

# KELLY PIPE

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## PIPING RESOURCE GUIDE

## Table of Contents

- Page 2 About Kelly Pipe / Legal Notice
- Page 3 Bundling Charts / Services
- Page 4 Pipe Chart
- Page 5 Common Terms, Specifications and Formulas
- Page 6 Common Terms, Specifications and Formulas
- Page 7 -11 Line Pipe Data

## About Kelly Pipe

Kelly Pipe was founded in Los Angeles in 1898 and began as a storage yard for used pipe and boiler tube fabrication. In the early 1920's we moved to a larger downtown Los Angeles location and began distributing new pipe, valves and fittings. In 1966, Kelly Pipe opened our first branch in Santa Fe Springs, CA and in 1971 this location became our headquarters. Today, we have branch/stocking locations in Chicago, IL; Fairless Hills, PA; Wheatland, PA; Colton, CA; Salt Lake City, UT; Phoenix, AZ; Henderson, CO; Houston, TX; Charlotte, NC and Edmonton, AB.

Kelly Pipe also has sales offices in Citrus Heights, San Diego and Emeryville, CA; Odessa, TX; Spokane, WA and Casper, WY.

and Coupling; MG Piping Products; Westflex and Lavi Systems, Inc.

## Legal Notice

Please note, this catalog is to be used for general information only. Kelly Pipe Co has designed this catalog with great care. However Kelly Pipe Co makes no warranty or representation, expressed or implied, of any kind with respect to the information contained herein and shall in no event assume liability or responsibility for any loss, damages or injury whatsoever resulting from the use of the information. In all cases, the customer is therefore requested to use the information at its own risk and responsibility.

## Bundling Charts

### Domestic A53 Pipe x 21' Lengths

NPS	Sch 40 Pieces	Sch 40 Footage	Sch 80 Pieces	Sch 80 Footage
1/2"	132	2772'	96	2016'
3/4"	98	2058'	70	1470'
1"	65	1365'	50	1050'
1 1/4"	48	1008'	36	756'
1 1/2"	39	819'	30	630'
2"	28	588'	21	441'
2 1/2"	18	378'	14	294'
3"	14	294'	10	210'
4"	10	210'	7	147'

### Import A53 Pipe x 21' Lengths

NPS	Sch 40 Pieces	Sch 40 Footage	Sch 80 Pieces	Sch 80 Footage
1/2"	120	2520'	120	2520'
3/4"	84	1764'	84	1764'
1"	60	1260'	60	1260'
1 1/4"	42	882'	42	882'
1 1/2"	36	756'	36	756'
2"	26	546'	26	546'
2 1/2"	18	378'	18	378'
3"	14	294'	14	294'
4"	10	210'	10	210'

## Services

### Cutting / Beveling

#### Plasma Torch Cutting

1/8" thru 48" most wall thicknesses

#### Beveling

2" thru 48" most wall thicknesses

#### Cut to Length

Upon request, we are able to cut material to length, within most tolerances.

### Grooving

#### Roll Grooving

Material can be roll grooved at our facility in Chicago, IL and Santa Fe Springs, CA 4" nom. thru 24" OD most wall thicknesses. Victaulic AGS System 14" through 24" OD.

#### Cut Grooving

Material can be cut grooved at our facility in Santa Fe Springs, CA, 2" thru 24" most wall thicknesses.

### Other Services

#### Bundling

Kelly Pipe has the ability to assist our customers with special orders that require specific bundling requirements.

#### Coatings / Linings

Kelly Pipe, through several valued relationships with quality pipe coaters can supply pipe for your stock and projects requiring most types of pipe coatings and linings.



