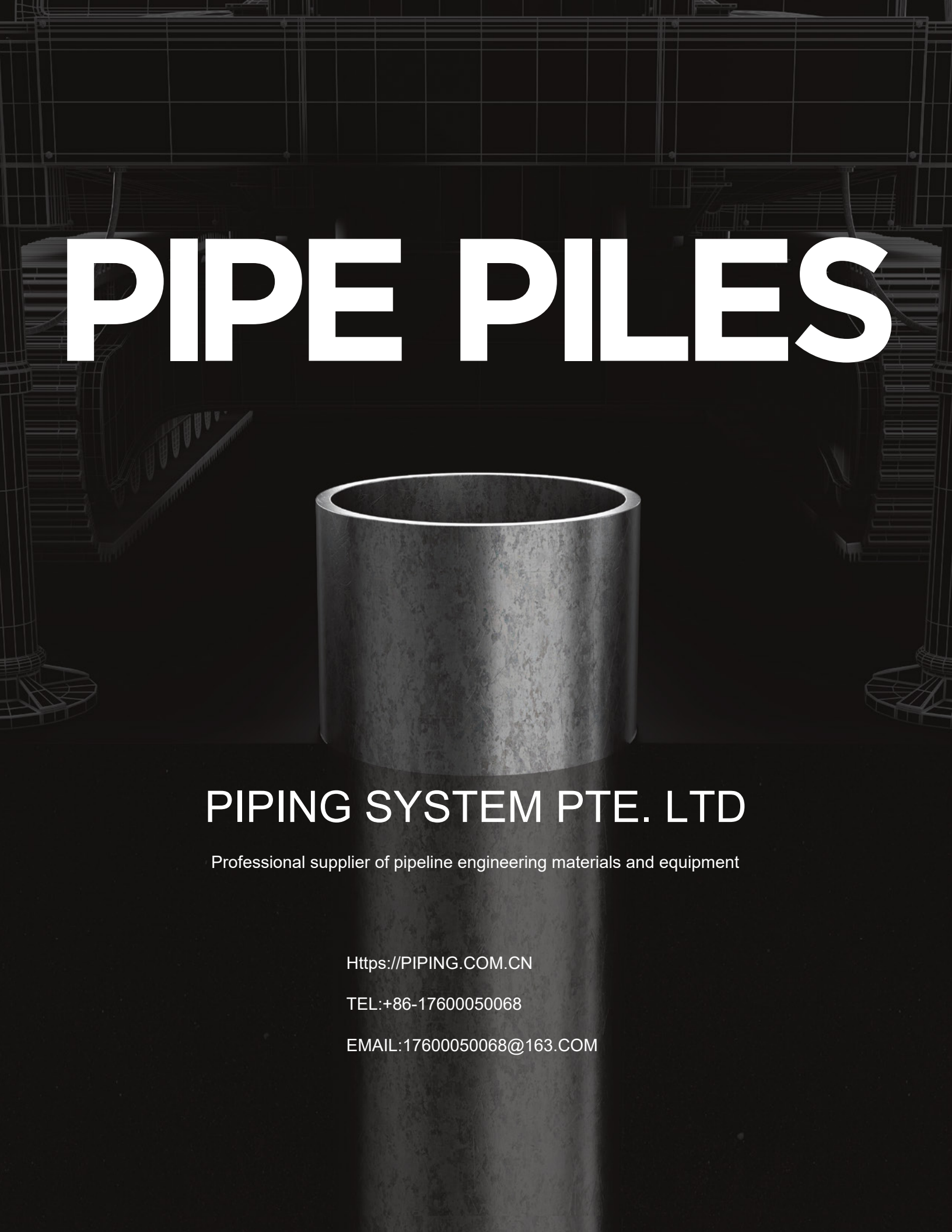


PIPE PILES



PIPING SYSTEM PTE. LTD

Professional supplier of pipeline engineering materials and equipment

[Https://PIPING.COM.CN](https://PIPING.COM.CN)

TEL:+86-17600050068

EMAIL:17600050068@163.COM

THE STRENGTH OF A GREAT PRODUCT. THE SUPPORT OF A GREAT COMPANY.

