

Tolerances for Diameter of Pipe Body

Size	Tolerance (with respect to specified outside diameter)
<2-3/8"	+0.016", -0.031" (+0.41mm, -0.8mm)
>2-3/8" and 4-1/2" Continuous welded	+/- 1.00%
>2-3/8" and <20"	+/-0.75%
>20" Seamless	+/-1.00%
>20" and <36 Welded	+0.75%, -0.25%
>36" Welded	+1/4", -1/8" (+6.4mm, -3.2mm)

Note:

In the event that the pipes are to be hydrostatically tested to pressures above the standard test pressures, other tolerances may be agreed upon between the manufacturer and the purchaser

Tolerances for Diameter of Pipe End

Size	Minus Tolerance	Plus Tolerance	End-to-end Tolerance	Diameter Axis Tolerance (percent of specified OD)	Max Differential between min & max diameters applies only to pipe with D/t<75
<10-3/4"	1/64" (0.4mm)	1/16" (1.6mm)	-	-	-
>10-3/4" and <20"	1/32" (0.8mm)	3/32" (2.4mm)	-	-	-
>20" and <42"	1/32" (0.8mm)	3/32" (2.4mm)	Note 1	+/- 1%	<0.500" (12.7mm)
>42"	1/32" (0.8mm)	3/32" (2.4mm)	Note 1	+/- 1%	<0.625" (15.9mm)

Notes:

- *1. The average diameter of the pipe shall not differ by more than 3/32" (2.4mm) from that of the other end.
- *2. Out-Of-Roundness tolerance apply to max and min diameters as measured with a bar gauge, caliper or device that measures actual max and min diameters.

Tolerances for Wall Thickness

Size	Type of Pipe	Tolerance (Percent of specified wall thickness)	
		Grade B or Lower	Grade X42 or higher
<2-7/8"	All	+20.0, -12.5	+15.0, - 12.5
>2-7/8" and <20"	All	+15.0, - 12.5	+15.0, - 12.5
>20"	Welded	+17.5, - 12.5	+19.5, - 8.0
>20"	Seamless	+15.0, - 12.5	+17.5, - 10.0

Notes:

If negative tolerances smaller than those listed above are required by the purchaser, the positive tolerance shall be increased to the applicable total range in percent less the negative tolerance of the wall thickness