

be deleted from this section of the project
specification when you choose to reconcile
references in the publish print process.

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

ASME INTERNATIONAL (ASME)

ASME B16.11	(2002) Forged Steel Fittings, Socket-Welding and Threaded
ASME B16.3	(1998) Malleable Iron Threaded Fittings Classes 150 and 300
ASME B16.39	(1998) Malleable Iron Threaded Pipe Unions Classes 150, 250, and 300
ASME B16.5	(2003) Pipe Flanges and Flanged Fittings NPS 1/2 Through NPS 24
ASME B16.9	(2003) Factory-Made Wrought Steel Buttwelding Fittings
ASME B18.2.2	(1987; R 1999) Square and Hex Nuts
ASME B18.2.4.6M	(1979; R 1998) Metric Heavy Hex Nuts
ASME B36.10M	(2004) Welded and Seamless Wrought Steel Pipe

ASTM INTERNATIONAL (ASTM)

ASTM A 105/A 105M	(2003) Standard Specification for Carbon Steel Forgings for Piping Applications
ASTM A 106	(2002a) Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service
ASTM A 181/A 181M	(2001) Standard Specification for Forgings, Carbon Steel, for General-Purpose Piping
ASTM A 193/A 193M	(2005) Standard Specification for Alloy-Steel and Stainless Steel Bolting Materials for High-Temperature Service
ASTM A 194/A 194M	(2004a) Standard Specification for Carbon and Alloy Steel Nuts for Bolts for High-Pressure or High-Temperature Service or Both
ASTM A 197/A 197M	(2000) Standard Specification for Cupola Malleable Iron
ASTM A 234/A 234M	(2003) Standard Specification for Piping

Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and High Temperatures

ASTM A 325	(2004b) Standard Specification for Structural Bolts, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength
ASTM A 325M	(2004b) Standard Specification for Structural Steel Bolts, Steel, Heat Treated 830 Mpa Minimum Tensile Strength (Metric)
ASTM A 53/A 53M	(2004a) Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless
ASTM F 104	(2003) Standard Classification System for Nonmetallic Gasket Materials

1.2 SUBMITTALS

NOTE: Review Submittal Description (SD) definitions in Section 01330 SUBMITTAL PROCEDURES and edit the following list to reflect only the submittals required for the project. Submittals should be kept to the minimum required for adequate quality control.

A "G" following a submittal item indicates that the submittal requires Government approval. Some submittals are already marked with a "G". Only delete an existing "G" if the submittal item is not complex and can be reviewed through the Contractor's Quality Control system. Only add a "G" if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy, Air Force, and NASA projects.

Choose the first bracketed item for Navy, Air Force and NASA projects, or choose the second bracketed item for Army projects.

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control approval.][for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for

the Government.] Submit the following in accordance with Section 01330
SUBMITTAL PROCEDURES:

SD-02 Shop Drawings

Installation Drawings for steel piping shall be submitted in accordance with paragraph entitled, "General Requirements," of this section.

SD-07 Certificates

Certificates shall be submitted for the following items showing conformance with the referenced standards contained in this section.

Piping for Steam and Condensate
Piping for High-Pressure Compressed-Air Systems
Fittings
Unions
Flanges
Gaskets
Bolting

1.3 GENERAL REQUIREMENTS

NOTE: If Section 15003S GENERAL MECHANICAL PROVISIONS is not included in the project specification, applicable requirements therefrom should be inserted and the following paragraph deleted.

Section 15003S GENERAL MECHANICAL PROVISIONS applies to work specified in this section.

Installation Drawings for steel piping shall be in accordance with the manufacturer's recommendations and in accordance with Section 15050S BASIC MECHANICAL MATERIALS AND METHODS.

PART 2 PRODUCTS

NOTE: For accessories and supporting elements see Section 15050S BASIC MECHANICAL MATERIALS AND METHODS.

2.1 PIPING FOR STEAM AND CONDENSATE

Steam and condensate piping for 1034-, 2413-, 13790-, 41369- kilopascal 150-, 350-, 2,000-, and 6,000-pound per square inch (psi) service shall be black carbon steel (BCS).

