



**American Water Works  
Association**

Errata to  
ANSI/AWWA C200-12  
Standard  
for

**Steel Water Pipe, 6 In. (150 mm) and Larger**  
*(August 2012)*

1. Add footnote 3 callout to Table 1, pg. 11, as follows:  
ASTM A139/A139M<sup>3</sup>
2. Change Sec. 4.11.3, page 21, to read:  
4.11.3 *Straightness*. The maximum deviation from a straight line, over the entire pipe length, shall be 0.2 percent of the pipe length.
3. Correct the AWS section numbers in Sec. 5.2.2.1, Items 4 and 5, page 29, as follows:
  4. Ultrasonic (UT) in accordance with AWS D1.1, Section 6, Part F, acceptance criteria in accordance with Part C, 6.13.1; or in accordance with ASME Section V, Article 4, acceptance criteria in accordance with ASME Section VIII, Div. 1, appendix 12; or API 5L, Annex E.
  5. Radiographic (RT) in accordance with AWS D1.1, Section 6, Part E, acceptance criteria in accordance with Part C, 6.12.1; or in accordance with ASME Section V, Article 2, acceptance criteria in accordance with ASME Section VIII, Div. 1, Part UW, UW-51, or UW-52 as applicable; or API 5L, Annex E.



**American Water Works  
Association**

The Authoritative Resource on Safe Water®

ANSI/AWWA C200-12  
(Revision of AWWA C200-05)

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*AWWA Standard*

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# Steel Water Pipe, 6 In. (150 mm) and Larger



Effective date: Sept. 1, 2012.

First edition approved by AWWA Board of Directors June 26, 1975.

This edition approved June 10, 2012.

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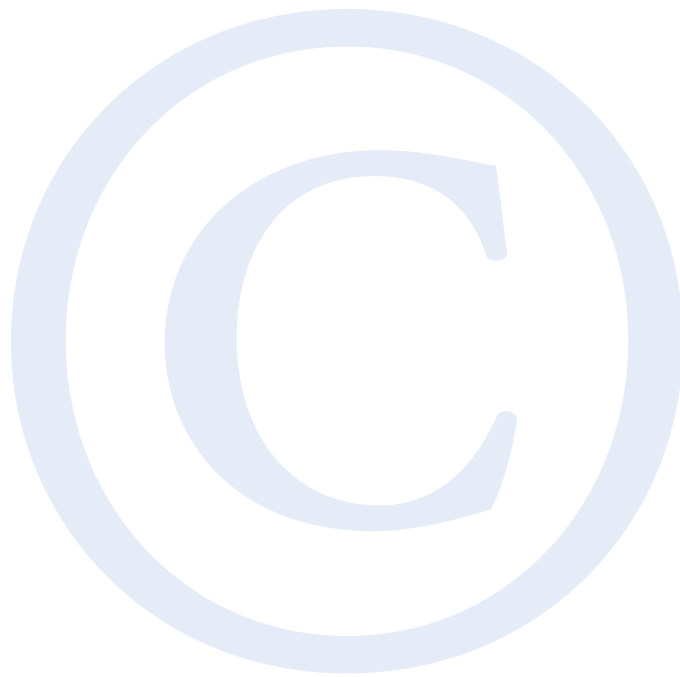
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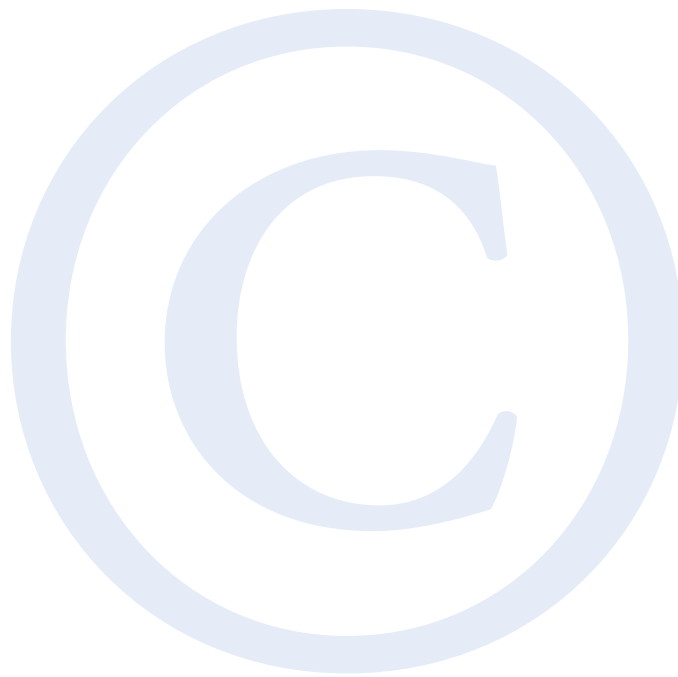
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## Foreword

*This foreword is for information only and is not a part of ANSI\*/AWWA C200.*

### **I. Introduction.**

I.A. *Background.* This standard covers butt-welded, straight-seam or spiral-seam steel pipe, 6 in. (150 mm) and larger, for transmission and distribution of water, including fabrication of pipe, requirements of welding operations, permissible variations of thickness and dimensions, preparation of ends, fabrication of special sections, inspection, and test procedures.

I.B. *History.* The first AWWA steel pipe standards issued were 7A.3 and 7A.4, published in 1940. Standard 7A.4 pertained to steel pipe smaller than 30 in. (750 mm) in diameter, and 7A.3 pertained to steel pipe 30 in. (750 mm) in diameter and larger. Subsequently, in recognition that some pipe used in water utility service was manufactured in steel mills rather than in a fabricator's shop, two new AWWA standards were issued in 1960. AWWA C201 replaced 7A.3 and pertained to all pipe, regardless of diameter, manufactured in a fabricator's shop from steel sheet or plate. The physical and chemical properties are properties of the sheet or plate from which the pipe is made. The properties are a function of the steel mill practice and are not affected significantly by fabricating procedures. AWWA C202 replaced 7A.4 and pertained to mill pipe, which is normally produced in a production pipe mill. The specified physical and chemical properties are those of the completed pipe. Physical testing is performed on the pipe rather than on the steel from which it originates. In many cases, the physical properties are significantly affected by the pipe-manufacturing procedure. AWWA C201 was revised in 1966, and AWWA C202 was revised in 1964. Both AWWA C201 and AWWA C202 were superseded by AWWA C200-75, approved by the AWWA Board of Directors on Jan. 26, 1975.

AWWA C200 includes all types and classes of steel pipe, 6 in. (150 mm) in diameter and larger, used in water utility service, regardless of the pipe manufacturing source. With adequate quality assurance, pipe manufactured in a fabricator's shop or in a steel pipe mill is suitable for water utility service.

By reference, AWWA C202 (which pertained to mill-type steel water pipe) included API<sup>†</sup> 5L and API 5LX pipe grades manufactured to API standards for high-pressure

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\* American National Standards Institute, 25 West 43rd Street, Fourth Floor, New York, NY 10036.

† American Petroleum Institute, 1220 L Street N.W., Washington, DC 20005.

applications. With the inclusion of ASTM A570/A570M and ASTM A572/A572M high-strength steels in AWWA C200-75, API high-pressure pipe was omitted from AWWA C200-75 as being redundant. API 5L and API 5LX pipe grades fully met all requirements of AWWA C200 and could be used for water utility applications if dictated by availability or other economic considerations.

AWWA C200-75 introduced design criteria for determination of wall thickness to meet internal pressure conditions. This facilitated the selection of the optimum combination of thickness and material for steel pipe.

Revisions in AWWA C200-86 included clarification of forming for lap joint ends and gasketed ends and testing of O-ring gaskets. Subsequent editions of this standard were approved by the AWWA Board of Directors on June 23, 1991; Feb. 2, 1997; and June 12, 2005. This edition was approved on June 10, 2012.

I.C. *Acceptance.* In May 1985, the US Environmental Protection Agency (USEPA) entered into a cooperative agreement with a consortium led by NSF International (NSF) to develop voluntary third-party consensus standards and a certification program for direct and indirect drinking water additives. Other members of the original consortium included the Water Research Foundation (formerly AwwaRF) and the Conference of State Health and Environmental Managers (COSHEM). The American Water Works Association and the Association of State Drinking Water Administrators (ASDWA) joined later.

