

# ASTM A53 Type E Grade B

With a more than 40 year history of making square, rectangular and round ASTM A500 products, Nucor Tubular Products (NTP) is now manufacturing ASTM A53 Grade B Type E pipe to the same commitment to quality that has made us one of the industry leaders in North America.

Manufactured in our Trinity, Alabama Division, NTP's A53 pipe is produced in 21' and 42' lengths and inventory can be viewed and orders placed and shipped on our on-line, Customer Secure Portal.

ASTM A53 covers welded black and hot-dipped galvanized electric resistance welded steel pipe, with a nominal wall thickness as shown. Application of ASTM A53 Standard Pipes acceptable for ordinary uses in steam, water, gas and air lines. It is suitable for welding and for forming operations such as coiling, bending and flanging.

**LENGTHS:** 21' to 42'

**HYDROSTATIC TESTING AND SEAM ANNEALING:**

Performed in-line per ASTM A53.

**COATINGS:** Outside surface can be bare or coated black.

**ENDS:** Beveled to angle of 30 degrees, +5 degrees, -0 degrees with a root face of 1/16" (+/-1/32")

**STANDARDS:** UL, C-UL and FM Listed FM Approved

Tensile Requirements	Grade B
Tensile, min. psi	60,000
Yield, min. psi	35,000
Elongation % in 2"	See footnotes of Table 2 in ASTM A53/A53M

Nucor Tubular Products manufactures ASTM A53 Type E Grade B in our 290,000 square foot Trinity, Alabama Division. Located just 7 miles from our Decatur, Alabama Division, Trinity is strategically located to ship via truck, rail or barge. Call your Account Representative for details.

## Composition, Max %

	Carbon	Manganese	Phosphorus	Sulfur	Copper	Nickel	Chromium	Molybdenum	Vanadium
Grade B	0.30	1.20	0.05	0.45	0.40	0.40	0.40	0.15	0.08

## Standard Pipe—Schedule 40

Nominal Size	Actual OD	Nominal Wall Thickness	Wt./Ft.	Test Pressure
2"	2.375"	0.154	3.650	2500
2-1/2"	2.875"	0.203	5.790	2500
3"	3.500"	0.216	7.580	2500
3-1/2"	4.000"	0.226	9.109	2400
4"	4.500"	0.237	10.790	2200
6"	6.625"	0.280	18.990	1800
8"	8.625"	0.322	28.580	1570

## Extra Heavy Pipe—Schedule 80

Nominal Size	Actual OD	Nominal Wall Thickness	Wt./Ft.	Test Pressure
2"	2.375"	0.218	5.020	2500
2-1/2"	2.875"	0.276	7.660	2500
3"	3.500"	0.300	10.250	2500
3-1/2"	4.000"	0.318	12.510	2800
4"	4.500"	0.337	14.980	2800



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## Hydrostatic and Non-Destructive Electric Testing

Hydrostatic inspection test pressures for plain-end pipe are listed in Table X 2.2 of the A53/A 53M—12 specification. Test pressures shall be maintained for a minimum of five seconds.

Non-destructive electric testing of the weld seam is required on each length of ERW pipe NPS 2 and larger.

## Product Marking

Each length of pipe is continuously stenciled to show the manufacturer, the grade of pipe (ASTM A 53), the kind of pipe E for Electric Resistance Welded, B for Grade B, the size, XS for extra strong, and length.

### Permissible Variations in Wall Thickness

Minimum wall thickness at any point shall not be more than 12.5% under nominal wall thickness specified and conforms to Table X2.4

### Permissible Variations in Outside Diameter

NPS 1-1/2" and under +/- .016

NPS 2" and over +/- 1%

### Permissible Variations in Weight per Foot

Pipe shall not vary more than  $\pm 10\%$  from the standard specified.

