

Under Revision See DK93291

Superseded by AS/NZS 2544:1995

AS 2544—1982
UDC 669.131.6 : 621.643.4

Australian Standard
2544—1982

**GREY IRON PRESSURE
PIPES AND FITTINGS**



STANDARDS ASSOCIATION OF AUSTRALIA

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This Australian standard was prepared by Committee WS/16, Cast Iron Pressure Pipes and Fittings. It was approved on behalf of the Council of the Standards Association of Australia on 1 April 1982 and published on 9 August 1982.

The following interests were represented on the committee responsible for the preparation of this standard:

Australian Gas Association
Brisbane City Council
Confederation of Australian Industry
Department of Housing and Construction
Department of Public Works, N.S.W.
Engineering and Water Supply Department, S.A.
Gas and Fuel Corporation of Victoria
Hunter District Water Board
Institution of Engineers, Australia
Metal Trades Industry Association of Australia
Melbourne and Metropolitan Board of Works
Metropolitan Water Sewerage and Drainage Board, N.S.W.
Metropolitan Water Supply Sewerage and Drainage Board, W.A.
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This standard was issued in draft form for comment as DR 79088.

AUSTRALIAN STANDARD

GREY IRON PRESSURE PIPES AND FITTINGS

AS 2544—1982

First published (as AS A145—Pipes)	1965
Revised	1970
Revised and issued as AS 1723	1975 ✓
First published (as AS A146—Fittings).. ..	1965
Revised	1970
Revised and issued as AS 1488	1974 ✓
AS 2544 first published	1982

0 AUG 1982

PUBLISHED BY THE STANDARDS ASSOCIATION OF AUSTRALIA
STANDARDS HOUSE, 80 ARTHUR ST, NORTH SYDNEY, N.S.W.



ISBN 0 7262 2555 X

PREFACE

This standard was prepared by the Association's Committee on Cast Iron Pressure Pipes and Fittings as both a revision and a combination of AS 1723—1975, Centrifugally Cast Grey Iron Pressure Pipes (Excluding Pipes with Bolted Gland Joints), and AS 1488—1974, Cast Grey Iron Fittings for Pressure Pipes (Excluding Bolted Gland Joints). It was considered that grey iron pressure pipes and fittings should be incorporated in the one standard for ease of reference. Both of the aforementioned standards are superseded by this standard.

The changes to AS 1723 are basically editorial to cover amalgamation with AS 1488 which in turn has been extensively revised in order to specify only those fittings which are most commonly used in the water supply industry.

To achieve this rationalization, the variety of fittings has been reduced in line with international standards practice, and it is anticipated that economies will result accordingly throughout the industry. Details of fittings not dealt with by this standard must be specified by the purchaser.

As Class B and D fittings specified in AS 1488 are not commonly used with water supply pressure pipes, only Class C fittings from that standard are included in this standard.

Fittings dealt with by this standard are intended primarily for use with water supply pressure pipes having compatible outside diameters, but can be used with other pressure pipes by means of suitable adaptors. Tables in this standard relate only to the dimensions of the bodies and spigot ends of fittings.

This standard sets out manufacturing requirements and dimensions for pipes and fittings. The hydrostatic test pressures specified in Clause 3.8 are intended primarily to detect casting flaws and bear no relation to safe working pressures for the pipes or fittings. As stated in the Foreword, no attempt has been made to relate wall thickness of pipes and fittings to any particular working pressure.

The Association acknowledges with gratitude the work done by the Melbourne and Metropolitan Board of Works in the preparation of the drawings and tables incorporated in this standard.

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CONTENTS

	<i>Page</i>		<i>Page</i>
FOREWORD	4	5.10 Risers, Hydrant—Sizes 80 and 100 ..	21
SECTION 1. SCOPE AND GENERAL		5.11 Tapers—Sizes 100 to 600 ..	22
1.1 Scope	5	5.12 Tees, Air Valve and Hydrant— socket/spigot	24
1.2 Referenced Documents	5	5.13 Tees, Air Valve and Hydrant— spigot/spigot	25
1.3 Definitions	5	5.14 Tees, Scour—socket/socket	26
1.4 Class Designation	5	5.15 Tees, Scour—spigot/spigot	27
SECTION 2. MANUFACTURE AND FINISH		5.16 Tees, Flange	28
2.1 Quality of Metal	6	5.17 Tees, Socket	29
2.2 Mode of Casting	6	5.18 Tees—socket/socket/flange	30
2.3 Heat Treatment of Pipes	6	5.19 Tees, Spigot	31
2.4 Workmanship and Finish	6	5.20 Tees—spigot/spigot/flange	32
SECTION 3. INSPECTION AND TESTING		5.21 Thrust Pads	33
3.1 Inspection	7	5.22 Jointing Lugs	34
3.2 Tests of Metal	7	5.23 Lifting Lugs	35
3.3 Test Specimens for Tensile and Hard- ness Testing	7	SECTION 6. DIMENSIONS AND TOLERANCES ON SPIGOT AND SOCKET PIPES	
3.4 Frequency of Testing	7	6.1 Dimensions	36
3.5 Tensile Strength	7	6.2 Tolerances on Dimensions and Mass ..	36
3.6 Hardness	7	SECTION 7. PIPES WITH SCREW-ON FLANGES	
3.7 Retests for Tensile Strength and Hardness	7	7.1 General	38
3.8 Hydrostatic Pressure Tests	8	7.2 Materials	38
SECTION 4. JOINTS		7.3 Dimensions and Tolerances	38
4.1 General	10	7.4 Hydrostatic Pressure Test	38
4.2 Sockets	10	SECTION 8. BOLT-ON PUDDLE FLANGES ON PIPE	
4.3 Spigots	10	8.1 General	40
4.4 Flexible Joints	10	8.2 Materials	40
4.5 Integral Flanges	10	SECTION 9. COATING AND LINING	
SECTION 5. DIMENSIONS AND TOLERANCES ON FITTINGS		9.1 General	41
5.1 Dimensions	11	9.2 Coatings	41
5.2 Tolerance on Dimensions and Mass ..	11	9.3 Linings	41
DIMENSIONAL TABLES		SECTION 10. MARKING	
5.1 Barrel and Spigot for Fittings	12	10.1 General	43
5.2 Bends, Flange—Sizes 100 to 600	13	10.2 Pipes	43
5.3 Bends, Socket—Sizes 100 and 150	14	10.3 Fittings	43
5.4 Bends, Socket—Sizes 200 to 600	15	10.4 Screw-on Flanges	43
5.5 Bends, Spigot—Sizes 100 and 150	16	APPENDICES	
5.6 Bends, Spigot—Sizes 200 to 600	17	A Purchasing Guidelines	44
5.7 Caps	18	B Symbols	46
5.8 Connectors	19		
5.9 Plugs	20		

