



Standard Specification for Welded and Seamless Steel Pipe Piles¹

This standard is issued under the fixed designation A 252; 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 nominal (average) wall steel pipe piles of cylindrical shape and applies to pipe piles in which the steel cylinder acts as a permanent load-carrying member, or as a shell to form cast-in-place concrete piles.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions of the values in inch-pound units to values in SI units.

1.3 The text of this specification contains notes and footnotes that provide explanatory material. Such notes and footnotes, excluding those in tables and figures, do not contain any mandatory requirements.

1.4 The following precautionary caveat pertains only to the test method portion, Section 16 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 370 Test Methods and Definitions for Mechanical Testing of Steel Products²

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products²

A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys³

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications⁴

¹ 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 Carbon Steel Tubular Products.

Current edition approved Jan. 10, 1998. Published September 1998. Originally published as A 252 – 44 T. Last previous edition A 252 – 96.

² Annual Book of ASTM Standards, Vol 01.03.

³ Annual Book of ASTM Standards, Vol 01.01.

⁴ Annual Book of ASTM Standards, Vol 14.02.

3. Terminology

3.1 *Definitions*—Definitions of terms used in this specification shall be in accordance with Terminology A 941.

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

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

4. Ordering Information

4.1 Orders for material under this specification shall contain information concerning as many of the following items as are required to describe the desired material adequately:

4.1.1 Quantity (feet or number of lengths),

4.1.2 Name of material (steel pipe piles),

4.1.3 Method of manufacture (seamless or welded),

4.1.4 Grade (Tables 1 and 2),

4.1.5 Size (outside diameter and nominal wall thickness),

4.1.6 Lengths (single random, double random, or uniform) (see Section 13),

4.1.7 End finish (Section 15), and

4.1.8 ASTM specification designation and year of issue,

4.1.9 Location of purchaser's inspection (see 19.1), and

4.1.10 Bar coding (see 22.2).

5. Materials and Manufacture

5.1 The piles shall be made by the seamless, electric resistance welded, flash welded, or fusion welded process. The seams of welded pipe piles shall be longitudinal, helical-butt, or helical-lap.

NOTE 1—For welded pipe piles, the weld should not fail when the product is properly fabricated and installed and subjected to its intended end use.

6. Process

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

7. Chemical Composition

7.1 The steel shall contain no more than 0.050 % phosphorus.