



Standard Specification for Steel Line Pipe, Black, Furnace-Butt-Welded¹

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1. Scope

1.1 This specification covers furnace-butt-welded, black, plain-end or threaded-end, steel pipe for use in the conveyance of fluids under pressure. Pipe in sizes NPS $\frac{1}{2}$ to 4, inclusive, with nominal wall thickness 0.350 in. [8.9 mm] or less, as given in ASME B36.10M 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 For plain-end pipe, 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.

2. Referenced Documents

2.1 ASTM Standards:²

A450/A450M Specification for General Requirements for Carbon and Low Alloy Steel Tubes

A530/A530M Specification for General Requirements for 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 ASME Standard:

ASME B36.10M Welded and Seamless Wrought Steel Pipe³

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 Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990.

2.3 API Standards:

5L Specification for Line Pipe⁴

5B Specification for Threading, Gauging, and Thread Inspection of Casing, Tubing, and Line Pipe Threads⁴

3. Terminology

3.1 *Definitions*—For terminology used in this specification, refer to Terminology A941.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *furnace-butt-welded pipe, n*—pipe produced in multiple lengths from coiled skelp and subsequently cut into individual lengths, having its longitudinal butt joint forge welded by the mechanical pressure developed in rolling the hot-formed skelp through a set of round pass welding rolls.

3.2.2 *lot, n*—a quantity of pipe of the same ordered diameter, heat, wall thickness, and grade as given in Table 1.

3.2.3 *specified outside diameter (OD), n*—the outside diameter specified in the purchase order or the outside diameter listed in ASME B36.10M for the nominal pipe size specified in the purchase order.

4. General Requirements

4.1 Pipe furnished under this specification shall conform to the applicable requirements of Specification A530/A530M unless otherwise provided herein.

5. Ordering Information

5.1 It is the purchaser's responsibility to specify in the purchase order all information necessary to purchase the needed material. Examples of such information include, but are not limited to, the following:

5.1.1 Specification designation and year-date,

5.1.2 Quantity (feet or metres),

5.1.3 Grade (A or B),

5.1.4 Size (either nominal (NPS) or outside diameter, and wall thickness),

5.1.5 Length,

5.1.6 End finish (plain-end, special plain-end, or threaded-end, see 15.1),

5.1.7 End use of the pipe,

⁴ Available from The American Petroleum Institute (API), 1220 L. St., NW, Washington, DC 20005.