Atlas Tube ERW pipe piles are manufactured to deliver unmatched quality and dependability, supporting both the public and private sectors. All of our piles are produced to meet ASTM 252 or ASTM 500.

MARKETS:

USACE, DOTs and private projects.

APPLICATIONS:

Bearing pile, shell pile, micropile casing, jack and bore, etc.

TRACEABILITY:

100% domestic material with full traceability.

VALUE-ADDED SERVICES:

Beveling and attachment of points/plates.

CUSTOMIZATION:

Custom lengths, gauges and grades available upon request.

RELIABLE DELIVERY:

Products ship via truck, rail or barge from our North American mills.

LOCATIONS:

Chicago, Illinois; Blytheville, Arkansas; Birmingham, Alabama; Plymouth, Michigan; Harrow, Ontario.

A252

As the industry standard pipe pile specification, A252 covers nominal (average) wall steel pipe piles of cylindrical shape and applies to pipe piles in which the steel cylinder acts as a permanent load-carrying member, or as a shell for cast-in-place concrete piles.

A500

As the industry standard structural specification, A500 covers cold-formed welded and seamless carbon steel round, square, rectangular or special structural tubular shapes for welded, riveted or bolted construction of bridges and buildings, as well as general structural purposes.

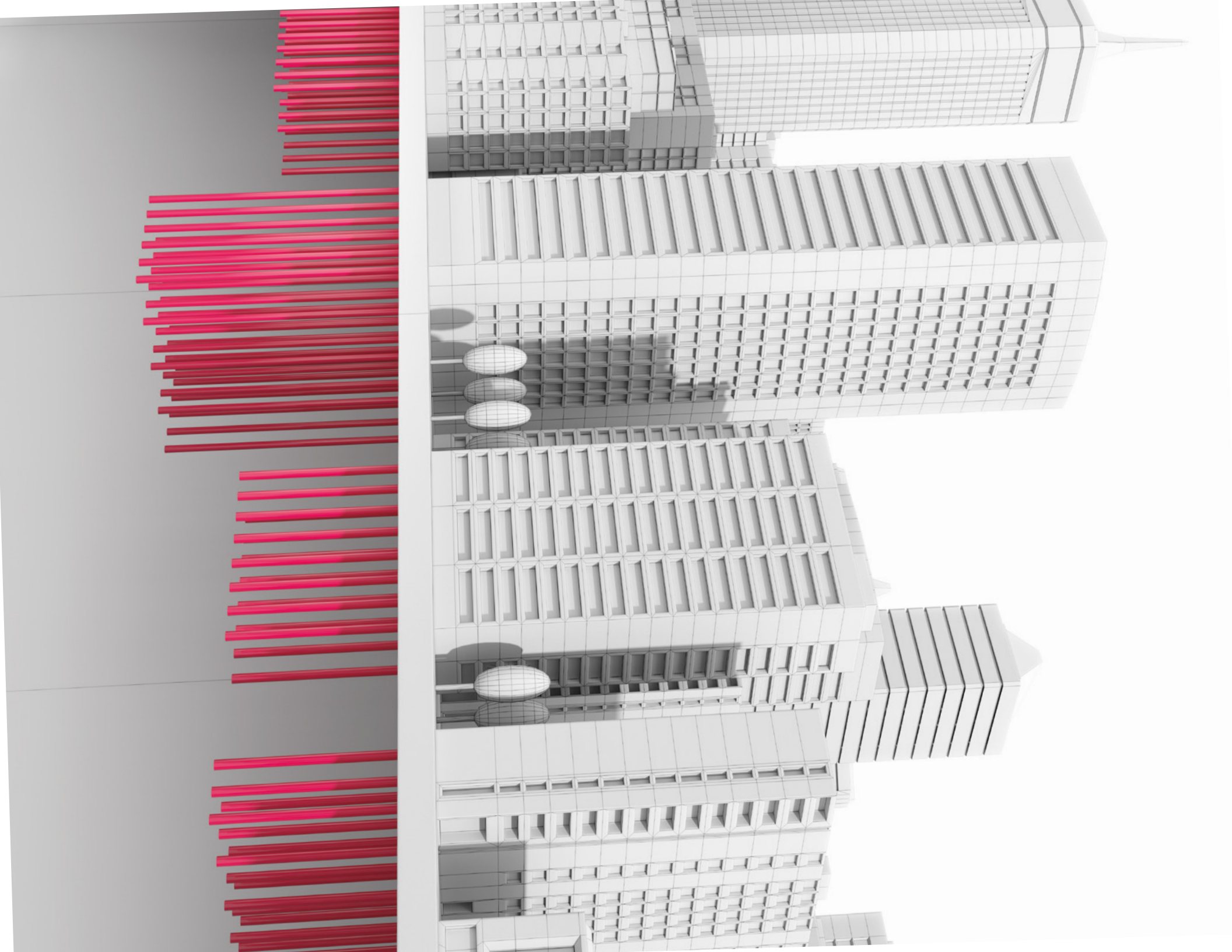
STEEL PIPE SPECIFICATIONS

ASTM	MIN YIELD (KSI)