In the United States, authority to regulate products for use in, or in contact with, drinking water rests with individual states.\* Local agencies may choose to impose requirements more stringent than those required by the state. To evaluate the health effects of products and drinking water additives from such products, state and local agencies may use various references, including

1. An advisory program formerly administered by USEPA, Office of Drinking Water, discontinued on Apr. 7, 1990.
2. Specific policies of the state or local agency.
3. Two standards developed under the direction of NSF, NSF/ANSI 60, Drinking Water Treatment Chemicals—Health Effects, and NSF<sup>†</sup>/ANSI 61, Drinking Water System Components—Health Effects.

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\* Persons outside the United States should contact the appropriate authority having jurisdiction.

† NSF International, 789 N. Dixboro Road, Ann Arbor, MI 48105.

4. Other references, including AWWA standards, *Food Chemicals Codex*, *Water Chemicals Codex*,\* and other standards considered appropriate by the state or local agency.

Various certification organizations may be involved in certifying products in accordance with NSF/ANSI 61. Individual states or local agencies have authority to accept or accredit certification organizations within their jurisdiction. Accreditation of certification organizations may vary from jurisdiction to jurisdiction.

Annex A, "Toxicology Review and Evaluation Procedures," to NSF/ANSI 61 does not stipulate a maximum allowable level (MAL) of a contaminant for substances not regulated by a USEPA final maximum contaminant level (MCL). The MALs of an unspecified list of "unregulated contaminants" are based on toxicity testing guidelines (noncarcinogens) and risk characterization methodology (carcinogens). Use of annex A procedures may not always be identical, depending on the certifier.

AWWA C200 does not address additives requirements. Thus, users of this standard should consult the appropriate state or local agency having jurisdiction in order to

1. Determine additives requirements, including applicable standards.
2. Determine the status of certifications by parties offering to certify products for contact with, or treatment of, drinking water.
3. Determine current information on product certification.

## **II. Special Issues.**

### *II.A. Advisory Information on Product Application.*

1. Basis of design. AWWA C200 pertains to the manufacture and testing of the steel-pipe cylinder. Coatings that protect against corrosion are referenced in Sec. 4.5. AWWA C604, *Installation of Buried Steel Water Pipe, 4 In. (100 mm) and Larger*, provides field installation guidelines. Overall design of steel pipelines is described in AWWA Manual M11, *Steel Water Pipe—A Guide for Design and Installation*.

Design of the wall thickness of steel pipe is primarily affected by internal pressure, including operating static and transient pressures. Other factors that may influence the designed wall thickness are external loads, including trench loading and earth fill; special physical loading, such as continuous-beam loading with saddle supports or ring girders; vacuum conditions; type of joint used; and practical considerations for handling, shipping, lining, and coating or similar operations.

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\* Both publications available from National Academy of Sciences, 500 Fifth Street, N.W., Washington, DC 20001.

The design techniques described in AWWA Manual M11 are used to determine required wall thicknesses of steel pipe. The purchaser may establish and specify a wall thickness determined to be satisfactory for all conditions, including internal pressure, trench loadings, special physical loadings, and handling. Selection of design stresses and deflection limits should be made with regard to the properties of the lining and coating materials used. The purchaser may alternatively specify the performance criteria for the pipeline, in which case the manufacturer, using AWWA standards, provides the wall-thickness calculations for purchaser acceptance. Performance criteria provided should include internal design pressures, external loading, and any other special conditions. The manufacturer is allowed to select materials and manufacturing processes within the limitations of this standard to produce pipe to the wall thickness required to additionally satisfy the specified performance criteria. This thickness should govern if it is greater than the wall thickness specified by the purchaser. Thickness tolerances for pipe are governed by the requirements of this standard.

2. Application. This standard describes the requirements for steel water pipe for use in water transmission and distribution under normal circumstances. It is the responsibility of the purchaser for each project to determine if any unusual circumstances related to the project require additional provisions that are not included in the standard. Such special conditions might affect design, manufacture, quality control, corrosion protection, or handling requirements.

3. Brittle fracture precautions. Sec. 4.7.2 provides test requirements for steel to ensure notch toughness. Under certain conditions where a restrained pipeline with welded lap joints will be used, notch toughness verification may be necessary.

