



PIPE MANUFACTURER'S SPECIFICATIONS

Specification	A252 Piling Pipe
Scope	Covers nominal (average) wall steel pipe piles of cylindrical shape and applies to pipe piles in which the steel cylinder acts as a permanent load-carrying member or as a shell to form cast-in-place concrete piles.
Kinds of Steel Permitted For Pipe Material	Open-hearth Basic-oxygen Electric-furnace
Permissible Variations in Wall Thickness	Not more than 12.5% under the nominal wall thickness specified.
Chemical Requirements	Seamless and Welded Pipe: Open-hearth, Electric-furnace or Basic-oxygen
Hydrostatic Testing	None specified.
Permissible Variations in Weights per Foot	The weight of any length of pile shall not vary more than 15% over or 5% under the weight specified. Each length shall be weighed separately.
Permissible Variations in Outside Diameter	Shall not vary more than plus or minus 1% from the diameter specified.
Mechanical Tests Specified	Tensile Test -- Either longitudinal or transverse at option of manufacturer. Minimum yield determined by the drop of the beam, by the halt in the gage of the testing machine, or by the use of dividers.
Number of Tests Required	One tensile property test per 200 lengths.
Lengths	May be ordered in single or double random lengths or in uniform lengths: Single Random -16'-25' md. Double Random - Over 25' (mm. avg. of 35'). Uniform - Plus or minus 1 on length specified.
Required Markings on Each Length (On Tags attached to each Bundle in case of Bundled Pipe)	Rolled, Die Stamped or Paint Stencilled (Mfgs. option) Manufacturer's name, brand or trademark, heat number, method of pipe manufacture, size, weight, length, wall thickness and ASTM A252 and the Grade.
General Information	Surface imperfections exceeding 25% of the nominal wall in depth are considered defects. Welding may repair defects not exceeding 33.5% of the nominal wall in depth. Before welding, the defect shall be completely removed.

NOTE: This is summarized information from ASTM Standards and API Specification 5L. Please refer to the specific Standard or Specification for more details.