

FOREWORD

(This Foreword is not part of ANSI/ASME B36.19M-1985)

This Standard for corrosion resistant piping, designated categorically as *stainless*, is based on the same principles that formed the background for the development of ANSI/ASME B36.10M, Welded and Seamless Wrought Steel Pipe, and reference is made to this source of information.

The wall thicknesses shown for Schedules 40S and 80S are identical with those of Schedules 40 and 80 in ANSI/ASME B36.10M except in the 12 in. size in Schedule 40S and the 10 in. and 12 in. sizes in Schedule 80S. The thickness for these three sizes corresponds to wall thicknesses of Standard wall and Extra-Strong wall.

The more recent development of the highly alloyed stainless steels has brought about a minor conflict with convention. With these newer materials, the need for standards is just as great and the present types of threads are just as satisfactory, but the basic cost of the metal is much higher and the art of fusion welding has developed concurrently. The character of stainless steel permits the design of thin-wall piping systems without fear of early failure due to corrosion, and the use of fusion welding to join such piping has eliminated the necessity of threading it. For these reasons, the wall thickness dimensions shown under Schedule 10S have been developed, based on the conventional formula, but then modified to correspond to the nearest Birmingham Wire Gage (B.W.G.) number.

Following publication of the 1949 edition there developed a demand for a still lighter wall pipe. A Schedule 5S was determined cooperatively by representatives of chemical companies, processing industries, and manufacturers of welding fittings. This was endorsed by the ASA Chemical Industry Correlating Committee and the Manufacturers Standardization Society of the Valve and Fittings Industry. The new schedule was included in the revised standard which was approved by ASA (now ANSI) on April 7, 1952.

In 1956 it was recommended that the wall thickness of 12 in. 5S be lessened, and a new revision of the standard was issued shortly after its approval by ASA (now ANSI) on February 27, 1957. In this fourth edition, dimensions were expanded beyond 12 in. pipe size by inclusion of, and reference to, ASTM Specification A 409. This revision was approved by ASA (now ANSI) on October 29, 1965.

The B36 Standards Committee membership was asked in March 1970 for recommendations as to what action should be taken on ANSI B36.19-1965 since, according to ANSI procedures, this standard was due for revision or reaffirmation. The B36 Standards Committee recommended reaffirmation. This action was approved by the Secretariat and by the American National Standards Institute on May 26, 1971.

In 1975 the B36 Standards Committee undertook a review of the standard, considering its acceptability and usefulness. The results were favorable; some editorial refinements and updating were proposed along with the incorporation of factors for conversion to SI (metric) units. The revision was approved by the Standards Committee, the Secretariat, and subsequently the American National Standards Institute on October 4, 1976.

This standard was revised in 1984 to include SI metric dimensions. The outside diameter and wall thicknesses were converted to millimeters by multiplying the inch dimensions by 25.4. Outside diameters larger than 16 in. were rounded to the nearest 1 mm, and outside