4. Testing of special sections. Sec. 5.2.2 provides for nondestructive testing of the weld seams of special sections. This testing should be adequate for normal conditions previously discussed under 2., Application.

5. Roundness of pipe. The roundness of pipe during handling, shipping, joint makeup, and backfilling should be covered in the purchaser's documents. When requested, the pipe is delivered with internal bracing for shipping and handling purposes. Although not generally designed for such, this bracing can assist in limiting the maximum vertical deflection of the pipe during installation and backfilling operations. Bracing design for this purpose is the responsibility of the constructor.

**III. Use of This Standard.** It is the responsibility of the user of an AWWA standard to determine that the products described in that standard are suitable for use in the particular application being considered.

III.A. *Purchaser Options and Alternatives.* The following information should be provided by the purchaser.

1. Standard used—that is, ANSI/AWWA C200, Standard for Steel Water Pipe, 6 In. (150 mm) and Larger, of latest revision.
2. Whether compliance with NSF/ANSI 61, Drinking Water Treatment Components—Health Effects, is required.
3. A description or drawings indicating the diameter and total quantity of pipe required for each diameter.
4. Internal design pressure.
5. External design pressures and other special physical loadings.
6. Permeation requirements (Sec. 4.1).
7. Details of other federal, state or provincial, and local requirements (Sec. 4.2.1).
8. The drawings and calculations to be provided by the manufacturer if required (Sec. 4.3 and 4.4).
9. Protective coating if applicable (Sec. 4.5).
10. Specification of pipe or steel if there is a preference (Sec. 4.6), or desired physical properties for “ordering to chemistry only” (Section 3 and Sec. 4.7.3).
11. Minimum service temperature for toughness requirements (Sec. 4.7.2).
12. Wall thickness (Sec. 4.7.4).
13. Qualification code for manual welders (Sec. 4.10.3.1).
14. Length of pipe sections, random or specified lengths (Sec. 4.11.4).
15. Type of pipe ends (description or drawings) (Sec. 4.12).
16. Requirements for reports of tests of rubber-gasket materials (Sec. 4.12.6.3).
17. All special sections, indicating for each component part the dimensions or standard designation (Sec. 4.13) and the grade of material required (Sec. 4.14).
18. Instructions regarding inspection at place of manufacture (Sec. 5.1).
19. Method, acceptance criteria, location, and frequency of nondestructive testing to be used for special sections (Sec. 5.2.2.1)
20. Test reports if required (Sec. 5.4).
21. Requirements for marking, line diagrams, or laying schedules (Sec. 6.1).
22. Special handling requirements and allowable out-of-roundness (Sec. 6.2).
23. Affidavit of compliance if required (Sec. 6.3).

III.B. *Modification to Standard.* Any modification of the provisions, definitions, or terminology in this standard must be provided by the purchaser.

**IV. Major Revisions.** Major revisions made to the standard in this edition include the following:

1. Foreword, Special Issues, Sec. II.A. Advisory Information on Product Application. Paragraphs 2 and 3 were revised, the pipe wall thickness equation, Eq. F.1 was deleted, and additional information on roundness of pipe was added. Changes were made to reflect numerous changes in the body of the standard.

2. Foreword, Sec. III.A., Purchaser Options and Alternatives. A number of these items have been revised to reflect changes in the standard.

3. Section 3, Definitions. The definitions for nominal wall thickness and nominal weight per unit length (for bare pipe) have been deleted and replaced with a new definition for thickness.

4. The title of Sec. 4.2.2, Discontinuities, was changed to "Defects" to better reflect the actual items being referenced. Defects are unacceptable discontinuities.

5. Sec. 4.2.3, Repair of defects. An additional item was added addressing cut-outs for testing.

6. Sec. 4.3 and Sec. 4.4 have revised wording changes.

7. Sec. 4.6, Pipe Made to ASTM or API Requirements. This section was revised to update the ASTM specification requirements and to include an API specification requirement.

8. Sec. 4.7, Fabricated Pipe. Charpy impact testing was added with criteria as to when it is required. Criteria similar to ASME BPVC was added to clarify when Charpy testing is prudent.

