

**ASTM A795 GR-A SCHEDULE- 10 FOR
BLACK AND HOT DIPPED GALVANIZED STEEL PIPES**

SIZE		OD (Minimum)		OD (Maximum)		WALL THICKNESS		Weight of Tube (Plain End)		PRESSURE GR-A	Pieces Per bundle
INCH	NB (mm)	INCH	MM	INCH	MM	INCH	MM	lb./Ft.	kg./Mtr.	PSI	
3/4"	20	1.035	26.30	1.070	27.10	0.083	2.11	0.860	1.28	700	120
1"	25	1.300	33.00	1.330	33.80	0.109	2.77	1.410	2.09	700	84
1 1/4"	32	1.645	41.80	1.680	42.60	0.109	2.77	1.810	2.69	1000	61
1 1/2"	40	1.885	47.90	1.920	48.70	0.109	2.77	2.090	3.11	1000	42
2"	50	2.350	59.70	2.400	60.90	0.109	2.77	2.640	3.93	1000	37
2 1/2"	65	2.850	72.30	2.900	73.70	0.120	3.05	3.530	5.26	1000	29
3"	80	3.460	88.00	3.530	89.80	0.120	3.05	4.340	6.46	1000	19
3 1/2"	90	3.960	100.60	4.040	102.60	0.120	3.05	4.980	7.41	1200	19
4"	100	4.450	113.20	4.540	115.40	0.120	3.05	5.620	8.37	1200	14
5"	125	5.507	139.90	5.620	142.70	0.134	3.40	7.780	11.58	1200	7
6"	150	6.560	166.60	6.690	169.98	0.134	3.40	9.300	13.85	1000	7

1) Tolerance:-

- a) **On Thickness:-** The minimum wall thickness at any point shall be not more than 12.5% under the specified wall thickness.
- b) **On Diameter:-** For NPS 1 1/2" & under any point shall not vary more than +0.4 mm -0.8 mm. For NPS 2" & above shall not vary more than $\pm 1\%$ from the standard specified.
- c) **On Weight:-** The weight of the pipe shall not more than $\pm 5\%$ of the specified Weight.

2) Ends:- Each end of pipe shall be furnish plain end unless otherwise specified.

3) Internal Debeading : 2" and above - Internal beads to be removed completely.

4) Chemical Composition : GR.A % MAX -C - 0.25%, Mn - 0.95%, S - 0.035%, P - 0.035%

5) Mechanical (Min.) : GR.A Yield Strength-205 N/mm², Tensile Strength-330 N/mm², Elongation-25-30%

6. Flattenig Test :- Weld located 0/90 degree from line of direction of force.
 Stage-1 :For weld ductility until 2/3 of outside dia of specimen tube.
 Stage-2 :For ductility of steel until 1/3 of outside dia of specimen tube.
 Stage-3 :Full flattening for testing of laminated and unsound material

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7) LEAK TIGHTNESS TEST:-

a) :On line NDT(Eddy Current)

b) :Hydro testing at pressure as per above Table and holding time Min. 5
second

8) BLACK VARNISH :-

:Tubes are uniformly varnished externally over their full length.

9). ZINC COATING:-

:The Average 460 Gm/mm² but one side should not be less than 400Gm/mm² Or S
specified by custome
:Free from bare Spot,Black spot,rough,overcoating, Peel off or anyother
surface defect..

10). THREADING:-:

: For 1/2" & 3/4" - 14 TPI, 1" to 2" - 11.5 TPI and 2 1/2" to 6" - 8TPI.
:Check with standard ASTM ring and plug gauges.

11).MARKING:-

: We can do on line stenciling as per this stanadrd & as per customer needs at
one meter interval

12).PACKING:-

:Hexagonal Type

**13) MILL TEST
CERTIFICATE**

:We can issue a MTC, certifying that the tubes supplied comply with this ASTM A
795 Standard