

Tabulation of Differences Between PSL 1 and PSL 2

Grade Range	A25 through X70	Gr B through X80	Table I
Size range	0.405 through 80	4-1/2 through 80	Table I
Type of pipe ends	Plain-end, Threaded-end, Bevelled-end, special coupling pipe	Plain-end	Table I
Seam welding	All methods; continuous welding limited to Grade A25	All methods except continuous and laser welding	Table I
Electric welds: welder frequency	No Minimum	100 kHz minimum	5.1.3.3.2
Heat treatment of electric welds	Required for grades > X42	Required for all grades (Gr B through X80)	5.1.3.3.1; 5. J .3.3.2: 6.2.7
Chemistry: max C for seamless pipes	0.28% for grades > Gr B	0.24%	Tables 2A, 2B
Chemistry: max C for welded pipes	0.26% for grades > Gr B	0.22%	Tables 2A, 2B
Chemistry: max P	0.030% for grades > A	0.025%	Tables 2A, 2B
Chemistry: max S	0.030%	0.015%	Tables 2A, 2B
Carbon equivalent	Only when purchaser specifies SR18	Maximum required for each grade	4.2: 4.3: 6.1.3: SR15.1
Yield strength, maximum	None	Maximum for each grade	Tables 3A, 3B
UTS, maximum	None	Maximum for each grade	Tables 3A, 3B
Fracture Toughness	None required	Required for all grades	6.2.6; 9.3.5: 9.8.4; 9.10.7;
Non-destructive inspection of seamless pipes	Only when purchaser specifies SR4	SR4 mandatory	Table 14 9.7.2.6
Repair by welding of pipe body, plate and skelp	Permitted	Prohibited	5.3.2; 9.7.6: B.1; B.2
Repair by welding of weld seams without filler metal	Permitted by agreement	Prohibited	4.3; 9.7.4.4; 9.7.6: B.1.2; B.4
Certification	Certificates when specified per SR15	Certificates (SR15.1) mandatory	12.1
Traceability	Traceable only until all tests are passed, unless SR15 is specified	Traceable after completion of tests (SR15.2) mandatory	5.6

Notes:

*PSL1 & PSL2 requirements are given in the latest edition of API 5L specifications.