# Kel Iy Pipe Chart

Nominal Pipe Size	Actual OD	Sch 10			Sch 20	Sch 30	Sch 40	STD	Sch 60	Sch 80	XH	Sch 100	Sch 120	Sch 140	Sch 160	XXH
1/8"	0.405						0.680 0.240	0.680 0.240		0.950 0.310	0.950 0.310					
1/4"	0.540						0.088 0.420	0.088 0.420		0.119 0.540	0.119 0.540					
3/8"	0.675						0.091 0.570	0.091 0.570		0.126 0.740	0.126 0.740					
1/2"	0.840						0.109 0.850	0.109 0.850		0.147 1.088	0.147 1.088				0.188 1.300	0.294 1.710
3/4"	1.050						0.113 1.133	0.113 1.133		0.154 1.474	0.154 1.474				0.218 1.940	0.308 2.440
1"	1.315	0.109 1.400					0.133 1.679	0.133 1.679		0.179 2.172	0.179 2.172				0.250 2.840	0.358 3.660
1 1/4"	1.660	0.109 1.810					0.140 2.273	0.140 2.273		0.191 2.997	0.191 2.997				0.250 3.770	0.382 5.21
1 1/2"	1.990	0.109 2.090					0.145 2.718	0.145 2.718		0.200 3.653	0.200 3.653				0.281 4.860	0.400 6.41
2"	2.375	0.109 2.640					0.154 3.653	0.154 3.653		0.218 5.022	0.218 5.022				0.344 7.670	0.436 9.040
2 1/2"	2.785	0.120 3.530					0.203 5.793	0.203 5.793		0.276 7.667	0.276 7.667				0.375 10.02	0.552 13.71
3"	3.500	0.120 4.340	0.156 5.57	0.188 6.65			0.216 7.659	0.216 7.659		0.300 10.25	0.300 10.25				0.438 14.34	0.600 18.60
3 1/2"	4.000	0.120 4.980					0.226 10.79	0.226 10.79		0.318 12.52	0.318 12.52					
4"	4.500	0.120 5.620	0.156 7.24	0.188 8.67			0.237 10.79	0.237 10.79		0.337 15.00	0.337 15.00		0.438 19.02		0.531 22.53	0.674 27.57
5"	5.562	0.134 7.780		0.188 10.80			0.258 14.62	0.258 14.62		0.375 20.80	0.375 20.80		0.500 27.04		0.625 32.99	0.750 38.59
6"	6.625	0.134 9.300	0.188 12.95	0.250 17.04			0.280 18.97	0.280 18.97		0.432 28.57	0.432 28.57		0.562 36.39		0.719 45.39	0.864 53.21
8"	8.625		0.188 16.95	0.219 19.68	0.250 22.36	0.277 24.72	0.322 28.55	0.322 28.55	0.406 35.67	0.500 43.39	0.500 43.39	0.594 51.00	0.719 60.77	0.812 67.82	0.906 74.76	0.875 72.49
10"	10.75		0.188 21.23	0.219 24.65	0.250 28.06	0.307 34.27	0.365 40.48	0.365 40.48	0.500 54.79	0.594 64.49	0.500 54.79	0.719 77.10	0.844 89.38	1.000 104.23	1.125 115.78	1.000 104.23
12"	12.75		0.188 22.20	0.219 29.34	0.250 33.41	0.330 43.81	0.406 53.57	0.375 49.56	0.562 73.22	0.688 88.71	0.500 65.48	0.844 107.42	1.000 125.61	1.125 139.81	1.312 160.42	1.000 125.61
14"	14.00	0.250 36.75			0.312 45.65	0.375 54.57	0.438 63.50	0.375 54.57	0.594 85.13	0.750 106.23	0.500 72.16	0.938 130.98	1.094 150.93	1.250 170.37	1.406 189.29	
16"	16.00	0.250 42.05			0.312 52.32	0.375 54.57	0.500 82.85	0.375 62.58	0.656 107.60	0.844 136.74	0.500 82.85	1.031 164.98	1.219 192.61	1.468 228.05	1.594 245.48	
18"	18.00	0.250 47.44			0.312 58.99	0.438 82.23	0.562 104.76	0.375 70.59	0.750 138.30	0.938 171.08	0.500 93.54	1.156 208.15	1.375 244.37	1.562 274.58	1.781 308.79	
20"	20.00	0.250 52.78			0.375 78.60	0.500 104.23	0.594 123.23	0.375 78.60	0.812 166.56	1.031 209.06	0.500 104.23	1.281 256.34	1.500 296.65	1.750 341.41	1.969 379.53	
24"	24.00	0.250 63.47			0.375 94.62	0.562 140.81	0.688 171.45	0.375 94.62	0.969 238.57	1.219 296.86	0.500 125.61	1.531 367.74	1.812 429.79	2.062 483.57	2.3445 542.64	
30"	30.00		0.250 79.51			0.625 196.25		0.375 118.76			0.500 157.68					
36"	36.00		0.250 95.54				0.750 282.62	0.375 142.81			0.500 189.75					
48"	48.00							0.375 190.92			0.500 253.89					

