

Scope	Steel pipe piling for permanent, structural load-carrying member or as a shell to form cast-in-place concrete piles.
Specification	ASTM A252, Grades 2 and 3/modified to 50 ksi min. yield
Manufacturing Process	Straight-seam electric resistance weld (ERW)
Size (OD)	8.625, 10.750 and 12.750
Gauge/Wall Thickness	0.250, 0.313, 0.375 and 0.500 (nominal)
Strength/Elongation Properties	Yield: 50 ksi min., 60 ksi min., 75 ksi min., 80 ksi min. Aim to. Tensile: 66 ksi min. Elongation: 20% min.
Straightness Tolerance	1/8" x length (in feet), divided by five
Weight Tolerance	Weight must not vary more than 15% over or 5% under. Piling weight controlled by utilizing minimum-gauge coil stock. Searing does not weigh each individual length of pipe.
Chemical Composition	Carbon: 0.23 max. Manganese: 1.35 max. Meets ASTM A252
Carbon Equivalent (CE)	0.45 max (per AWS D1.1)
Weldability	AWD D1.1 base metal Can be welded with AWS prequalified welding procedures
Testing	ASTM A370: In-house flattening and cone test per heat
Material Test Reports	Material test reports are furnished for each length of pipe. Steel mill coil certifications/gauge certifications available upon request.
Marking/ID Stamp	Ink stenciling on one side of the OD, ID stamping when requested

STRENGTH LEVELS	GRADE 2	GRADE 3
Yield Strength	35,000 psi min.	45,000 psi min.
Tensile Strength	60,000 psi min.	66,000 psi min.
Elongation % in 2" Min.	25	20
Meets AWS D1.1 Base Metal Welding requirements	Yes	Yes

CHEMISTRY LEVELS	ALL GRADES
Carbon	N/A
Manganese	N/A
Phosphorus	0.050 max.
Sulphur	N/A
Silicon	N/A
Grain Refining Elements	N/A

TOLERANCES	ALL GRADES
OD Size	
>1.9 - 2.5 incl.	+/- 1%
>2.5 - 3.5 incl.	+/- 1%
>3.5 - 5.5 incl.	+/- 1%
>5.5	+/- 1%
Wall Thickness	-12.5%
Weight	+15% / -5%
Straightness (max. allowed)	Not specified