

## Part 642 – Specifications

### Chapter 3 – National Standard Material Specifications

#### Material Specification 551—Coated Corrugated Steel Pipe

##### A. Scope

This specification covers the quality of zinc-coated, aluminum-coated, aluminum-zinc alloy-coated, and polymer-coated corrugated steel pipe and fittings.

##### B. Pipe

All pipe shall be metallic zinc-coated, aluminum-coated, or aluminum-zinc alloy-coated corrugated steel pipe and fittings conforming to the requirements of ASTM A742, A760, A761, A762, A849, A875, and A929 for the specified type, class, fabrication of pipe and coating, and to the following additional requirements:

- (i) When closed riveted pipe is specified:
  - Pipe shall be fabricated with circumferential seam rivet spacing that does not exceed 3 inches except that 12 rivets are sufficient to secure the circumferential seams in 12-inch pipe.
  - Longitudinal seams that will be within the coverage area of a coupling band, the rivets shall have flat heads, or the rivets and holes shall be omitted and the seams shall be connected by welding to provide a minimum of obstruction to the seating of the coupling bands.
- (ii) Double riveting or double spot welding for pipe less than 42 inches in diameter may be required. When double riveting or double spot welding is specified, the riveting or welding shall be performed in a manner specified for pipe 42 inches or greater in diameter.

##### C. Coatings

- (1) Coatings described herein, unless otherwise specified, equally refer to the inside and outside pipe surfaces.
- (2) When coatings in addition to metallic coatings are specified, they shall conform to the requirements of ASTM A742, A760, A761, A762, A849, A875, and A929 for the specified type.
- (3) Polymer-coated pipe, unless otherwise specified on the drawings or in the construction specifications, shall be coated on each side with a minimum thickness of 0.01 inches (10 mils), designated as grade 10/10 in ASTM A762.

##### D. Coupling Bands

- (1) Coupling bands are to be provided for each section of pipe. The hardware for fastening the coupling band tightly to the connecting pipe shall be fabricated to permit tightening sufficiently to provide the required joint tensile strength and, if required, watertightness without failure of its fastening.
- (2) Gaskets, if specified, are to be provided for each coupling band. The fabrication of coupling bands and fastening hardware, in addition to the above, shall be sufficient to provide the required gasket seating without warping, twisting, or bending.

##### E. Fittings

- (1) Fittings shall be fabricated from steel conforming to ASTM A742, A849, A875, and

- A929. The coating of fittings shall be the same as that specified for the contiguous corrugated coated pipe.
- (2) Welded surfaces and adjacent surfaces damaged during welding shall be treated by removing all flux residue and weld splatter. The affected surfaces shall be cleaned to bright metal by sand blasting, power disk sanding, or wire brushing. The cleaned area shall extend at least 0.5 inch into the undamaged section of the coated area. Repair and coating application of damaged and uncoated pipe surface areas shall be in accordance with ASTM A780.