## Common Terms, Specifications and Formulas

### Different ways Pipe is Produced

**Continuous Weld** – Heated skelp is passed continuously through welding rolls, which form the tube and squeeze the hot edges together to make a weld.

**Electric Resistance Weld** – Pipe made from strips of hot-rolled steel which are passed through forming rolls and welded.

**Seamless** – Pipe made from a solid billet, which is heated, then rotated under extreme pressure. The rotational pressure creates an opening in the center of the billet, which is then shaped by a mandrel to form pipe.

**Double Submerged Arc Weld** – Steel plate is processed into a cylinder then welded both from the inside and outside by a welding arc that is submerged in flux.

**Spiral Weld** – Spiral weld pipe has a welded seam that spirals down the entire length of pipe. Spiral weld pipe is typically used in low pressure or structural applications.

### Pipe Chart

On page 4— The chart reads as follows;  
For example 2" Schedule 40

Wall Thickness → 0.154  
3.653 ← Weight / ft

#### Helpful Tips

- Schedule 40 and Standard Wall is the same through 10"
- Schedule 80 and XH is the same through 8"
- Nominal OD vs. Actual OD varies thru 12", 14" and above are the same

### Trucking Jargon

#### Strip Loaded

4 x 4 dunnage is placed between each layer of pipe.

#### Pyramid Loaded

No 4 x 4 dunnage is used. Pipe is stacked piece upon piece forming a "pyramid" of pipe on the bed of a truck trailer.

#### Stringing

When pipe is pulled directly off a truck one or more pieces at a time to "string" end to end. Typically, a per hour fee is charged to have pipe strung.

### Weight Per Foot Formula

to figure weight per foot of any size pipe or Wall thickness

**Weight in Lbs = 10.68 (D-T) T**

D= Outside Diameter of the Pipe

T = Wall Thickness of the Pipe

**Example : Weight per foot of 8" Sch 40 pipe**

Weight = 10.68 (8.625 - .322).322

Weight = 10.68 (8.30).322

Weight = 88.64 x .322    Weight = 28.55 lbs / ft

### Yield & Tensile Strength

Grade	Min Yield	Min Tensile
A53A	30,000	48,000
A53B	35,000	60,000
A106B	35,000	60,000
API5LB	35,000	60,000
API5L-X42	42,000	60,000

## Common Terms, Formulas and Specifications

### Types of Coating

#### Mill Lacquer

A lacquer applied to the OD of pipe to offer temporary corrosion protection while pipe is being stored. (Picture 1)



Pic 1

#### Galvanized

Hot dip galvanizing process requires the pipe to be dipped into a series of cleaning and pre-treatment chemicals prior to immersion in the molten zinc. (Picture 2)



Pic 2

#### Fusion Bond Epoxy

Fusion bond epoxy is an environmentally-safe thermosetting coating that is sprayed onto the pipe surface after it has been cleaned and heated to over 450°F. The epoxy powder melts onto the steel surface and fuses to the pipe, creating a hard barrier. (Picture 3)



Pic 3

#### Extruded Polyethylene (X-tru Coat)

Extruded polyethylene, usually yellow in color for natural gas usage, consists of a continuous sheath of high density polyethylene extruded over a rubberized asphalt adhesive (Picture 4)



Pic 4

### Line Pipe Data definitions

#### Hydrostatic Testing

High pressure water test to predetermined pressures as required by specifications.

#### Yield Strength

The tensile stress required to produce a total elongation of .5 percent of the gauge length as determined by an extensometer. Expressed in P.S.I.

