



Commercial Quality (CQ) Steel Pipe

Submittal Data Sheet

Approvals and Specifications

This product meets the following standards:

- Flattening tested for NPS 1/2" and higher
- Non-destructively electric tested
- Made in Canada

Product Marking

Each length of pipe 1/2" NPS and larger is continuously stenciled to show:

- The manufacturer name,
- CQ "Made in Canada",
- Lot number (if galvanized)
- The letters "HT" if hydrostatically tested
- Date

*No stencil is applied on pipe intended for fencing.

Dimensions and Weights

NPS	OD	Light Wall	Light Weight	S10 Wall	S10 Weight	S40 Wall	S40 Weight	S80 Wall	S80 Weight
	in	in	lb/ft	in	lb/ft	in	lb/ft	in	lb/ft
1/2	0.840	-	-	-	-	0.109	0.85	0.147	1.09
3/4	1.050	-	-	-	-	0.113	1.13	0.154	1.48
1	1.315	0.100	1.300	-	-	0.133	1.68	0.179	2.17
1 ¼	1.660	0.100	1.670	0.109	1.81	0.140	2.27	0.191	3.00
1 ½	1.900	0.100	1.920	0.109	2.09	0.145	2.72	0.200	3.63
2	2.375	0.100	2.430	0.109	2.64	0.154	3.66	0.218	5.03
2 ½	2.875	-	-	0.120	3.53	0.203	5.80	0.276	7.67
3	3.500	-	-	0.120	4.34	0.216	7.58	0.300	10.26
3 ½	4.000	-	-	0.120	4.98	0.226	9.12	-	-
4	4.500	-	-	0.120	5.62	0.237	10.80	-	-
6	6.625	-	-	0.134	9.30	0.280	18.99	-	-



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Scope

Covers bare, black and hot-dipped galvanized, Electric Resistance Welded pipe. Pipe is intended for general applications and as a structural support for fencing. Pipe is suitable for welding and threading. Pipe is not intended for flanging.

Hot-Dipped Galvanized

When galvanized, the average weight of zinc coating is determined by the ASTM A90 testing method. When galvanized pipe is bent or otherwise fabricated to a degree which causes zinc coating to stretch or compress beyond the limit of elasticity, some flaking of the coating may occur.

Non-destructive Electric Testing

Non-destructive electric testing of the weld seam is done on each length of ERW pipe NPS 1/2" and larger.

Flattening Tested

As a test for quality of the weld, position of the weld at 90° from the direction of force and flatten until the OD is 3/4 of the original outside diameter. No cracks shall occur along the inside or outside surface of the weld.

End Finish

Plain end: ends are beveled top a angle of 30°, + 5° - 0° with a root face of 1/16 ± 1/32

Chemical Requirements

Composition, max % Carbon: 0.25, Manganese: 0.95, Phosphorus: 0.035, Sulfur: 0.035, *Copper: 0.40, *Nickel: 0.40, *Chromium: 0.40, *Molybdenum: 0.15, *Vanadium 0.08

*The combination of these five elements shall not exceed 1.00%

Tensile Requirements

Tensile Strength: minimum 48000 Psi (330 MPa)

Yield Strength: minimum 30000 Psi (205 MPa)



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Permissible Variations In Wall Thickness, In Outside Diameter, In Weight Per Foot

Minimum wall thickness at any point shall not be more than -12.5% under nominal wall thickness specified.

Pipe Diameter NPS 1 ½" and under: ±.016 inch

Pipe Diameter NPS 2" and over: ±1%

Pipe weight per foot shall not vary more than ±10% from the standard specified.