CUT SHEET OFFERINGS

ERW — Atlas Pipe Piles

Scope	HSS — hollow structural sections for friction, load-bearing, mini caisson and micro pile applications
Size (OD)*	8.625, 9.625, 10.750, 12.000, 12.750, 14.000, 16.000, 18.000 and 20.000
Gauge / Wall Thickness	0.250, 0.313, 0.375, 0.500, 0.625, 0.688, 0.750 (nominal)
Specification	ASTM A252, Grades 2 and 3 / modified to 50 ksi min. yield
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.
Manufacture Process	Straight-seam electric resistance weld (ERW)
Chemical Composition	Carbon: 0.23 max. Manganese: 1.35 max. Meets ASTM A252 / ASTM A500
Carbon Equivalent (CE)	0.45 max. (per AWS D1.1)
Weldability	AWD D1.1 base metal / ASTM A500 Can be welded with AWS prequalified welding procedures
Straightness	⅛" x length (in feet), divided by five
Testing	ASTM A370 In-house flattening and cone test per heat
Non-destructive Testing	Available as required (Ultrasonic)
Permissible Specifications	Weight must not vary more than 15% over or 5% under. Atlas controls the weight of the piling by utilizing minimum-gauge coil stock. Atlas does not weigh each individual length of pipe.
Material Test Reports	Material test reports are furnished for each length of pipe. Steel mill coil certifications / gauge certifications are available upon request.
Marking / ID Stamp	Ink stenciling on one side of the OD Atlas ID stamps piling products when requested (Chicago mill only).
Value-added Services	End beveling, custom length cutting and AWS 1.1 welding (by certified welders). Accessories, such as driving shoes, splicers, conical points, backing rings and outside / inside flanges. Available at all 3 mill locations: Chicago, IL; Blytheville, AR; and Harrow, ON.

**Non-standard ODs/gauges are also available from mill rollings (minimums apply). Please contact your account manager for more details.*

AMERICAN METAL

APP-060518

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Atlas Pipe Piles

STEEL STANDARDS FOR HIGH-CAPACITY PILES

	ASTM A252 STEEL PIPE PILES	ASTM A500 GRADES B&C
DESCRIPTION	Specification for welded steel pipe piles	Specification for welded steel structural tubing in rounds and shapes
INTENDED USE	Steel pipe piles of cylindrical shape, in which the steel cylinder acts as a permanent load-carrying member, or as a shell to form cast-in-place concrete piles	Welded, riveted or bolted construction of bridges and buildings, and for general structural purposes

TECHNICAL INFORMATION

SPECIFICATIONS	ASTM A252		ASTM A500	
STRENGTH LEVELS	**Grade 2**	**Grade 3**	**Grade B**	**Grade C**
Yield Strength	35,000 psi min.	45,000 psi min.	42,000 psi min.	46,000 psi min.
Tensile Strength	60,000 psi min.	66,000 psi min.	58,000 psi min.	62,000 psi min.
Elongation % in 2" Min.	25	20	23	21
Meets AWS D1.1 Base Metal Welding Requirements	Yes	Yes	Yes	Yes

CHEMISTRY LEVELS	All Grades	Grade B	Grade C
Carbon	N/A	0.26 max.	0.23 max.
Manganese	N/A	1.35 max.	1.35 max.
Phosphorus	0.050 max.	0.035 max.	0.035 max.
Sulphur	N/A	0.035 max.	0.035 max.
Silicon	N/A	N/A	N/A
Grain Refining Elements	N/A	N/A	N/A

TOLERANCES	All Grades	All Grades
OD Size		
> 1.9–2.5 incl.	+/- 1%	+/- 0.75%
> 2.5–3.5 incl.	+/- 1%	+/- 0.75%
> 3.5–5.5 incl.	+/- 1%	+/- 0.75%
> 5.5	+/- 1%	+/- 0.75%
Wall Thickness	-12.5%	+/- 10%
Weight	+15%/-5%	Not specified
Straightness (max. allowed)	Not specified	⅛" x length (in feet) ÷ 5

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