#### Tensile Strength

Ultimate bursting strength to resist being pulled apart. Expressed in P.S.I.

**Mil I Hydrostatic Test Pressure, psi**

**Cal cul ated Internal Pressure At Minimum Yield d, psi**

**Cal cul ated Internal UI timate Bursting Pressure, psi**

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
2.375" O.D.						
0.154	2330	2500	3000	3000	3000	3000
0.218	2500	2500	3000	3000	3000	3000
0.344	2500	2500	3000	3000	3000	3000
0.436	2500	2500	3000	3000	3000	-
2.875" O.D.						
0.203	2500	3000	3000	3000	3000	3000
0.276	2500	3000	3000	3000	3000	3000
0.375	2500	3000	3000	3000	3000	-
0.552	2500	2500	3000	3000	3000	-
3.500" O.D.						
0.216	2200	2500	3000	3000	3000	3000
0.300	2500	2500	3000	3000	3000	3000
0.438	2500	2500	3000	3000	3000	3000
0.600	2500	2500	3000	3000	3000	-
4.500" O.D.						
0.156	1250	1460	2180	2390	2700	3000
0.188	1500	1750	2630	2880	3000	3000
0.237	1900	2210	3000	3000	3000	3000
0.337	2700	2800	3000	3000	3000	3000
0.438	2800	2800	3000	3000	3000	3000
0.531	2800	2800	3000	3000	3000	-
0.674	2800	2800	3000	3000	3000	-
5.563" O.D.						
0.258	1670	1950	2920	3000	3000	3000
0.375	2430	2800	3000	3000	3000	3000
0.625	2800	2800	3000	3000	3000	-
0.750	2800	2800	3000	3000	3000	-

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
2.375" O.D.						
0.154	3890	4540	5450	5970	6740	7780
0.218	5510	6430	7710	8440	9550	11010
0.344	8690	10140	12170	13330	15060	17380
0.436	11010	12850	15420	16890	19090	-
2.875" O.D.						
0.203	4240	4940	5930	6500	7340	8470
0.276	5760	6720	8060	8830	9980	11520
0.375	7830	9130	10960	12000	13570	15650
0.552	11520	13440	16130	17660	19970	-
3.500" O.D.						
0.216	3700	4320	5180	5680	6420	7410
0.300	5140	6000	7200	7890	8910	10920
0.438	7510	8760	10510	11510	13010	15020
0.600	10290	12000	14400	15770	17830	-
4.500" O.D.						
0.156	2080	2430	2910	3190	3610	4160
0.188	2510	2920	3510	3840	4340	5010
0.237	3160	3690	4420	4850	5480	6320
0.337	4490	5240	6290	6890	7790	8990
0.438	5840	6810	8180	8950	10120	11680
0.531	7080	8260	9910	10860	12270	-
0.674	8990	10480	12580	13780	15580	-
5.563" O.D.						
0.258	2780	3250	3900	4270	4820	5570
0.375	4040	4720	5660	6200	7010	8090
0.625	6740	7860	9440	10340	11680	-
0.750	8090	9440	11320	12400	14020	-

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
2.375" O.D.						
0.154	6220	7780	7780	8170	8560	9730
0.218	8810	11010	11010	11570	12120	13770
0.344	13900	17380	17380	18250	19120	21730
0.436	17620	22030	22030	23130	24230	-
2.875" O.D.						
0.203	6780	8470	8470	8900	9320	10590
0.276	9220	11520	11520	12100	12670	14400
0.375	12520	15560	15560	16430	17220	19570
0.552	18430	23040	23040	24190	25340	-
3.500" O.D.						
0.216	5920	7410	7410	7780	8150	9260
0.300	8230	10290	10290	10800	11310	12860
0.438	12010	15020	15020	15770	16520	18770
0.600	16460	20570	20570	21600	22630	-
4.500" O.D.						
0.156	3330	4160	4160	4370	4580	5200
0.188	4010	5010	5010	5260	5510	6270
0.237	5060	6320	6320	6640	6950	7900
0.337	7190	8990	8990	9440	9890	11230
0.438	9340	11680	11680	12260	12850	14600
0.531	11330	14160	14160	14870	15580	-
0.674	14380	17970	17970	18870	19770	-
5.563" O.D.						
0.258	4450	5570	5570	5840	6120	6960
0.375	6470	8090	8090	8490	8900	10110
0.625	10790	13480	13480	14160	14830	-
0.750	12940	16180	16180	16990	17800	-

