Specification for Carbon Structural Steel²
- A 283/A 283M Specification for Low and Intermediate Tensile Strength Carbon Steel Plates²
- A 285/A 285M Specification for Pressure Vessel Plates, Carbon Steel, Low- and Intermediate-Tensile Strength²

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.09 on Carbon Steel Tubular Products.

Current edition approved Oct. 10, 1996. Published November 1997. Originally published as A 134 – 31 T. Last previous edition A 134 – 93.

² Annual Book of ASTM Standards, Vol 01.04.

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³

A 570/A 570M Specification for Steel, Sheet and Strip, Carbon, Hot-Rolled, Structural Quality⁴

2.2 ASME Boiler and Pressure Vessel Code: Section IX Welding Qualifications⁵

2.3 American National Standards Institute Standard: B 16.25 Buttwelding Ends⁶

B 36.10 Welded and Seamless Wrought Steel Pipe⁶

3. Ordering Information

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

- 3.1.1 Quantity (feet, meters, or number of lengths),
- 3.1.2 Name of material (electric-fusion-(arc) welded pipe),
- 3.1.3 Grade (Section 4),
- 3.1.4 Size (inside or outside diameter and nominal wall thickness),
- 3.1.5 Length (specified or random),
- 3.1.6 Specific straightness requirements (see 12.3),
- 3.1.7 End finish (Section 15),
- 3.1.8 Hydrostatic test pressure (Section 11),
- 3.1.9 ASTM designation, and
- 3.1.10 End use of material.

4. Material

4.1 The steel from which the pipe is made shall conform to Specifications A 283/A 283M, A 285/A 285M, A 570 or A 36/A 36M or to other ASTM specifications for equally suitable weldable material, as specified: For purposes of marking and certification, when required, the pipe grade of material shall be established by the A xxx plate specification designation and plate grade, when applicable.

5. Manufacture

5.1 The longitudinal edges of the steel shall be shaped to give the most satisfactory results by the particular welding

³ Annual Book of ASTM Standards, Vol 01.01.

⁴ Annual Book of ASTM Standards, Vol 01.03.

⁵ Available from American Society of Mechanical Engineers, 345 E. 47th St. New York, NY 10017.

⁶ Available from American National Standards Institute, 11 West 42nd St., 13th Floor, New York, NY 10036.