STANDARDS ASSOCIATION OF AUSTRALIA

Australian Standard
for
GREY IRON PRESSURE PIPES AND FITTINGS

FOREWORD

The necessary thickness for cast grey iron pipes and fittings depends on several factors including the following:

- (a) The internal pressure to which the pipes and fittings are likely to be subjected, including pressure due to water hammer.
- (b) The external loads expected to be applied to the pipes and fittings when laid, depending on the depth of the pipeline in the ground and other pipelaying conditions.
- (c) Stresses due to expansion and contraction.
- (d) The stresses incurred during handling of the pipe and fittings.
- (e) Any necessary allowance for corrosion.

Because the effect of many of these factors cannot be precisely anticipated, this standard does not attempt to relate the specified thickness of the pipe and fitting to particular internal working pressures.

It is the responsibility of the designer of the pipeline to evaluate the effect of the prevailing factors and to ensure that pipes and fittings manufactured to this standard are suitable for the proposed application. Fittings of higher strength may be achieved by the use of a higher grade of cast iron or greater wall thickness.

SECTION 1. SCOPE AND GENERAL

1.1 SCOPE. This standard specifies requirements for grey iron pressure pipes centrifugally cast in metal moulds and grey iron fittings of nominal sizes up to and including DN 600.

The pipes and fittings are intended primarily for the conveyance of water under pressure, but they may be used for the conveyance of sewage or other fluids.

This standard specifies three classes of pipe on the basis of wall thickness and one class of fitting, but the standard does not imply any correlation between the wall thicknesses specified and any particular working pressure.

NOTES:

1. Guidelines to purchasers on requirements that must or may need to be agreed upon at the time of the enquiry or order, are detailed in Appendix A.
2. Cast grey iron fittings complying with this standard are compatible with centrifugally cast ductile iron pipes manufactured in accordance with AS 2280.
3. Purchasers are advised to check with the manufacturer as to the availability of grey iron pipes complying with this standard. See Appendix A, Paragraph A3 (a).
4. Nominal size 525 is not a standard cast iron pipe size in Australia, and therefore is not included in pipe tables.

1.2 REFERENCED DOCUMENTS. The following standards are referred to in this standard:

- AS 1111 ISO Metric Hexagon Commercial Bolts and Screws
- AS 1315 Specification and Methods of Test for Portland Cement
- AS 1391 Methods for Tensile Testing of Metals
- AS 1465 Dense Natural Aggregates for Concrete
- AS 1646 Rubber Joint Rings for Water Supply, Sewerage and Drainage Purposes
- AS 1816 Method for Brinell Hardness Test Part 1—Testing of Metals
- AS 1830 Grey Iron Castings
- AS 2129 Flanges and Bolting for Pipes, Valves and Fittings
- BS 3148 Tests for Water for Making Concrete

1.3 DEFINITIONS. For the purpose of this standard, the following definitions apply:

1.3.1 Bulkhead testing condition — a condition of testing for a pipe or fitting whereby a test machine is used to anchor and seal the joints on the pipe or fitting being tested.

1.3.2 Coating — a corrosion-inhibiting medium applied to the external surface of a pipe or fitting.

1.3.3 Effective length — the overall length of a pipe or fitting measured along its centreline, but excluding the depth of any socket(s).

1.3.4 Fettling — the cleaning of castings, removal of fins, gates and the like, by chipping, grinding or other mechanical means.

1.3.5 Fitting — any casting intended for connection to a pressure pipeline, e.g. bend, cap, connector, plug, taper, tee. (See Appendix B for symbols for fittings.)

1.3.6 Free-end testing condition — a condition of testing for a flanged pipe or fitting whereby the flanged end or ends under test are fitted with a blanking piece without external restraint.

1.3.7 Lining — a medium applied to the internal surface of a pipe or fitting.

1.3.8 Mortar — cement mortar consisting of portland cement, inert aggregates and water.

1.3.9 Nominal size — the approximate internal diameter of a pipe or fitting and represented by the symbols DN and dn.

1.3.10 Test sample — a portion of material or a group of items selected from a batch or consignment by a sampling procedure.

1.3.11 Test specimen — a portion of material or a single item taken from the test sample for the purpose of applying a particular test.

1.3.12 Test piece — a prepared piece for testing, made from a test specimen by some mechanical operation.

1.4 CLASS DESIGNATION. Grey iron pipe shall be designated Class B, C or D on the basis of wall thickness (see Table 6.1).