9. Sec. 4.7.4 and 4.11.1, Thickness Determination sections, were clarified on what tolerances apply and when manufacturing tolerances apply.

10. Table 1. ASTM A139 material properties were added as well as ASTM A516 plate per current practice.

11. A new Figure 1, Charpy test evaluation, was added.

12. Old Sec. 4.9, General Requirements for Fabrication of ASTM Pipe, was deleted and is now covered in Sec. 4.6.

13. Sec. 4.9.1, Weld seams. Offset requirements were adjusted. The section was rewritten and a new Figure 3, Repair method by offset value and wall thickness, was added. The offset limits and allowable repairs were adjusted to be more closely aligned with other recognized codes and standards. Requirements for two repair methods were added to the section.

14. Sec. 4.10.2.1, Qualification, and 4.10.3.1, Qualification. Language was added to make Table 1 materials allowable when welding procedures are qualified to ASME Section IX. Typical steels used in the standard are currently not specifically listed in ASME.

15. Old Sec. 4.11.4, Welding operator tests, was deleted because of the contractual nature of the language.

16. Sec. 4.10.4.3, Bend-test specimens. Side bend for materials over  $\frac{3}{8}$  in. was added to bring the standard in line with acceptable ASTM bend-test criteria.

17. Sec. 4.10.4.6, Frequency of production weld tests, was revised for clarity.

18. Sec. 4.11.1, Section title, Thickness and weights, was changed to "Thickness," and the section was revised to describe thickness and tolerance in accordance with the definition and other requirements.

19. Sec. 4.11.3, Straightness, was changed from a 10-ft measurement to a full pipe length measurement for consistency with other pipe manufacturing standards and codes.

20. Sec. 4.12.6.2, Rubber gaskets, was revised to bring the gasket requirements up to current standards.

21. A new Sec. 4.12.6.3, Rubber gasket requirements, was added, splitting out the physical requirements for gaskets and adding requirements for ozone resistance and water immersion.

22. Sec. 4.12.6.4, Testing and certification. Additional information was added to the section on splices.

23. A new Sec. 4.12.6.5, Gasket dimensions and tolerances, was added.

24. A new Sec. 4.12.6.6, Gasket markings, was added.

25. Sec. 5.1.3, Rejection of pipe. A sentence was added stating that rejected pipe may be repaired or replaced.

26. Sec. 5.2.1, Hydrostatic testing of pipe. A minimum test time and a note about nondestructive tests in lieu of the hydrostatic test were added.

27. A new Sec. 5.2.1.2 was added regarding previously hydrostatically tested pipe.

28. Sec. 5.2.2, Testing of special sections. The references were updated, a hydrostatic method for testing special sections and an air test method for testing of collars, wrappers, etc., were added.

29. Old Sec. 5.2.2.3, Hydrostatic testing, was deleted. This section was rewritten and added to Sec. 5.2.2.

**V. Comments.** If you have any comments or questions about this standard, please call AWWA Engineering and Technical Services at 303.794.7711, FAX at 303.795.7603, write to the department at 6666 West Quincy Avenue, Denver, CO 80235-3098, or email at [standards@awwa.org](mailto:standards@awwa.org).



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**American Water Works  
Association**

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*AWWA Standard*

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# **Steel Water Pipe, 6 In. (150 mm) and Larger**

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## **SECTION 1: GENERAL**

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### **Sec. 1.1 Scope**

This standard describes electrically butt-welded straight-seam or spiral-seam pipe and seamless pipe, 6 in. (150 mm)\* in nominal diameter and larger, for the transmission and distribution of water or for use in other water system facilities.

### **Sec. 1.2 Purpose**

The purpose of this standard is to provide the minimum requirements for steel water pipe, 6 in. (150 mm) and larger, including materials and quality of work, fabrication of pipe, and special sections.

### **Sec. 1.3 Application**

This standard can be referenced in the purchaser's documents for steel water pipe, 6 in. (150 mm) and larger. The stipulations of this standard apply when this document has been referenced and then only to steel water pipe, 6 in. (150 mm) and larger.

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\* Metric conversions given in this standard are direct conversions of US customary units and are not those specified in the International Organization for Standardization (ISO) standards.