**Mill Hydrostatic Test Pressure, psi**

**Calculated Internal Pressure At Minimum Yield, psi**

**Calculated Internal Ultimate Bursting Pressure, psi**

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
6.625" OD						
0.156	1060	1240	1480	1620	1840	2120
0.188	1280	1490	1790	1960	2210	2550
0.219	1480	1740	2080	2280	2580	2980
0.250	1700	1980	2380	2600	2940	3000
0.280	1900	2220	2660	2920	3000	3000
0.432	2800	2800	3000	3000	3000	3000
0.562	2800	2800	3000	3000	3000	3000
0.719	2800	2800	3000	3000	3000	-
0.864	2800	2800	3000	3000	3000	-
8.625" OD						
0.156	810	950	1140	1250	1410	1630
0.188	980	1140	1370	1500	1700	1960
0.219	1140	1330	1600	1750	1980	2290
0.250	1300	1520	1830	2000	2260	2610
0.277	1450	1690	2020	2200	2510	2890
0.322	1680	1960	2350	2580	2910	3000
0.500	2610	2800	3000	3000	3000	3000
0.875	2800	2800	3000	3000	3000	-
0.906	2800	2800	3000	3000	3000	-
10.75" O.D.						
0.188	790	920	1250	1370	1550	1780
0.219	920	1070	1450	1590	1800	2080
0.250	1050	1220	1660	1820	2060	2370
0.279	1170	1360	1850	2030	2290	2650
0.307	1290	1500	2040	2230	2520	2910
0.365	1530	1780	2420	2660	3000	3000

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
6.625" OD						
0.156	1410	1650	1980	2170	2450	2830
0.188	1700	1990	2380	2610	2950	3410
0.219	1980	2310	2780	3040	3440	3970
0.250	2260	2640	3170	3470	3920	4530
0.280	2540	2960	3550	3890	4400	5070
0.432	3910	4560	5480	6000	6780	7820
0.562	5090	5940	7130	7800	8820	-
0.719	6510	7600	9120	9980	11290	-
0.864	7820	9130	10950	12000	13560	-
8.625" OD						
0.156	1090	1270	1520	1660	1880	2170
0.188	1310	1530	1830	2010	2270	2620
0.219	1520	1780	2130	2340	2640	3050
0.250	1740	2030	2430	2670	3010	3480
0.277	1930	2250	2700	2950	3340	3850
0.322	2240	2610	3140	3430	3880	4480
0.500	3480	4060	4870	5330	6030	6960
0.875	6090	7100	8520	9330	10550	-
0.906	6200	7350	8820	9660	10920	-
10.75" O.D.						
0.188	1050	1220	1470	1610	1820	2100
0.219	1220	1430	1710	1870	2120	2440
0.250	1400	1630	1950	2140	2420	2790
0.279	1560	1820	2180	2390	2700	3110
0.307	1710	2000	2400	2630	2970	3430
0.365	2040	2380	2850	3120	3530	4070

