



Designation: A1006/A1006M – 00(Reapproved 2010)

Standard Specification for Steel Line Pipe, Black, Plain End, Laser Beam Welded¹

This standard is issued under the fixed designation A1006/A1006M; 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 laser beam welded, black, plain end steel pipe for use in the conveyance of fluids under pressure. Pipe in sizes NPS 1 to 26, inclusive, with nominal wall thickness 0.750 in. [19.1 mm] or less, as given in [Table 1](#), is included. Pipe having other dimensions, in this size range, may be furnished provided such pipe complies with all other requirements of this specification.

1.2 It is intended that the pipe be capable of being circumferentially welded in the field when welding procedures in accordance with the requirements of the applicable pipeline construction code are used.

1.3 The values stated in either inch-pound units or in SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values in each system are not exact equivalents: therefore, each system is to be used independently of the other, without combining values in any way.

1.4 The following precautionary statement pertains to the test method portion, [Section 14](#), of this specification. *This standard does not purport to address all of the safety concerns, 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:²

- [A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)
- [A450/A450M Specification for General Requirements for Carbon and Low Alloy Steel Tubes](#)
- [A530/A530M Specification for General Requirements for](#)

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.

Specialized Carbon and Alloy Steel Pipe

[A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products](#)

[A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys](#)

2.2 API Publication:

[API RP 5L3 Recommended Practice for Conducting Drop-Weight Tear Tests on Line Pipe](#)³

2.3 ASME Standard:

[ASME Boiler and Pressure Vessel Code, Section IX, Welding and Brazing Qualifications](#)⁴

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *laser beam welding, n*—a welding process that utilizes a laser beam to produce melting of full thickness of edges to be welded, followed by the fusion of those edges.

3.1.2 *specified outside diameter, n*—the outside diameter shown in the purchase order or in [Table 1](#) for the applicable NPS size.

3.2 *Definitions*—For definitions of other terms used in this specification, refer to Terminology [A941](#).

4. Ordering Information

4.1 Information items to be considered, if appropriate, for inclusion in the purchase order are as follows:

- 4.1.1 Specification designation and year of issue,
- 4.1.2 Quantity (feet or metres),
- 4.1.3 Grades (see [Table 2](#) or [8.6](#)),
- 4.1.4 Size, either nominal (NPS) or outside diameter and wall thickness,
- 4.1.5 Nominal length (see [16.3](#)),
- 4.1.6 End finish (plain end beveled or special, see [17.1](#)),
- 4.1.7 Bar coding (see [20.3](#)),
- 4.1.8 Special requirements, and
- 4.1.9 Supplementary requirements.

³ Available from American Petroleum Institute (API), 1220 L. St., NW, Washington, DC 20005-4070, <http://www.api.org>.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.