



# Standard Specification for Polyamide 11 Gas Pressure Pipe, Tubing, and Fittings<sup>1</sup>

This standard is issued under the fixed designation F2945; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope\*

1.1 This specification covers requirements and test methods for the characterization of polyamide 11 pipe, tubing, and fittings for use in fuel gas pipelines. The pipe and fittings covered by this specification are intended for use in the distribution and transmission of fuel gases.

1.1.1 This specification does not cover threaded pipe. Generic fusion guidelines are given in [Appendix X1](#). Design considerations are discussed in [Appendix X2](#). In-plant quality control programs are specified in [Annex A1](#).

1.2 The text of this specification references notes, footnotes, and appendixes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the specification.

NOTE 1—Heat fusion joining of PA11 pipe and fittings meeting the requirements of this standard is limited to PA11 pipe and fittings meeting the requirements of this standard. Heat Fusion joining of PA11 pipe and fittings meeting the requirements of this standard is not allowed to pipes and fittings made from any other thermoplastic materials (for example, PA12, PEs, PVCs, etc.).

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 The following is an index of the annexes and appendixes in this specification:

Annexes	Subject
<a href="#">Annex A1</a>	In-Plant Quality Control for sizes up to 12 in.
<a href="#">Annex A2</a>	PA-11 Butt Fusion Fittings
Appendixes	Subject
<a href="#">Appendix X1</a>	Butt Fusion Guidelines for PA-11 Piping
<a href="#">Appendix X2</a>	Design Consideration

1.5 *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.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standard-*

*ization 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:<sup>2</sup>

- [D543 Practices for Evaluating the Resistance of Plastics to Chemical Reagents](#)
- [D618 Practice for Conditioning Plastics for Testing](#)
- [D638 Test Method for Tensile Properties of Plastics](#)
- [D648 Test Method for Deflection Temperature of Plastics Under Flexural Load in the Edgewise Position](#)
- [D789 Test Method for Determination of Relative Viscosity of Concentrated Polyamide \(PA\) Solutions](#)
- [D790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials](#)
- [D792 Test Methods for Density and Specific Gravity \(Relative Density\) of Plastics by Displacement](#)
- [D1598 Test Method for Time-to-Failure of Plastic Pipe Under Constant Internal Pressure](#)
- [D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings](#)
- [D1600 Terminology for Abbreviated Terms Relating to Plastics](#)
- [D1898 Practice for Sampling of Plastics \(Withdrawn 1998\)<sup>3</sup>](#)
- [D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings](#)
- [D2290 Test Method for Apparent Hoop Tensile Strength of Plastic or Reinforced Plastic Pipe](#)
- [D2774 Practice for Underground Installation of Thermoplastic Pressure Piping](#)
- [D2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products](#)
- [D3418 Test Method for Transition Temperatures and Enthalpies of Fusion and Crystallization of Polymers by](#)

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.60 on Gas.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> The last approved version of this historical standard is referenced on [www.astm.org](http://www.astm.org).

\*A Summary of Changes section appears at the end of this standard

- Differential Scanning Calorimetry
- D4066 Classification System for Nylon Injection and Extrusion Materials (PA)
- F412 Terminology Relating to Plastic Piping Systems
- F1025 Guide for Selection and Use of Full-Encirclement-Type Band Clamps for Reinforcement or Repair of Punctures or Holes in Polyethylene Gas Pressure Pipe
- F1563 Specification for Tools to Squeeze-off Polyethylene (PE) Gas Pipe or Tubing
- F1733 Specification for Butt Heat Fusion Polyamide(PA) Plastic Fitting for Polyamide(PA) Plastic Pipe and Tubing
- F1973 Specification for Factory Assembled Anodeless Risers and Transition Fittings in Polyethylene (PE) and Polyamide 11 (PA11) and Polyamide 12 (PA12) Fuel Gas Distribution Systems
- F2138 Specification for Excess Flow Valves for Natural Gas Service
- F2145 Specification for Polyamide 11 (PA 11) and Polyamide 12 (PA12) Mechanical Fittings for Use on Outside Diameter Controlled Polyamide 11 and Polyamide 12 Pipe and Tubing
- F2600 Specification for Electrofusion Type Polyamide-11 Fittings for Outside Diameter Controlled Polyamide-11 Pipe and Tubing
- F2897 Specification for Tracking and Traceability Encoding System of Natural Gas Distribution Components (Pipe, Tubing, Fittings, Valves, and Appurtenances)
- 2.2 *ANSI Standards:*<sup>4</sup>
- B 16.40 Manually Operated Thermoplastic Gas Shutoffs and Valves in Gas Distribution Systems
- B 31.8 Gas Transmission and Distribution Piping Systems
- 2.3 *Federal Specifications:*<sup>5</sup>
- Fed. Std. No. 123 Marking for Shipment (Civil Agencies)
- OPS Part 192 Title 49, Title 49 Code of Federal Regulations
- 2.4 *Military Standards:*<sup>6</sup>
- MIL-STD-129 Marking for Shipment and Storage
- MIL-STD-1235 (ORD) Single- and Multi-Level Continuous Sampling Procedures and Tables for Inspection by Attributes
- 2.5 *ISO Standards:*<sup>7</sup>
- ISO 75–1 Plastics - Determination of temperature of deflection under load - Part 1: General test method
- ISO 75–2 Determination of temperature of deflection under load - Part 2: Plastics and ebonite
- ISO 179/1eA Determination of Charpy impact properties. Non-instrumented impact test
- ISO 527–1 Determination of tensile properties - Part 1: General principles
- ISO 527–2 Determination of tensile properties - Part 2: Test conditions for moulding and extrusion plastics