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
6.625" OD						
0.156	2260	2830	2830	2970	3110	3530
0.188	2720	3410	3410	3580	3750	4260
0.219	3170	3970	3970	4170	4360	4960
0.250	3620	4530	4530	4750	4980	5660
0.280	4060	5070	5070	5330	5580	6340
0.432	6260	7820	7820	8220	8610	9780
0.562	8140	10180	10180	10690	11200	-
0.719	10420	13020	13020	13670	14330	-
0.864	12520	15650	15650	16430	17210	-
8.625" OD						
0.156	1740	2170	2170	2280	2390	2710
0.188	2090	2620	2620	2750	2880	3270
0.219	2440	3050	3050	3200	3350	3810
0.250	2780	3480	3480	3650	3830	4350
0.277	3080	3850	3850	4050	4240	4820
0.322	3580	4480	4480	4700	4930	5600
0.500	5570	6960	6960	7300	7650	8700
0.875	9740	12170	12170	12780	13390	-
0.906	10080	12610	12610	13240	13870	-
10.75" O.D.						
0.188	1680	2100	2100	2200	2310	2620
0.219	1960	2440	2440	2570	2690	3060
0.250	2230	2790	2790	2930	3070	3490
0.279	2490	3110	3110	3270	3430	3890
0.307	2740	3430	3430	3600	3770	4280
0.365	3260	4070	4070	4280	4480	5090



**Mill Hydrostatic Test Pressure, psi**

**Calculated Internal Pressure At  
Minimum Yield, psi**

**Calculated Internal Ultimate Bursting  
Pressure, psi**

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
10.75" OD						
0.500	2090	2440	3000	3000	3000	3000
0.594	2490	2800	3000	3000	3000	3000
1.125	2800	2800	3000	3000	3000	3000
12.75" OD						
0.188	660	770	1050	1150	1300	1500
0.219	770	900	1230	1340	1520	1750
0.250	880	1030	1400	1530	1730	2000
0.281	990	1160	1570	1720	1950	2250
0.375	1320	1540	2100	2300	2600	3000
0.406	1430	1670	2270	2490	2810	3000
0.500	1760	2060	2800	3000	3000	3000
0.562	1980	2310	3000	3000	3000	-
0.625	2210	2570	3000	3000	3000	-
0.688	2430	2800	3000	3000	3000	-
0.844	2800	2800	3000	3000	3000	-
1.132	2800	2800	3000	3000	3000	-
14.00" OD						
0.250	800	940	1280	1400	1580	1820
0.281	900	1050	1430	1570	1770	2050
0.312	1000	1170	1590	1740	1970	2270
0.375	1210	1410	1910	2090	2370	2730
0.438	1410	1640	2230	2450	2770	-
0.500	1610	1880	2550	2790	3000	-
0.594	1910	2230	3000	3000	3000	-
0.750	2410	2800	3000	3000	3000	-
1.406	2800	2800	3000	3000	3000	-

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
10.75" OD						
0.500	2790	3260	3910	4280	4840	5580
0.594	3320	3870	4640	5080	5750	-
1.125	6280	7330	8790	9630	10880	-
12.75" OD						
0.188	880	1030	1240	1360	1530	1770
0.219	1030	1200	1440	1580	1790	2060
0.250	1180	1370	1650	1800	2040	2350
0.281	1320	1540	1850	2030	2290	2640
0.375	1760	2060	2470	2710	3060	3530
0.406	1910	2230	2670	2930	3310	3820
0.500	2350	2750	3290	3610	4080	4710
0.562	2640	3090	3700	4060	4580	-
0.625	2940	3430	4120	4510	5100	-
0.688	3240	3780	4530	4960	5610	-
0.844	3970	4630	5560	6090	6880	-
1.132	6170	7200	8640	9470	10700	-
14.00" OD						
0.250	1070	1250	1500	1640	1860	2140
0.281	1200	1400	1690	1850	2090	2410
0.312	1340	1560	1870	2050	2320	2670
0.375	1610	1880	2250	2460	2790	3210
0.438	1880	2190	2630	2880	3250	-
0.500	2140	2500	3000	3290	3710	-
0.594	2550	2970	3560	3900	4410	-
0.750	3210	3750	4500	4930	5570	-
1.406	6030	7030	8440	9240	10440	-