2.1.1 Type BCS-150 (1034 kilopascal 150-psi Service)

NOTE: Avoid screwed-end connections in condensate piping wherever possible. Bend pipe for change in

direction where practicable.

Pipe or tube (DN6 through DN25): (1/8 inch through 10 inches): Schedule 40 for steam, Schedule 80 for condensate, seamless black carbon steel, conforming to ASTM A 106, Grade B and ASME B36.10M

NOTE: Select 150- or 300-psi 1034 or 2068 kilopascal malleable-iron or forged-steel fittings; delete fittings not applicable if option is not given.

Fittings (DN6 through DN50): 2068 kilopascal (1/8 inch through 2 inches): 300-psi working steam pressure (wsp) banded malleable iron, screwed end, conforming to ASTM A 197/A 197M and ASME B16.3

Fittings (DN6 through DN50): 15- or 20- megapascal (1/8 inch through 2 inches): 2,000-or 3,000-psi water, oil, or gas (wog) forged carbon steel, socket weld or screwed end, conforming to ASTM A 105/A 105M and ASME B16.11

Fittings (DN65 through DN250): (2-1/2 through 10 inches): Wall thickness to match pipe, long radius, butt weld, black carbon steel, conforming to ASTM A 234/A 234M, Grade WPB, and ASME B16.9

NOTE: Select 250-psi 1724 kilopascal malleable iron or forged steel unions.

Unions (DN6 through DN50): 1724 kilopascal (1/8 inch through 2 inches): 250-psi wsp, malleable iron, screwed end, ground joint, with brass or bronze seat insert, conforming to ASME B16.39

Unions (DN6 through DN50): 15- or 20- megapascal (1/8 inch through 2 inches): 2,000 or 3,000-psi wog, forged carbon steel; socket weld through 50 millimeter 2-inch, screwed end through 25 millimeter 1-inch, conforming to ASTM A 105/A 105M and ASME B16.11, with ground joint and stainless-steel seat insert

Flanges (DN65 through DN250): 1034-kilopascal (2-1/2 through 10 inches): 150-pound, forged carbon steel, welding neck, with raised face or flat face and concentric finish, conforming to ASTM A 105/A 105M and ASME B16.5

Flange Gaskets: Compressed non-asbestos sheet conforming to ASTM F 104, Type 1, P1161A, coated on both sides with graphite or similar lubricant, containing not less than 75-percent non-asbestos fiber materials

Bolting: Bolting and flange bolting shall be hexhead and shall conform to ASTM A 325M ASTM A 325. Heavy hex-nuts shall conform to ASME B18.2.4.6M ASME B18.2.2.. Square-head bolts and nuts are not acceptable.

2.1.2 Type BCS-350 (2413 kilopascal 350-psi Service)

NOTE: Avoid screwed-end connections in condensate piping wherever possible. Bend pipe for change in direction, where practicable.

Pipe or tube(DN6 through DN25): (1/8 inch through 10 inches): Schedule 40 for steam, Schedule 80 for condensate; seamless black carbon steel, conforming to ASTM A 106, Grade B and ASME B36.10M

Fittings(DN6 through DN50): 15- or 20- megapascal (1/8 inch through 2 inches): 2,000-or 3,000-psi wog to match pipe wall, forged carbon steel, socket weld or screwed end, conforming to ASTM A 105/A 105M and ASME B16.11

Fittings(DN6 through DN25): (1/8 inch through 10 inches): Schedule 40, long-radius, butt weld, black carbon steel, conforming to ASTM A 234/A 234M, Grade WPB, and ASME B16.9

Unions(DN6 through DN50): 15- or 20- megapascal (1/8 inch through 2 inches): 2,000-or 3,000-psi wog to match pipe wall, forged carbon steel, socket weld through 50 millimeter 2-inch, screwed end through 25 millimeter 1-inch, conforming to ASTM A 105/A 105M and ASME B16.11, with ground joint and stainless-steel seat insert

Flanges (DN65 through DN250): 2068 kilopascal (2-1/2 through 10 inches): 300-pound, forged carbon steel, weld neck, with raised face and concentric serrated finish, conforming to ASTM A 181/A 181M, Class 70, and ASME B16.5

Gaskets: Spiral-wound, non-asbestos-fiber-filled, carbon steel, with centering provisions, conforming to ASME B16.5, Group 1

Bolting: Heavy hex-head, carbon-steel bolts or bolt studs and semifinished heavy hexnuts, conforming to ASTM A 325M ASTM A 325.

