



Standard Specification for Threaded Couplings, Steel, Black or Zinc-Coated (Galvanized) Welded or Seamless, for Use in Steel Pipe Joints¹

This standard is issued under the fixed designation A 865; 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 black or galvanized welded or seamless threaded steel couplings for use with steel pipe in NPS ½ to NPS 20 inclusive (Note 1). Couplings ordered under this specification are intended for the uses outlined in the pipe specifications referencing this specification.

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.

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

2. Referenced Documents

2.1 ASTM Standards:

A 90 Test Method for Weight (Mass) of Coatings on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings²

A 700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment³

B 6 Specification for Zinc⁴

2.2 ANSI Standard:

B 1.20.1 Pipe Threads⁵

2.3 API Standards:

5B Specification for Threading, Gaging, and Thread Inspection of Casing, Tubing, and Line Pipe Threads⁶

5L Specification for Line 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 Specification number,

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.

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² *Annual Book of ASTM Standards*, Vol 01.06.

³ *Annual Book of ASTM Standards*, Vol 01.05.

⁴ *Annual Book of ASTM Standards*, Vol 02.04.

⁵ Available from American National Standards Institute, 11 West 42nd St., 13th Floor, New York, NY 10036.

⁶ Available from American Petroleum Institute, 2101 L Street, N.W., Washington, DC 20037.

- 3.1.2 Quantity (pieces),
- 3.1.3 Name of material (steel pipe-couplings),
- 3.1.4 Method of manufacture (welded or seamless),
- 3.1.5 Finish (black or Type I or Type II) galvanized (see 8.1),
- 3.1.6 Size (NPS designator),
- 3.1.7 Standard or extra-strong classification,
- 3.1.8 Taper tapped-couplings for NPS 2 and smaller, either recessed or non-recessed, if desired, and
- 3.1.9 Certification (see 11.3), if required.

4. Process

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

4.2 Welded couplings NPS 3½ and under may be butt-welded, unless otherwise specified. Welded couplings over NPS 3½ shall be electric-welded.

5. Chemical Composition

5.1 The steel shall conform to the chemical composition requirements as specified in Table 1.

6. Dimensions

6.1 Coupling dimensions are listed in Tables 2-4 and (see Figs. 1-3).

7. Permissible Variations in Dimensions

7.1 *Diameter*—For couplings NPS 1½ and under, the outside diameter at any point shall not vary more than ¼ in. (0.4 mm) over nor more than ⅓ in. (0.8 mm) under the standard specified. For couplings NPS 2 and over, the outside diameter shall not vary more than ±1 % from the standard specified.

7.2 *Threads*—The variation of the threads shall not exceed ±1½ turns for straight tapped and ±1 turn for taper tapped from nominal as determined using gages and the gaging practices in ANSI B 1.20.1.

8. Galvanized Couplings

8.1 Galvanized couplings may be coated with zinc by either the hot-dipped (Type 1) or by the electrogalvanizing process.