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
10.75" OD						
0.500	4470	5580	5580	5860	6140	6980
0.594	5300	6630	6630	6960	7290	-
1.125	10050	12560	12560	13190	13810	-
12.75" OD						
0.188	1420	1770	1770	1860	1950	2210
0.219	1650	2060	2060	2160	2270	2580
0.250	1880	2350	2350	2470	2590	2940
0.281	2120	2640	2640	2780	2910	3310
0.375	3060	3820	3820	4010	4200	4780
0.406	3060	3820	3820	4010	4200	4780
0.500	3760	4710	4710	4940	5180	5880
0.562	4230	5290	5290	5550	5820	-
0.625	4710	5880	5880	6180	6470	-
0.688	5180	6480	6480	6800	7120	-
0.844	6350	7940	7940	8340	8740	-
1.132	9880	12350	12350	12970	13580	-
14.00" OD						
0.250	1710	2140	2140	2250	2360	2680
0.281	1930	2410	2410	2530	2650	3010
0.312	2140	2670	2670	2810	2940	3340
0.375	2570	3210	3210	3380	3540	4020
0.438	3000	3750	3750	3940	4130	-
0.500	3430	4290	4290	4500	4710	-
0.594	4070	5090	5090	5350	5600	-
0.750	5140	6430	6430	6750	7070	-
1.406	9640	12050	12050	12650	13260	-

**Mill Hydrostatic Test Pressure, psi**

**Calculated Internal Pressure At  
Minimum Yield, psi**

**Calculated Internal Ultimate Bursting  
Pressure, psi**

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
16.00" OD						
0.219	620	720	980	1070	1210	1400
0.250	700	820	1120	1220	1380	1590
0.281	790	920	1250	1370	1550	1790
0.312	880	1020	1390	1520	1720	1990
0.375	1050	1230	1670	1830	2070	2390
0.500	1410	1640	2230	2440	2760	-
0.656	1840	2150	2930	3000	3000	-
0.688	1940	2260	3000	3000	3000	-
0.844	2370	2770	3000	3000	3000	-
1.031	2800	2800	3000	3000	3000	-
1.219	2800	2800	3000	3000	3000	-
1.438	2800	2800	3000	3000	3000	-
1.594	2800	2800	3000	3000	3000	-
18.00" OD						
0.219	550	640	870	950	1080	1240
0.250	620	730	990	1090	1230	1420
0.312	780	910	1240	1360	1530	1770
0.375	940	1090	1490	1630	1840	2120
0.438	1100	1280	1740	1900	2150	-
0.500	1250	1460	1980	2170	2460	-
0.562	1400	1640	2230	2440	2760	-
0.688	1720	2010	2730	2990	3000	-
0.812	2030	2370	2980	3000	3000	-
0.938	2640	2740	3000	3000	3000	-
1.156	2800	2800	3000	3000	3000	-
1.375	2800	2800	3000	3000	3000	-

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
16.00" OD						
0.219	820	960	1150	1260	1420	1640
0.250	940	1090	1310	1440	1630	1880
0.281	1050	1230	1480	1620	1830	2110
0.312	1170	1360	1640	1790	2030	2340
0.375	1410	1640	1970	2160	2440	2810
0.500	1880	2190	2630	2880	3250	-
0.656	2460	2870	3440	3770	4260	-
0.688	2580	2870	3610	3960	4470	-
0.844	3160	3690	4430	4850	5490	-
1.031	3870	4510	5410	5930	6700	-
1.219	4570	5330	6400	7010	7920	-
1.438	5390	6290	7550	8270	9350	-
1.594	5980	6870	8370	9170	10360	-
18.00" OD						
0.219	730	850	1020	1120	1270	1460
0.250	830	970	1170	1280	1440	1670
0.312	1040	1210	1460	1590	1800	2080
0.375	1250	1460	1750	1920	2170	2500
0.438	1460	1700	2040	2240	2530	-
0.500	1670	1940	2330	2560	2890	-
0.562	1870	2190	2620	2870	3250	-
0.688	2290	2680	3210	3520	3980	-
0.812	2710	3160	3790	4150	4690	-
0.938	3130	3650	4380	4790	5420	-
1.156	3850	4500	5390	5910	6680	-
1.375	4580	5350	6420	7030	7940	-

