



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

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1. Scope*

1.1 This specification covers black or galvanized welded or seamless threaded steel couplings for use with steel pipe in NPS $\frac{1}{8}$ to NPS 20 [DN 6 to DN 500] 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) and DN [diameter nominal] has been substituted in this standard for such traditional terms as nominal diameter, size, and nominal size.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

2. Referenced Documents

2.1 ASTM Standards:²

A700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Shipment (Withdrawn 2014)³

B6 Specification for Zinc

E376 Practice for Measuring Coating Thickness by Magnetic-Field or Eddy-Current (Electromagnetic) Testing Methods

2.2 ANSI Standard:

B 1.20.1 Pipe Threads⁴

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.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

2.3 API Standards:

5B Specification for Threading, Gaging, and Thread Inspection of Casing, Tubing, and Line Pipe Threads⁵

5L Specification for Line Pipe⁵

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,

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 [DN]),

3.1.7 Standard or extra-strong classification,

3.1.8 Taper tapped-couplings for NPS 2 [DN 50] 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 3 $\frac{1}{2}$ [DN 90] and under may be butt-welded, unless otherwise specified. Welded couplings over NPS 3 $\frac{1}{2}$ [DN 90] 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 **Figs. 1-3**.

⁵ Available from American Petroleum Institute (API), 1220 L. St., NW, Washington, DC 20005.

*A Summary of Changes section appears at the end of this standard