



Designation: A862/A862M – 98 (Reapproved 2020)

Standard Practice for Application of Asphalt Coatings to Corrugated Steel Sewer and Drainage Pipe¹

This standard is issued under the fixed designation A862/A862M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This practice covers the post coating of corrugated steel pipe and corrugated structural steel plate with asphalt materials. This practice is intended for shop-applied coating only.

1.2 The values stated in either inch-pound units or SI units shall be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, use each system independently of the other, without combining values in any way. The SI units are shown in brackets in the text for clarity, but they are the applicable values when the application is to be performed using SI units.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

A849 Specification for Post-Applied Coatings, Pavings, and Linings for Corrugated Steel Sewer and Drainage Pipe

3. Significance and Use

3.1 Asphalt coating is used to provide additional protection for corrugated steel products (product) in corrosive or abrasive environments, or both.

¹ This practice is under the jurisdiction of ASTM Committee A05 on Metallic-Coated Iron and Steel Products and is the direct responsibility of Subcommittee A05.17 on Corrugated Steel Pipe Specifications.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

4. Classification

4.1 This practice covers three separate and distinct classifications of coatings. The general conditions under which these coatings are used are described in Specification A849.

4.1.1 *Classification A, Asphalt Coated*—A uniform coating is applied to the interior and exterior of the product.

4.1.2 *Asphalt Coated with Paved Invert* :

4.1.2.1 *Classification B1, Asphalt, Half Coated with Paved Invert*—A uniform coating is applied to the interior and exterior of the pipe covering at least 50 % of the circumference on the lower portion of the pipe as installed, and then a paving is applied on the lower portion of the interior of the pipe as installed (the invert) to provide a smooth flow line.

4.1.2.2 *Classification B2, Asphalt, Fully Coated with Paved Invert*—A uniform coating is applied to the interior and exterior of the pipe, and then a paving is applied on the lower portion of the interior of the pipe as installed (the invert) to provide a smooth flow line.

4.1.3 *Classification C, Asphalt Coated and Lined*—A uniform coating is applied to the interior and exterior of the pipe, and then a lining is applied to fill the corrugations on the full interior of the pipe to provide a smooth interior.

NOTE 1—This coating is sometimes referred to as any of the following: asphalt coated and lined, asphalt coated and fully paved, asphalt coated and 100 % paved, or asphalt coated smooth flow. The term “bituminous” is sometimes used instead of asphalt.

5. Materials

5.1 The coating and lining material shall be in conformance with the requirements for asphalt material in Specification A849.

6. Tank Control and Maintenance

6.1 *Tank Temperature*—The asphalt temperature in the tank shall be maintained between 392 and 410 °F [200 and 210 °C] during the coating operation.

6.2 *Tank Cleanliness:*

6.2.1 The asphalt in the tank shall be kept free of contaminants such as dirt, drum paper, and asphalt drippings from the shop floor.

6.2.2 The asphalt tank shall be cleaned as necessary with a minimum frequency of once per year.