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
16.00" OD						
0.219	1310	1640	1640	1720	1810	2050
0.250	1500	1880	1880	1970	2060	2340
0.281	1690	2110	2110	2210	2320	2630
0.312	1870	2340	2340	2460	2570	2930
0.375	2250	2810	2810	1950	3090	3520
0.500	3000	3750	3750	3940	4130	-
0.656	3940	4920	4920	5170	5410	-
0.688	4130	5160	5160	5420	5680	-
0.844	5060	6330	6330	6650	6960	-
1.031	6190	7730	7730	8120	8510	-
1.219	7310	9140	9140	9600	10060	-
1.438	8630	10780	10780	11320	11860	-
1.594	9560	11950	11950	12550	13150	-
18.00" OD						
0.219	1170	1460	1460	1530	1610	1830
0.250	1330	1670	1670	1750	1830	2080
0.312	1660	2080	2080	2180	2290	2600
0.375	2000	2500	2500	2630	2750	3130
0.438	2340	2920	2920	3070	3210	-
0.500	2670	3330	3330	3500	3670	-
0.562	3000	3750	3750	3930	4120	-
0.688	3670	4590	4590	4820	5050	-
0.812	4330	5410	5410	5680	5950	-
0.938	5000	6250	6250	6570	6880	-
1.156	6170	7710	7710	8090	8480	-
1.375	7330	9170	9170	9630	10080	-

### Mill Hydrostatic Test Pressure, psi

### Calculated Internal Pressure At Minimum Yield, psi

### Calculated Internal Ultimate Bursting Pressure, psi

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
20.00" OD						
0.250	560	660	940	1040	1170	1350
0.312	700	820	1180	1290	1460	1680
0.375	840	980	1420	1550	1760	2020
0.500	1120	1310	1890	2070	2340	-
0.594	1340	1560	2250	2460	2750	-
0.688	1550	1810	2600	2750	2750	-
0.812	1830	2130	2750	2750	2750	-
1.031	2320	2710	2750	2750	2750	-
1.281	2750	2750	2750	2750	2750	-
1.375	2750	2750	2750	2750	2750	-
24.00" OD						
0.250	470	550	790	860	980	1120
0.375	700	820	1180	1290	1460	1690
0.500	940	1090	1580	1720	1950	2250
0.688	1290	1500	2170	2300	2300	-
0.969	1820	2120	2300	2300	2300	-
1.219	2290	2300	2300	2300	2300	-

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
20.00" OD						
0.250	750	880	1050	1150	1300	1500
0.312	940	1090	1310	1440	1620	1870
0.375	1130	1310	1580	1730	1950	2250
0.500	1500	1750	2100	2300	2600	-
0.594	1780	2080	2490	2730	3090	-
0.688	2060	2410	2890	3160	3580	-
0.812	2440	2840	3410	3740	4220	-
1.031	3090	3610	4330	4740	5360	-
1.281	3840	4480	5380	5890	6660	-
1.375	4130	4810	5780	6330	7150	-
24.00" OD						
0.250	630	730	800	960	1080	1250
0.375	940	1090	1310	1440	1630	1880
0.500	1250	1460	1750	1920	2170	2500
0.688	1720	2010	2410	2640	2980	-
0.969	2420	2830	3390	3710	4200	-
1.219	3050	3560	4270	4670	5280	-

OD & Wall Thickness	Grade A	Grade B	X-42	X-46	X-52	X-60
20.00" OD						
0.250	1200	1500	1500	1580	1800	1950
0.312	1500	1870	1870	1970	2250	2430
0.375	1800	2250	2250	2360	2700	2930
0.500	2400	3000	3000	3150	3300	-
0.594	2850	3560	3560	3740	3920	-
0.688	3300	4130	4130	4330	4540	-
0.812	3900	4870	4870	5120	5360	-
1.031	4950	6190	6190	6500	6800	-
1.281	6150	7690	7690	8070	8450	-
1.375	6600	8250	8250	8660	9075	-
24.00" OD						
0.250	1000	1250	1250	1310	1500	1630
0.375	1500	1880	1880	1970	2250	2440
0.500	2000	2500	2500	2630	2750	3130
0.688	2750	3440	3440	3610	3780	-
0.969	3880	4850	4850	5090	5330	-
1.219	4880	6100	6100	6400	6700	-