



Designation: A 950/A 950M – 99

Standard Specification for Fusion-Bonded Epoxy-Coated Structural Steel H-Piles and Sheet Piling¹

This standard is issued under the fixed designation A 950/A 950M; 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 structural steel H-piles and sheet piling with protective fusion-bonded epoxy coating applied by the electrostatic spray, flocking, or fluidized bed process.

NOTE 1—The coating applicator is identified throughout this specification as the manufacturer.

1.2 Requirements for coatings are contained in Annex A1.

1.3 This specification is applicable for orders in either inch-pound units (as Specification A 950) or SI units (as Specification A 950M). The values stated in either inch-pound or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets.

1.4 *This standard does not purport to address any 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:

A 6/A6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling²

A 36/A36M Specification for Carbon Structural Steel²

A 328/A328M Specification for Steel Sheet Piling²

A 572/A572M Specification for High-Strength Low-Alloy Columbium-Vanadium Structural Steel²

A 588/A588M Specification for High-Strength Low-Alloy Structural Steel with 50 ksi [345 MPa] Minimum Yield Point to 4 in. [100 mm] Thick²

A 690/A690M Specification for High-Strength Low-Alloy Steel H-Piles and Sheet Piling for Use in Marine Environments²

A 857 Specification for Steel Sheet Piling, Cold-Formed, Light Gage²

B 117 Practice for Operating Salt Spray (Fog) Apparatus³

D 2200 Pictorial Surface Preparation Standards for Painting Steel Surfaces⁴

D 3451 Practices for Testing Polymeric Powders and Powder Coatings⁴

G 8 Test Methods for Cathodic Disbonding of Pipeline Coatings⁴

G 12 Test Method for Nondestructive Measurement of Film Thickness of Pipeline Coatings on Steel⁴

G 14 Test Method for Impact Resistance of Pipeline Coatings (Falling Weight Test)⁴

G 20 Test Method for Chemical Resistance of Pipeline Coatings⁴

2.2 American Petroleum Institute Specification:

API RP 5L7 Recommended Practice for Internal Fusion Bonded Epoxy Coating of Line Pipe⁵

2.3 **National Association of Corrosion Engineers Standard:**
TM0175 Visual Standard for Surfaces of New Steel Centrifugally Blast Cleaned with Steel Shot or Steel Grit (Nace No. 2)⁶

2.4 Steel Structures Painting Council Standards:

SSPC VIS 1 Visual Standards⁷

SSPC-SP 1 Surface Preparation Specification No. 1: Solvent Cleaning⁷

SSPC-SP 10 Near-White Blast Cleaning⁷

3. Ordering Information

3.1 Information items to be considered, if appropriate, for inclusion in purchase orders are as follows:

3.1.1 Specification designation and year of issue for H-pile or sheet piling,

3.1.2 Section,

³ *Annual Book of ASTM Standards*, Vol 03.02.

⁴ *Annual Book of ASTM Standards*, Vol 06.02.

⁵ Available from the American Petroleum Institute, 1220 L St., Washington, DC 20005.

⁶ Available from the National Institute of Corrosion Engineers, 1440 South Creek, Houston, TX 77084.

⁷ Available from the Steel Structures Painting Council, 4400 5th Ave., Pittsburgh, PA 15213.

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is under the direct responsibility of Subcommittee A01.02 on Structural Steel for Bridges, Buildings, Rolling Stock, and Ships.

Current edition approved Sept. 10, 1999. Published November 1999. Originally published as A 950/A 950–95. Last previous edition A 950/A 950M-98.

² *Annual Book of ASTM Standards*, Vol 01.04.