- ISO 1183 Methods for determining the density of non-cellular plastics - Part 1: Immersion method, liquid pycnometer method and titration method
- ISO 22621 Part 1 Plastics piping systems for the supply of gaseous fuels for maximum operating pressure up to and including 2 MPa (20 bar)–Polyamide (PA): General
- ISO 13478 Thermoplastics pipes for the conveyance of fluids- Determination of resistance to rapid crack propagation (RCP) - Full-scale test (FST)
- 2.6 *Plastic Pipe Institute:*<sup>8</sup>
- PPI TR3 Policies and Procedures for Developing Hydrostatic Design Basis (HDB), Pressure Design Basis (PDB), Strength Design Basis (SDB), and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials or Pipe
- PPI TR4 Hydrostatic Design Bases and Maximum Recommended Hydrostatic Design Stresses for Thermoplastic Piping Materials
- PPI TN7 Nature of Hydrostatic Stress Rupture Curves
- PPI TR9 Recommended Design Factors for Pressure Applications of Thermoplastic Pipe Materials
- PPI TR-45 Butt Fusion Joining Procedures for Field Joining of Polyamide-11

### 3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology F412, and abbreviations are in accordance with Terminology D1600, unless otherwise specified.

3.2 The gas industry terminology used in this specification is in accordance with ANSI B31.8 or CFR OPS Part 192 Title 49, unless otherwise indicated.

3.3 The term *pipe* used herein refers to both pipe and tubing unless specifically stated otherwise.

#### 3.4 *Definitions of Terms Specific to This Standard:*

3.4.1 *re-rounding equipment, n*—equipment used to reform the pipe and permanently reduce ovality to 5 % or less.

3.4.2 *rounding equipment, n*—equipment, devices, clamps, and so forth, used to temporarily hold the pipe round while out-of-roundness measurements are made, or a joining procedure (heat fusion, electrofusion, or mechanical) is performed.

3.4.3 *standard thermoplastic material designated code, n*—the pipe material designation code shall consist of the abbreviation for the polyamide (PA) followed by Arabic numerals which describe the short term properties in accordance with Classifications from Table 2 followed by the hydrostatic design stress for water at 73.4 °F (23 °C) in units of

<sup>8</sup> Available from National Fire Protection Association (NFPA), 1 Batterymarch Park, Quincy, MA 02169-7471, <http://www.nfpa.org>.

TABLE 1 Sustained Pressure

Test Temperature	Min Hr.	PA 32312 Hoop Stress	PA 32316 Hoop Stress
73 ± 3.6 F (23 ± 2 C)	1000 hr	2800 psi (19 MPa)	3200 psi (22 MPa)
176 ± 3.6F (80 ± 2 C)	100 hr	1850 psi (12.7 MPa)	1850 psi (12.7 MPa)

<sup>4</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

<sup>5</sup> DLA Document Services Building 4/D 700 Robbins Avenue Philadelphia, PA 19111-5094 <http://quicksearch.dla.mil/>

<sup>6</sup> Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, Case postale 56, CH-1211, Geneva 20, Switzerland, <http://www.iso.ch>.

<sup>7</sup> Available from Plastics Pipe Institute (PPI), 105 Decker Court, Suite 825, Irving, TX 75062, <http://www.plasticpipe.org>.

