



Standard Specification for Welded and Seamless Carbon Steel and Austenitic Stainless Steel Pipe Nipples¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers the requirements for welded and seamless carbon steel pipe nipples, black and zinc-coated (hot-dip galvanized), and welded and seamless austenitic stainless steel pipe nipples in standard steel pipe sizes from ½ to 12 in. inclusive, in standard or special lengths.

1.1.1 *Welded Carbon Steel*—Pipe nipples ordered under these requirements are intended for general uses, as described by Specification A 53.

1.1.2 *Seamless Carbon Steel*—Pipe nipples ordered under these requirements are intended for general and special uses, as described by the applicable Specifications A 53 and A 106 (see 4.1.1).

1.1.3 *Austenitic Stainless Steel*—Pipe nipples ordered under these requirements are intended for high-temperature and general corrosion service, as described by Specification A 312 (see 4.1.2).

2. Referenced Documents

2.1 ASTM Standards:

A 53 Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless²

A 106 Specification for Seamless Carbon Steel Pipe for High-Temperature Service²

A 312 Specification for Seamless and Welded Austenitic Stainless Steel Pipes²

2.2 American National Standards Institute Standards:³

B 1.20.1 Pipe Threads, General Purpose

B 36.10 Standard for Welded and Seamless Wrought Steel Pipe

B 36.19 Standard for Stainless Steel Pipe

3. Ordering Information

3.1 Orders for material under this specification should

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² Annual Book of ASTM Standards, Vol 01.01.

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

include the following, as required to describe the desired material adequately.

3.1.1 Quantity (pieces),

3.1.2 Name of material (carbon steel or austenitic stainless steel pipe nipples) (see 4.1.1 and 4.1.2),

3.1.3 Method of pipe manufacture (butt-welded, electric-resistance welded, or seamless). If carbon steel-welded furnished, unless otherwise specified (see 4.1.1, Note 1).

3.1.4 Type and grade (if stainless steel),

3.1.5 Finish (carbon steel, black or galvanized),

3.1.6 Size (nominal and weight class or schedule number as shown in Table 1, or outside diameter and nominal wall),

3.1.7 Length (standard or special, see 4.3),

3.1.8 Specification number,

3.1.9 Certification of compliance, if required, and

3.1.10 Special requirements or exceptions to this specification.

3.2 In addition, when material is purchased for agencies of the U.S. Government, it shall conform to the Supplementary Requirements as defined herein when specified in the contract or purchase order.

4. Requirements

4.1 *Material and Weight*—Pipe nipples covered by this specification shall be made from new, pressure-tested pipe conforming to the requirements specified in 4.1.1 and 4.1.2.

4.1.1 *Carbon Steel*—Carbon steel pipe nipples shall be in accordance with the following:

Method of Pipe Manufacture	Specification
Welded (Note 1)	A 53
Seamless (Note 2)	A 53
	A 106

NOTE 1—Unless otherwise specified, furnace butt-welded nipples shall be furnished in sizes 4 in. and under for standard and extra strong pipe, and 2½ in. and under for schedule 160 and XXS pipe. Welded nipples in sizes larger than that indicated for butt welded shall be electric welded.

NOTE 2—Material used for a given size may vary with the nipple manufacturer.

4.1.2 *Austenitic Stainless Steel*—Austenitic stainless steel pipe nipples shall be in accordance with Specification A 312.

4.2 *Threads*—Pipe nipples shall be threaded on both ends with NPT taper pipe threads conforming to the requirements of