



considered a workmanlike finish. Disposition of such pipe shall be a matter of agreement between the manufacturer and the purchaser.

18.5 When imperfections or defects are removed by grinding, a smooth curved surface shall be maintained, and the wall thickness shall not be decreased below that permitted by this specification. The outside diameter at the point of grinding is permitted to be reduced by the amount so removed.

18.5.1 Wall thickness measurements shall be made with a mechanical caliper or with a properly calibrated nondestructive testing device of appropriate accuracy. In case of dispute, the measurement determined by use of the mechanical caliper shall govern.

18.6 Weld repair shall be permitted only subject to the approval of the purchaser and in accordance with Specification A530/A530M.

18.7 The finished pipe shall be reasonably straight.

## 19. End Finish

19.1 The Pipe shall be furnished to the following practice, unless otherwise specified.

19.1.1 *NPS 1½ [DN 40] and Smaller*—All walls shall be either plain-end square cut, or plain-end beveled at the option of the manufacturer.

19.1.2 *NPS 2 [DN 50] and Larger*—Walls through extra strong weights, shall be plain-end-beveled.

19.1.3 *NPS 2 [DN 50] and Larger*—Walls over extra strong weights, shall be plain-end square cut.

19.2 Plain-end beveled pipe shall be plain-end pipe having a bevel angle of 30°, + 5° or - 0°, as measured from a line drawn perpendicular to the axis of the pipe with a root face of  $\frac{1}{16} \pm \frac{1}{32}$  in. [ $1.6 \pm 0.8$  mm]. Other bevel angles may be specified by agreement between the purchaser and the manufacturer.

## 20. Sampling

21.3 If any test specimen is rejected, it shall be permitted to retest the specimen.

## 22. Retests

22.1 If the percentage of defective specimen is less than 10%, the percentage of fracture is more than 10%, the gage length of a 2-in. scratches marked on the specimen shall be allowed. If a specimen is rejected, a retest shall be permitted.

## 23. Test Specimens

23.1 On NPS 8 and larger, specimens shall be taken longitudinally or transversely. On smaller sizes, specimens shall be taken longitudinally or transversely. On sizes 12 in. and larger, specimens shall be taken longitudinally or transversely.

23.2 When round wall thicknesses over 1 in. are required, longitudinal axis of location midway between ends of pipe.

23.3 Test specimens shall be taken from the flattening of pipe. Specimens for tensile and free from burrs, shall be taken from the flattening of pipe.

23.4 Test specimens shall be cut from one end of pipe. Specimens shall be taken in a transverse direction. They shall be taken as close to the end of the pipe as possible. They shall be either ½ by ½ in. [25 by 25 mm] or 1½ by 1½ in. [38 by 38 mm] in cross section. They shall be taken from the flattening of pipe.