

Mannesmann Tube Company, Limited

51 VICTORIA SQUARE

MONTREAL

Specification

FOR

Mannesmann Spigot and Faucet Joint

Lapwelded Steel Pipes

SPECIFICATION

METHOD OF MANUFACTURE

The pipes are lapwelded by the water gas process.

KIND OF STEEL

Open hearth, basic steel is used for the manufacture of the pipes. The physical qualities of the steel are as follows:

Tensile Strength of from 22 to 27 tons per square inch,
Elongation at least 20% in an 8" test bar,
Reduction of area 50% of the ultimate tensile strength.

TESTING

If not otherwise specified, each pipe is subjected to a test pressure of double the working pressure.

COATING

After the pipes are re-heated to about 300 degrees Fahrenheit, they are dipped into a bath of specially composed asphaltic solution (Mannesmann Patent solution). The solution is burnt into the inner and outer pipe surfaces and will not crack off, even if the pipes are bent or knocked about.

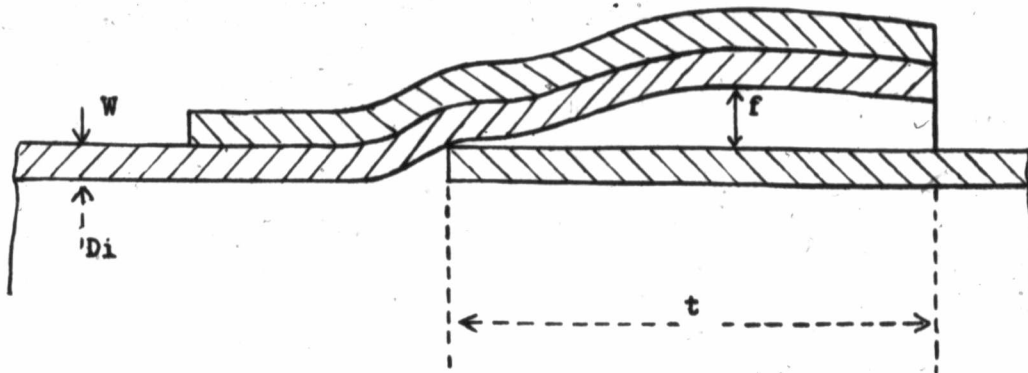
WRAPPING

After asphaltting the pipes are wrapped in a jute cloth which has been drawn through the asphaltic solution. The wrapping is done mechanically, the edges of the jute stripes are overlapping at least $\frac{1}{2}$ " wide. The wrapping is absolutely adhesive and impenetrable. A sufficient amount of asphalt and wrapping will be supplied with the pipes free of charge, in order to cover the joints after caulking and to repair any damage to the wrapping.

SOCKETS

The sockets are reinforced over the whole length by a shrunken-on ring and is sufficiently strong and stable to allow of driving home the hemp and lead in the proper way, i.e., the sockets will not vibrate or get deformed during the caulking process. The sockets are of ample depth and width required for proper caulking.

MANNESMANN LAPWELDED SPIGOT AND FAUCET STEEL PIPES
(REINFORCED SOCKET)



INTERNAL DIAMETER	PACKING SPACE		LIGHT SECTION			MEDIUM SECTION		
	LENGTH	WIDTH	THICKNESS OF PIPE WALL	APPROX. WEIGHT PER FOOT	PRICES PER FOOT	THICKNESS OF PIPE WALL	APPROX. WEIGHT PER FOOT	PRICES PER FOOT
Di.	t	f	w	lbs.	\$	w	lbs.	\$
14"	4½"	.355"	15/64"	40		.256"	44	
15"	4½"	.355"	15/64"	45		.256"	49	
16"	4½"	.355"	15/64"	46		.256"	50	
18"	4¾"	.355"	15/64"	54		.256"	58	
20"	5"	.375"	15/64"	60		.256"	64	
22"	5⅛"	.375"	1/4"	70		.275"	75	
24"	5¼"	.375"	1/4"	77		.275"	85	
26"	5½"	.395"	17/64"	86		.296"	95	
28"	5½"	.395"	17/64"	93		.296"	103	
30"	5¾"	.395"	9/32"	105		.296"	110	
33"	5¾"	.415"	19/64"	122		.315"	128	
36"	6"	.415"	19/64"	133		.315"	141	

LENGTH

Between 20 and 40 feet according to specification.

WEIGHTS

The weight given includes wrapping, pipes without wrapping about 7 to 8% less weight according to size of pipe.