A252 Grade 2	35
A252 Grade 3	45
A252 Grade 3 (Mod)*	50
A500 Grade C**	50

*Most common and readily available piling spec

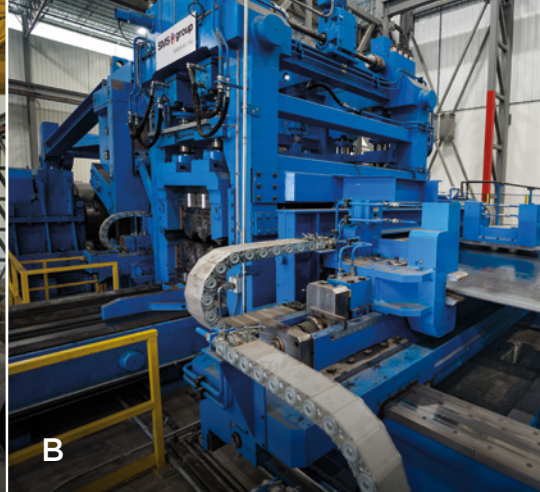
**Most common and readily available structural spec







A



B



C



G



H



I

WELCOME TO STATE-OF-THE-ART MANUFACTURING.

Our facilities feature the newest technology and automation to ensure you're getting the highest quality, most precise pipe piles as efficiently as possible. Our drop-in rollings and quick-change manufacturing process allow for flexibility and fast order turnaround.

COIL BAY (A)

Hot-rolled steel coils are inspected by our technicians to verify gauge and ensure the coils are defect-free. These are some of the largest coils produced in North America.

UNCOILER (B)

The steel is uncoiled, flattened and joined to the end of another coil with an end weld or butt weld, forming a continuous sheet. This welded portion will be cut out and scrapped.

ACCUMULATOR (C)

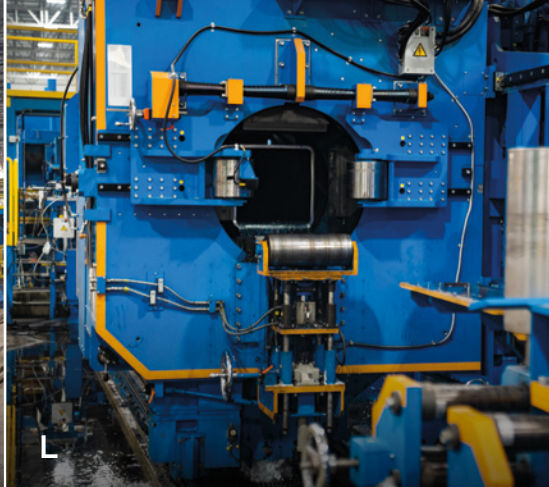
The continuous sheet heads into the spiral accumulator. The accumulator can hold up to 20 coils (approximately 800 tons). This allows our operations team to continually add coils so there is never a material lag.

EDGE MILLER (D)

The edge miller trims the edges of the coil to the required width and prepares the steel for the electric resistance welding (ERW) process.