Square-head bolts are not acceptable.

2.2 PIPING FOR HIGH-PRESSURE COMPRESSED-AIR SYSTEMS

NOTE: ASME B31.1 Does not cover industrial compressed air piping outside of power houses. ANSI B31.2 covers only fuel gas portion of obsolete industrial gas and air piping systems. ANSI committee recommends interim use of ASME B31.3 for compressed-air piping.

The following system pressures are based on ASME B31.3, zero corrosion factor, welded joints, and a stress value of 20,000 psi 138 megapascal systems with pipe size larger than 3 inches 80 millimeter.

The following material specifications do not take into account material temperatures lower than minus 20 degrees Fminus 7 degrees C.

2.2.1 Type BCS-2,000 (15 megapascal 2,000-psi Service)

Pipe or tube(DN6 through DN80): (1/8 inch through 3 inches): Schedule 40, seamless black carbon steel, conforming to ASTM A 106, Grade B, or ASTM A 53/A 53M, Grade B, Type S, and ASME B36.10M

Fittings (DN6 through DN40): 15 megapascal (1/8 inch through 1-1/2 inches): 2,000-psi wog, forged carbon steel, socket weld, conforming to

ASTM A 105/A 105M and ASME B16.11

Fittings (DN50 through DN80): (2 through 3 inches): Schedule 40, long radius, butt weld, black carbon steel, conforming to ASTM A 234/A 234M, Grade WPB, and ASME B16.9

Flanges (DN25 through DN80): 6200 kilopascal (1 inch through 3 inches): 900-pound, forged carbon steel, welding neck, with raised face and concentric serrated finish, conforming to ASTM A 105/A 105M or ASTM A 181/A 181M, Class 60, and ASME B16.5

Gaskets: Spiral wound, non-asbestos-fiber-filled, carbon steel, with centering provisions, conforming to ASME B16.5, Group 1

Bolting: Alloy-steel bolt studs conforming to ASTM A 193/A 193M, Grade B7, and semifinished heavy hex-nuts, conforming to ASTM A 194/A 194M, Grade 2H

2.2.2 Type BCS-6,000 (41368-kilopascal 6,000-psi Service)

Pipe or tube (DN15 through DN80): (1/2 inch through 3 inches): XXS, seamless, black carbon steel, conforming to ASTM A 106, Grade B, or ASTM A 53/A 53M, Grade B, Type S and ASME B36.10M

Fittings (DN15 through DN40): 41.3 megapascal (1/2 inch through 1-1/2 inches): 6,000-psi wog, forged carbon steel, socket weld, conforming to ASTM A 105/A 105M and ASME B16.11

Fittings (DN50 through DN80): (2 through 3 inches): XXS, long-radius, butt weld, black carbon steel, conforming to ASTM A 234/A 234M, Grade WPB, ASME B16.9, and ASME B36.10M

Flanges (DN50 through DN80): 17.2 megapascal (2 through 3 inches): 2,500-pound, forged carbon steel, welding neck with raised face and concentric serrated finish, conforming to ASTM A 105/A 105M and ASME B16.5

Gaskets: Spiral-wound, non-asbestos-filled, carbon steel, with centering provisions, conforming to ASME B16.5, Group 1

Bolting: Alloy steel bolt studs conforming to ASTM A 193/A 193M, Grade B7, and semifinished heavy hex-nuts, conforming to ASTM A 194/A 194M, Grade 2H

PART 3 EXECUTION

3.1 GENERAL

Pipe shall be installed in accordance with manufacturer's recommendations and in accordance with Section 15050S BASIC MECHANICAL MATERIALS AND METHODS.

-- End of Section --