**TABLE 2 D4066–94b Classifications (dry as molded)**

Classification	ASTM Test Method	ISO Test Method	Designation
PA			Polyamide
3 (group)			PA11
2 (class)			Heat stabilized
3 (grade)			
Relative Viscosity, min.	D789		1.83
Melting Point, °C	D3418, DTA or DSC		185 -195
Specific Gravity	D792	ISO 1183	1/03-1.06
Tensile strength, min. (MPa)	D638	ISO 527-1 and ISO 527-2	48
Elongation (ultimate), %, min.	D638		200
Flexural Modulus, Mpa	D790	ISO 527-1 and ISO 527-2	900
Izod Impact Resistance, J/m2, min		ISO 179/ 1eA	55
Deflection temperature, min at 1.8 Mpa, min °C	D648	ISO 75-1 and 75-2	40
Moisture, as received, max.	D789		0.08

100 psi with any decimal figures dropped. Where the hydrostatic design stress code contains less than two figures, a zero is used before the number. Thus, a complete material designation code shall consist of two letters and five figures for polyamide 11 materials. For example, PA 32316 is a polyamide 11 with a 1600 psi design stress for water at 73.4 °F (23 °C). The hydrostatic design stresses for gas are not used in this designation code.

3.4.4 *thermoplastic pipe dimension ratio (DR), n*—the ratio of pipe diameter to wall thickness. It is calculated by dividing the specified outside diameter of the pipe, in inches, by the minimum specified wall thickness, in inches. The standard dimension ratio (SDR) is a common numbering system which is derived from the ANSI preferred number series R 10.

3.4.5 *toe-in, n*—a small reduction of the outside diameter at the cut end of a length of thermoplastic pipe.

#### 4. Requirements for Materials

4.1 *General*—The polyamide 11 material used to make pipe and fittings shall be virgin or reworked material (see 4.5) and shall have a Plastics Pipe Institute (PPI) long-term hydrostatic design stress and hydrostatic design basis rating as determined per PPI TR3 and PPI TR4.

4.2 *Classification*—Polyamide materials suitable for use in the manufacturing of pipe and fittings under this specification shall be classified in accordance with Classification D4066-94b, as shown in Table 2.

4.3 *Short- and Long-Term Properties*—Polyamide 11 pipe and fittings shall be made from a Polyamide 11 material which also satisfies the combinations of short- and long-term property requirements shown in Table 3.

4.4 *Resistance to Rapid Crack Propagation (RCP) for Materials*—The material classification (formulation) used in the manufacture of pipe and fittings under this specification

shall be tested for resistance to failure by RCP in accordance with 6.6. The data obtained shall be made available upon request without limitations on disclosure, and shall not subsequently be subject to disclosure limitations when used by others. The values obtained are applicable to all pipes with the wall thickness of the pipe tested and all thinner wall pipes.

4.5 *Rework Material*—Clean PA11 rework material of the same commercial designation, generated from the manufacturer’s own pipe and fitting production shall not be used unless the pipe and fitting produced meet all the requirements of this specification. The use of these PA11 rework materials shall be governed by the requirements of 4.6 and the principals of PPI TN-30/2006. In pipe, rework materials shall be limited to a maximum of 30 % by weight.

4.6 *Documentation*—A documentation system to allow for traceability of raw materials including percentage and material classification (or designation, if applicable) of rework materials used in the manufacture of the pipe product meeting the requirements of this specification shall exist and be supplied to the purchaser, if requested.

#### 5. Requirements for Pipe and Fittings

5.1 *General*—Pipe shall be supplied in either coils or straight lengths. Any pipe supplied in coils must meet the same requirements before and after coiling.

5.2 *Workmanship*—The pipe and fittings shall be homogeneous throughout and free of visible cracks, holes, foreign inclusion, blisters, and dents, or other injurious defects. The pipe and fittings shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

##### 5.3 Pipe and Tubing Dimensions and Tolerances:

5.3.1 *Dimension*—The dimensions shall be specified by wall thickness and outside diameter.

5.3.1.1 *Diameters*—The outside diameter shall meet the requirements given in Table 4 or Table 5 when measured in accordance with 6.5.

5.3.1.2 *Toe-In*—When measured in accordance with 6.5.1.1, the outside diameter at the cut end of the pipe shall not be more than 1.5 % smaller than the undistorted outside diameter. Measurement of the undistorted outside diameter shall be made no closer than 1.5 pipe diameters or 11.8 in. (300 mm),

**TABLE 3 Short and Long Term Property Requirements**

PA Material Designation Code	Short-Term in Accordance with Table 2	Long-Term in Accordance with D2837
PA32312	PA323	HDB of 2500 psi for 73 °F (23 °C)
PA32316	PA323	HDB of 3150 psi for 73 °F (23 °C)