FORMING SECTION (E)

Forming rolls gradually shape the flat steel sheet into a tube.



WELDING (F)

The edges of the steel are heated up to 2,700°F using electric resistance welding. The hot steel is then pressed together to form a full thickness metallurgical bond, which is stronger than the steel itself. At the same time, excess metal forms a weld bead along the seam. The excess metal is removed from the outside of the pipe piles to form a smooth surface.

SEAM ANNEALER (G)

The heat-affected zone (HAZ) is normalized through the seam annealing process, which provides a uniform grain structure and minimizes the risk of untampered martensite in the steel. It results in reduced hardness, improved ductility and relieved internal stress. Our state-of-the-art seam annealing system uses automated weld line tracking and up to five annealers to ensure full through-wall annealing.

TOOLING BAY (H)

Tooling sets are stored and the offline mill stands are prepared for the next size/changeover.

PULL OUT STAND (I)

Tooling is installed and staged for the next size to be rolled. Staging the next set of tooling allows the changeover of the mill to be completed in as little as two hours.

COOLING SECTION (J)

After seam annealing, the welded tube is air cooled to just below 400°F, then bathed by a stream of coolant to prevent cracking and splitting and to maintain straightness tolerances. The coolant is recovered and filtered through a closed loop process, preventing it from contaminating wastewater collections.

FINAL SHAPING STATION (K)

Forming stands straighten and shape the pipe piling into its final round shape.

CUT OFF SAW (L)

The pipe piles enter the flying Kusakabe saw, which cuts tubes to ordered length with a 0.125" tolerance and provides a smooth end cut. Piles will then be staged for shipment.

