



Pipe Specification A135

Specification	A135 NPS 1/4 -- 30", Schedules 10, 40 and XL THD, Lightwall				
Scope	Covers two grades of electric resistance welded steel pipe. Grade A is adapted for flanging and bending and is suitable for welding. Purpose for which pipe is intended should be stated on order.				
Kinds of Steel Permitted For Pipe Material	Open-hearth Basic-oxygen Electric-furnace				
Permissible Variations in Wall Thickness	The minimum wall thickness at any point shall not be more than 12.5% under the nominal wall thickness specified. Threadable, lightwall (XL) must meet manufacturers minimums.				
Chemical Requirements	<div> <div></div> <div>C max %</div> <div>Mn max %</div> <div>P max %</div> <div>S max %</div> </div> Seamless or ERW Grade A 0.25 0.95 0.05 0.06 Grade B 0.30 1.20 0.05 0.06				
Tensile Requirements	<div> <div></div> <div>Grade A</div> <div>Grade B</div> </div> Tensile Strength, min., psi 48,000 60,000 Yield Strength, min., psi 30,000 35,000				
NDE & Hydrostatic Testing	Hydrostatic inspection test pressures for plain end and threaded are specified. Hydrostatic pressure shall be maintained for not less than 5 seconds for all sizes of electric resistance weld pipe. Non-destructive electric test should be in accordance with practices E213, method E227 or practice E213.				
Permissible Variations in Weights per Foot	Plus or Minus 10% schedule 10 Plus 10% minus 3 1/2% schedule 40				
Permissible Variations in Outside Diameter	Plus or minus 1%				
Mechanical Tests Specified	Tensile Test -- Transverse returned on pipe NPS 8 and larger. Flattening test -- Three steps required with weld located 0° or 90° from the line of direction of force required.				
Number of Tests Required	Flattening and tensile on one length of pipe from each lot of 400 lengths or less of a style.				
Lengths	Pipe shall be furnished in 38' with a minimum of 20 ft. Pipe furnished to schedule 10 shall be in a specified length between 16 and 22 ft.				
Required Markings on Each Length (On Tags attached to each Bundle in case of Bundled Pipe)	Rolloed, Stamped or Stenciled (Mfrs. Option) Name or brand of manufacturer. Kind of pipe, that is, electric-resistance welded A, electric welded B, same schedule wall thickness, schedule 10 or 40, NL ASTM A135 Length of pipe.				
General Information	End finish may be plain end beveled or plain end square cut.				