

MAURITIAN  
STANDARD  
MS 62—1984



---

Specification for  
Arc welded steel pipes and specials

---

Mauritius Standards Bureau

Price: Rs 1200 250.

## FOREWORD

This Mauritian Standard was drawn up by the Mechanical Engineering Industry Standards Committee through its sub-committee on Steel Pipes and approved by the Standards Council on 6 September 1984. It was notified in the Government Gazette on 9 February 1985.

In preparing this standard, reference was made to the following:

- 1 BS 18 ... Tensile testing of metals—steel tubes
- 2 BS 534 ... Steel pipes and specials for water and sewage
- 3 BS 3600 ... Steel pipes and tubes for pressure purposes: Carbon steel with specific room temperature properties
- 4 BS 3601 ... Dimensions and masses per unit length of welded and seamless steel pipes and tubes for pressure purposes
- 5 BS 4360 ... Specification for weldable structural steels
- 6 SABS 1182 ... Standard specification for light gauge welded steel pipes

Acknowledgement is made for the use of information from the above publications.

\*General Notice No. 151 of 1985.

PREVIEW

## SPECIFICATION FOR ARC WELDED STEEL PIPES AND SPECIALS

### 1 SCOPE

This Mauritian Standard sets out requirements for arc welded carbon steel pipes in sizes 406.4 mm to 2220 mm outside diameter for the conveyance of water and sewage and for general purposes. It includes external and internal protections against the corrosive action of the surrounding medium or conveyed fluid.

### 2 DEFINITIONS

For the purpose of this standard the following definitions apply.

- 2.1 *Pipe*: A straight conduit for fluid of circular cross-section with plain or prepared ends.
- 2.2 *Working pressure*: The maximum sustained operating pressure at which the pipe is intended to be used.
- 2.3 *Random lengths*: Normal manufacturing lengths falling within a specified range.
- 2.4 *Cut lengths*: Pipes cut to a specified length on which only a small tolerance is allowed.
- 2.5 *Effective length*: The actual length that a pipe contributes when correctly assembled in a run of piping. The dimension excludes the additional length contributed by a slip-on type coupling when this is used.
- 2.6 *Lot*: Not more than 50 pipes of the same nominal outside diameter, nominal wall thickness and length and (when relevant) having the same type of coating, from one manufacturer, submitted at any one time for inspection and testing.

### 3 DESIGNATION

The pipes shall be designated by their outside diameters and the grade of steel e.g. 406.4×410 denotes 406.4 mm outside diameter pipes made from steel of 410 N/mm<sup>2</sup> minimum tensile strength.

### 4 MANUFACTURE OF THE STEEL

- 4.1 The steel-making process shall conform to grade 43 of BS 4360 or equivalent.

### 5 MANUFACTURE OF PIPES

- 5.1 Pipes shall be manufactured from plate, sheet or strip, with either a longitudinal or spiral seam and are welded across the abutting edges by an automatic submerged arc or gas shielded arc or manual arc process or a combination thereof. At least two weld runs shall be used, one of which shall be on the inside of the pipe except for pipes with thickness less than 6.3 mm which may be welded in one run using a backing plate. Weld repairs shall be permitted and shall be of a quality at least equal in strength as the original arc welding.
- 5.2 Pipes shall be supplied in random lengths unless otherwise agreed. The range of lengths in which the pipes shall be supplied shall be the subject of agreement between the purchaser and the manufacturer. Where it is necessary to work to a fixed length and pipes are ordered as cut lengths, the tolerance on lengths shall not exceed  $+ \begin{matrix} 12 \\ 0 \end{matrix}$  mm and the pipe shall be cut square to the axis.