



Designation: A865/A865M – 06 (Reapproved 2017)

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 A865/A865M; 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 $\frac{1}{8}$ 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.

1.3 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

A700 Guide for Packaging, Marking, and Loading Methods for Steel Products for Shipment

B6 Specification for Zinc

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

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.

2.2 ANSI Standard:

B 1.20.1 Pipe Threads³

2.3 API Standards:

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

5L Specification for Line Pipe⁴

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**.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

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