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| 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 |

