

2. Beveled End – This kind of end used when butt type weld fittings are used.
3. Threaded End – This kind of end used with threaded connections in piping system
4. Socket & Spigot – This type of end generally used in Ductile iron pipeline and non-metallic piping pipeline such as PVC, GRE/GRP.

5. Material

ASME B31.3 provides the list of material that can be used in Process Piping. in below table, you can see the most commonly used material types & their Grades. [supsysic-tables id='1']

Carbon steel Used up to 425°C	Stainless steel Used for corrosive fluid	Low alloy steel Used for temp > (425°C)	Low temp carbon steel Used for temp < (-29°C)
A53 Gr B A206 Gr B API 5L Gr B	A312 Gr TP304 A312 Gr TP316 A312 Gr TP321	A335 Gr P2 , P12, P11, P22, P5, P9	A333 Gr 6

Chemical Properties of these piping material are covered in their respective ASTM standard. ASTM Standard restrict the use of material produced by certain manufacturing process only. For example, ASTM A206 allow only killed steel that produces by the open-hearth, basic-oxygen, or electric furnace, with preferred separate degassing.

6. Heat Treatment (Hot Finished Vs Cold Finished)

Heat treatment of pipe depends on the way it is manufactured.

- **In the case of hot finished pipe**, no heat treatment is required. As during the manufacturing, Pipe temp. remain in the range of heat treatment temperature till the final size and thickness are achieved
- **In the case of Cold finished pipe**, heat treatment is required as per applicable ASTM standard. The cold finished pipe is either cold drawn or temperature is not in maintained in the standard specified range during the manufacturing.

Different heat treatment methods are used for different grade of the pipe material. These heat treatment methods are

- Normalizing
- Quenching
- Tempering
- Solution Annealing
- Stress relieving
- Or it is a Combination of above

7. Product analysis – Chemical & Mechanical Testing

Metallurgical Tests confirm the chemical requirements of pipe are as per the material standard.

- Metallurgical Tests are normally known as Micro and Macro testing.
- Micro Analysis or Chemical Analysis of
 - Raw material
 - Product

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