

(c) If any item is marked by die stamping, the die must have blunt or rounded edges that will minimize stress concentrations.

(d) Paragraph (a) of this section does not apply to items manufactured before November 12, 1970, that meet all of the following:

(1) The item is identifiable as to type, manufacturer, and model.

(2) Specifications or standards giving pressure, temperature, and other appropriate criteria for the use of items are readily available.

[Amdt. 192-1, 35 FR 17660, Nov. 17, 1970, as amended by Amdt. 192-31, 43 FR 883, Apr. 3, 1978; Amdt. 192-61, 53 FR 36793, Sept. 22, 1988; Amdt. 192-62, 54 FR 5627, Feb. 6, 1989; Amdt. 192-61A, 54 FR 32642, Aug. 9, 1989; 58 FR 14521, Mar. 18, 1993; Amdt. 192-76, 61 FR 26122, May 24, 1996; 61 FR 36826, July 15, 1996]

§ 192.65 Transportation of pipe.

In a pipeline to be operated at a hoop stress of 20 percent or more of SMYS, an operator may not use pipe having an outer diameter to wall thickness ratio of 70 to 1, or more, that is transported by railroad unless:

(a) The transportation is performed in accordance with API RP 5L1.

(b) In the case of pipe transported before November 12, 1970, the pipe is tested in accordance with subpart J of this part to at least 1.25 times the maximum allowable operating pressure if it is to be installed in a class 1 location and to at least 1.5 times the maximum allowable operating pressure if it is to be installed in a class 2, 3, or 4 location. Notwithstanding any shorter time period permitted under subpart J of this part, the test pressure must be maintained for at least 8 hours.

[Amdt. 192-12, 38 FR 4761, Feb. 22, 1973, as amended by Amdt. 192-17, 40 FR 6346, Feb. 11, 1975; 58 FR 14521, Mar. 18, 1993]

Subpart C—Pipe Design

§ 192.101 Scope.

This subpart prescribes the minimum requirements for the design of pipe.

§ 192.103 General.

Pipe must be designed with sufficient wall thickness, or must be installed with adequate protection, to withstand anticipated external pressures and

loads that will be imposed on the pipe after installation.

§ 192.105 Design formula for steel pipe.

(a) The design pressure for steel pipe is determined in accordance with the following formula:

$$P=(2 St/D)\times F\times E\times T$$

P=Design pressure in pounds per square inch (kPa) gauge.

S=Yield strength in pounds per square inch (kPa) determined in accordance with § 192.107.

D=Nominal outside diameter of the pipe in inches (millimeters).

t=Nominal wall thickness of the pipe in inches (millimeters). If this is unknown, it is determined in accordance with § 192.109.

Additional wall thickness required for concurrent external loads in accordance with § 192.103 may not be included in computing design pressure.

F=Design factor determined in accordance with § 192.111.

E=Longitudinal joint factor determined in accordance with § 192.113.

T=Temperature derating factor determined in accordance with § 192.115.

(b) If steel pipe that has been subjected to cold expansion to meet the SMYS is subsequently heated, other than by welding or stress relieving as a part of welding, the design pressure is limited to 75 percent of the pressure determined under paragraph (a) of this section if the temperature of the pipe exceeds 900 °F (482 °C) at any time or is held above 600 °F (316 °C) for more than 1 hour.

[35 FR 13257, Aug. 19, 1970, as amended by Amdt. 192-47, 49 FR 7569, Mar. 1, 1984; Amdt. 192-85, 63 FR 37502, July 13, 1998]

§ 192.107 Yield strength (*S*) for steel pipe.

(a) For pipe that is manufactured in accordance with a specification listed in section I of appendix B of this part, the yield strength to be used in the design formula in § 192.105 is the SMYS stated in the listed specification, if that value is known.

(b) For pipe that is manufactured in accordance with a specification not listed in section I of appendix B to this part or whose specification or tensile properties are unknown, the yield strength to be used in the design formula in § 192.105 is one of the following:

§ 192.109

(1) If the pipe is tensile tested in accordance with section II-D of appendix B to this part, the lower of the following:

(i) 80 percent of the average yield strength determined by the tensile tests.

(ii) The lowest yield strength determined by the tensile tests.

(2) If the pipe is not tensile tested as provided in paragraph (b)(1) of this section, 24,000 p.s.i. (165 MPa).

[35 FR 13257, Aug. 19, 1970, as amended by Amdt. 192-78, 61 FR 28783, June 6, 1996; Amdt. 192-83, 63 FR 7723, Feb. 17, 1998; Amdt. 192-85, 63 FR 37502, July 13, 1998]

§ 192.109 Nominal wall thickness (*t*) for steel pipe.

(a) If the nominal wall thickness for steel pipe is not known, it is determined by measuring the thickness of each piece of pipe at quarter points on one end.

(b) However, if the pipe is of uniform grade, size, and thickness and there are more than 10 lengths, only 10 percent of the individual lengths, but not less than 10 lengths, need be measured. The thickness of the lengths that are not measured must be verified by applying a gauge set to the minimum thickness found by the measurement. The nominal wall thickness to be used in the design formula in §192.105 is the next wall thickness found in commercial specifications that is below the average of all the measurements taken. However, the nominal wall thickness used may not be more than 1.14 times the smallest measurement taken on pipe less than 20 inches (508 millimeters) in outside diameter, nor more than 1.11 times the smallest measurement taken on pipe 20 inches (508 millimeters) or more in outside diameter.

[35 FR 13257, Aug. 19, 1970, as amended by Amdt. 192-85, 63 FR 37502, July 13, 1998]

§ 192.111 Design factor (*F*) for steel pipe.

(a) Except as otherwise provided in paragraphs (b), (c), and (d) of this section, the design factor to be used in the design formula in §192.105 is determined in accordance with the following table:

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Class location	Design factor (<i>F</i>)
1	0.72
2	0.60
3	0.50
4	0.40

(b) A design factor of 0.60 or less must be used in the design formula in §192.105 for steel pipe in Class 1 locations that:

(1) Crosses the right-of-way of an unimproved public road, without a casing;

(2) Crosses without a casing, or makes a parallel encroachment on, the right-of-way of either a hard surfaced road, a highway, a public street, or a railroad;

(3) Is supported by a vehicular, pedestrian, railroad, or pipeline bridge; or

(4) Is used in a fabricated assembly, (including separators, mainline valve assemblies, cross-connections, and river crossing headers) or is used within five pipe diameters in any direction from the last fitting of a fabricated assembly, other than a transition piece or an elbow used in place of a pipe bend which is not associated with a fabricated assembly.

(c) For Class 2 locations, a design factor of 0.50, or less, must be used in the design formula in §192.105 for uncased steel pipe that crosses the right-of-way of a hard surfaced road, a highway, a public street, or a railroad.

(d) For Class 1 and Class 2 locations, a design factor of 0.50, or less, must be used in the design formula in §192.105 for—

(1) Steel pipe in a compressor station, regulating station, or measuring station; and

(2) Steel pipe, including a pipe riser, on a platform located offshore or in inland navigable waters.

[35 FR 13257, Aug. 19, 1970, as amended by Amdt. 192-27, 41 FR 34605, Aug. 16, 1976]

§ 192.113 Longitudinal joint factor (*E*) for steel pipe.

The longitudinal joint factor to be used in the design formula in §192.105 is determined in accordance with the following table: