

DELAWARE MATERIAL SPECIFICATION

CORRUGATED METAL PIPE (ALUMINUM) MS 207B

1. **SCOPE**

This specification covers the quality of aluminum corrugated pipe and fittings.

2. **PIPE**

Aluminum corrugated pipe and fittings shall conform to the requirements of ASTM B-745 or B-790 for the specified pipe sheet thickness, shape, type, fabrication method. When close riveted pipe is specified: (1) the pipe shall be fabricated so that the rivet spacing in the circumferential seams shall not exceed 3 inches, except that 12 rivets will be sufficient to secure the circumferential seams in 12-inch pipe; and (2) in those portions of the longitudinal seams that will be covered by the coupling bands the rivets shall have finished flat heads or the rivets and holes shall be omitted and the seams shall be connected by welding to provide a minimum of obstruction to the seating of the coupling bands.

3. **COATINGS**

Coatings described herein, unless specified otherwise, refer equally to both the inside and outside pipe surfaces.

Bituminous coatings, when specified shall conform to the requirements of ASTM A-849.

4. **COUPLING BANDS**

Coupling bands are to be provided for each section of pipe. The hardware for fastening the coupling band tightly to the connecting pipe shall be fabricated to permit tightening sufficiently to provide the required joint tensile strength and, if required—watertightness, without failure of its fastening.

Gaskets, if specified, are to be provided for each coupling band. The fabrication of coupling bands and fastening hardware, in addition to the

above, shall be sufficient to provide the required gasket seating without warping, twisting or bending.

Gaskets provided with connecting bands meeting requirements for special joints in erodible soil conditions shall be as specified in ASTM A-760.

5. **FITTINGS**

Fittings shall be made from sheet aluminum conforming to ASTM B-744. The coatings of fittings shall be the same as that specified for the contiguous corrugated aluminum pipe.

Fittings that are welded during fabrication shall be done in good workman-like manner and finished leaving a continuous smooth surface. Aluminum welding electrodes used shall conform to the requirements of Aluminum Welding Society Specification AWS A5.10, "Specification for Aluminum and Aluminum Alloy Welding Rods and Bare Electrodes." Welded surfaces and adjacent surfaces damaged during welding shall be treated by removal of all weld splatter. The affected surface shall be cleaned to bright metal by sand blasting, power disk sanding, or wire brushing. The cleaned area shall extend at least one-half inch into the undamaged section of the coated area. Within 24 hours of completion of surface preparation all treated surfaces shall be painted with two (2) coats of chromate rich primer and allowed to dry prior to exposure to weathering conditions.