

STEEL PIPE PILES

ASTM A252 & A53



SPIRAL WELD

Spiral Weld Pipe is a firmly established member of the family of welded pipes. It is a high-quality product equal to longitudinally welded pipe. The base material is hot rolled steel in coil form (skelp). In the manufacturing process,

- uncoiling of steel
- flattening
- edge-machining
- bending
- forming into spiral pipe
- welding

All take place in a single work cycle. Welding of the strip edges - first inside, then outside - is carried out with the well-proven submerged arc equipment, which produces radiographically sound welds with outstanding physical properties. Spiral Weld Pipe is straight, round, and of the highest dimensional accuracy.

SEAMLESS

Seamless Pipe Piling is available in a wide range of hot finished carbon and alloy steels. The pipe is produced by rotary piercing and rolling of conditioned steel rounds of the proper grade, weight and diameter. The round is heated to a suitable forging temperature and pierced, yielding a hollow billet. The billet is then roller elongated in a succession of mills. This tubing then passes through a multiple-pass sizing reducing mill and a rotary sizer. After cooling, tubes are pickled in an acid bath to remove mill scale.

ELECTRIC RESISTANCE WELD

The base material for this pipe is hot rolled carbon steel (skelp). Flat strips of the steel are fed through a forming mill that gradually produces a tubular shape. Entering the welding unit, the butted edges are joined by electric resistance welding (ERW). The heat for welding is generated by the resistance of the steel to the flow of an electric current. The heat is confined to a narrow band along the edges while the balance of the building remains cold. No extraneous metal is added in the welding operation. After welding, the pipe is rolled to the accurate outside diameter required.

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SCHEDULED SIZES

TOP NUMBER: WALL THICKNESS; BOTTOM NUMBER: WEIGHT PER FOOT

PIPE SIZE	O.D. (INCHES)	5	10	20	30	STD.	40	60	XH	80	100	120	140	160	XXH
4	4.5					0.237 10.80	0.237 10.80		0.337 15.00	0.337 15.00		0.438 19.02		0.531 22.53	0.674 27.57
4.5	5					0.247 12.55			0.355 17.62						0.710 32.56
5	5.563					0.258 14.63	0.258 14.63		0.375 20.80	0.375 20.80		0.500 27.06		0.625 32.9	0.750 38.59
6	6.625					0.280 18.99	0.280 18.99		0.432 28.60	0.432 28.60		0.562 36.43		0.719 45.39	0.864 53.21
8	8.625			0.250 22.38	0.277 24.72	0.322 28.58	0.322 28.58	0.406 35.67	0.500 43.43	0.500 43.43	0.594 51.00	0.719 60.77	0.812 67.82	0.906 74.76	0.875 72.49
10	10.750		0.165 18.67	0.250 28.06	0.307 34.27	0.365 40.52	0.365 40.52	0.500 54.79	0.500 54.79	0.594 64.49	0.719 77.10	0.844 89.38	1.00 104.23	1.125 115.75	1.00 104.23
12	12.750	0.165 22.20		0.250 33.41	0.330 43.81	0.375 49.61	0.406 53.57	0.562 73.22	0.500 65.48	0.688 88.71	0.844 107.42	1.00 125.61	1.125 139.81	1.312 160.42	
14	14.00		0.250 36.75	0.312 45.65	0.375 54.62	0.375 54.62	0.438 63.50	0.594 85.13	0.500 72.16	0.750 106.23	0.938 130.98	1.094 150.93	1.250 170.37	1.406 189.29	
16	16.00		0.250 42.09	0.312 52.32	0.375 62.64	0.375 62.64	0.500 82.85	0.656 107.6	0.500 82.85	0.844 136.74	1.031 164.98	1.219 192.62	1.438 223.85	1.594 245.48	
18	18.00		0.250 47.44	0.312 58.99	0.438 82.23	0.375 70.65	0.562 104.76	0.750 138.30	0.500 93.54	0.938 171.08	1.156 208.15	1.375 244.37	1.562 274.48	1.781 308.79	
20	20.00		0.250 52.78	0.375 78.67	0.500 104.23	0.375 78.67	0.594 123.23	0.812 166.56	0.500 104.23	1.031 209.06	1.281 256.34	1.50 296.65	1.750 341.41	1.969 379.53	
22	22.00			0.375 86.69	0.500 114.92			0.875 197.60		1.125 251.05	1.250 277.27	1.625 353.94	1.875 403.38	2.125 451.49	
24	24.00		0.250 63.47	0.375 94.71	0.562 140.81	0.375 94.71	0.688 171.45	0.969 238.57	0.500 125.61	1.219 296.86	1.531 367.74	1.812 429.79	2.062 483.57	2.343 542.44	
26	26.00		0.312 85.68	0.500 136.30		0.375 102.72			0.500 136.30						
28	28.00		0.312 92.35	0.500 146.99	0.625 182.9	0.375 110.74			0.500 146.99						
30	30.00		0.312 99.02	0.500 157.68	0.625 196.26	0.375 118.76			0.500 157.68						
36	36.00		0.312 119.03	0.500 189.75	0.625 236.35	0.375 142.81	0.750 282.62		0.500 189.75						
42	42.00					0.375 166.86			0.500 221.82						
48	48.00					0.375 190.92			0.500 253.89						
54	54.00					0.375 214.97			0.500 285.96						