PIPE PILE SIZES & PROPERTIES

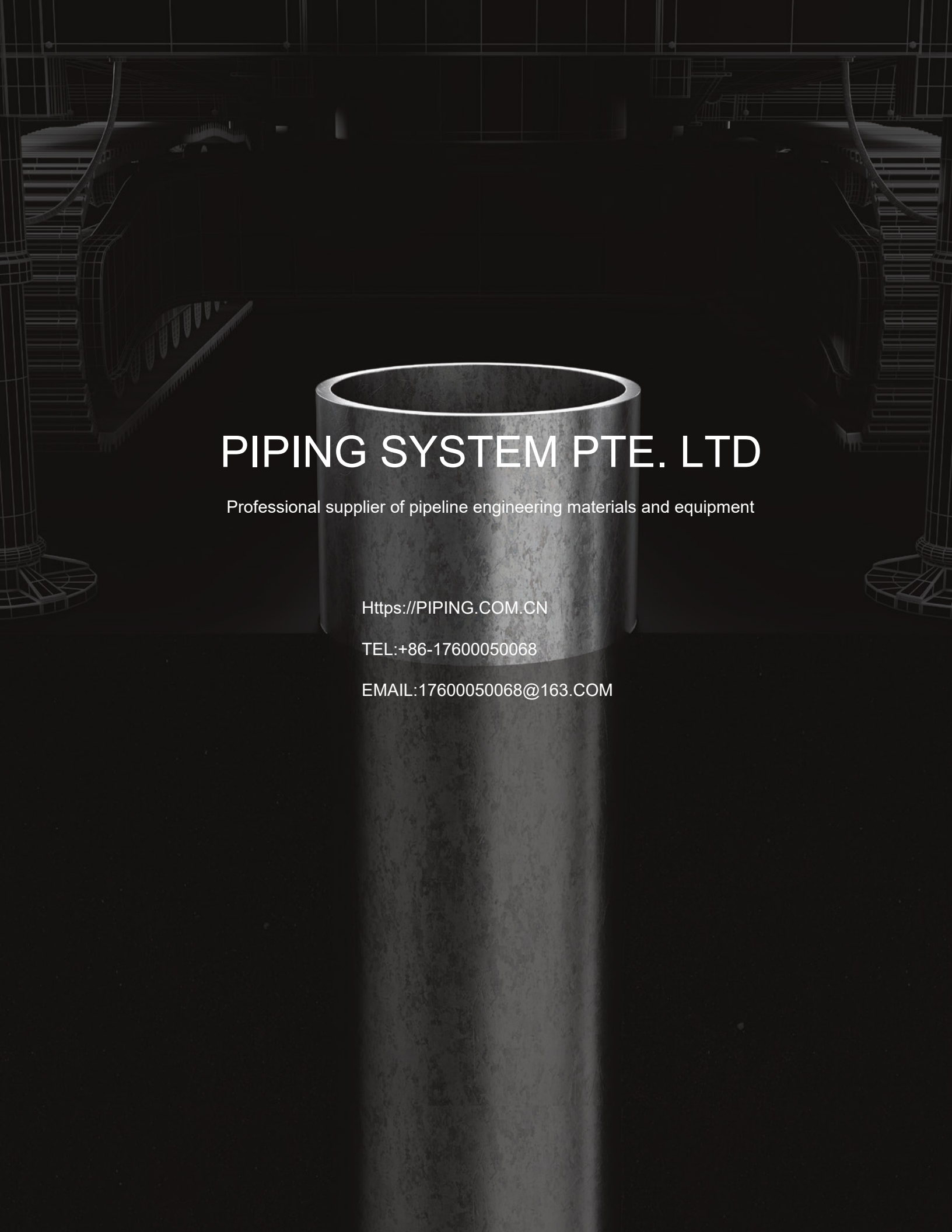
OUTER DIAMETER	WALL THICKNESS	INSIDE DIAMETER	WEIGHT	CROSS SECTION AREA	I	S	COATING AREA
in.	in.	in.	lbs./ft.	in. ²	in. ⁴	in. ³	ft. ² /ft.
6.625	0.250	6.125	17.04	5.01	25.47	7.69	1.73
	0.280	6.065	18.99	5.58	28.14	8.50	1.73
	0.375	5.875	25.05	7.36	36.08	10.89	1.73
	0.432	5.761	28.60	8.40	40.49	12.22	1.73
7	0.250	6.500	18.04	5.30	30.23	8.64	1.83
	0.312	6.376	22.31	6.55	36.73	10.49	1.83
	0.375	6.250	26.56	7.80	42.96	12.27	1.83
	0.500	6.000	34.74	10.21	54.24	15.50	1.83
8.625	0.250	8.125	22.38	6.58	57.72	13.38	2.26
	0.322	7.981	25.58	8.40	72.49	16.81	2.26
	0.375	7.875	33.07	9.72	82.86	19.21	2.26
	0.500	7.625	43.43	12.76	105.72	24.51	2.26
9.625	0.625	7.375	53.45	15.71	126.43	29.32	2.26
	0.250	9.125	25.05	7.36	80.95	16.82	2.52
	0.312	9.001	31.06	9.13	99.08	20.59	2.52
	0.375	8.875	37.08	10.90	116.74	24.26	2.52
	0.500	8.625	48.77	14.33	149.63	31.09	2.52
10.75	0.625	8.375	60.13	17.67	179.79	37.36	2.52
	0.250	10.250	28.06	8.25	113.71	21.16	2.81
	0.312	10.126	34.81	10.23	139.46	25.95	2.81
	0.365	10.020	40.52	11.91	160.73	29.90	2.81
	0.375	10.000	41.59	12.22	164.67	30.64	2.81
	0.500	9.750	54.79	16.10	211.95	39.43	2.81
	0.625	9.500	67.65	19.88	255.73	47.58	2.81
12	0.688	9.374	74.00	21.74	276.52	51.45	2.81
	0.250	11.500	31.40	9.23	159.33	26.56	3.14
	0.312	11.376	38.98	11.45	195.77	32.63	3.14
	0.375	11.250	46.60	13.69	231.59	38.60	3.14
	0.500	11.000	61.47	18.06	299.19	49.86	3.14
12.75	0.625	10.750	76.00	22.33	362.33	60.39	3.14
	0.250	12.250	33.41	9.82	191.82	30.09	3.34
	0.312	12.126	41.48	12.19	235.91	37.00	3.34
	0.375	12.000	49.61	14.58	279.33	43.82	3.34
	0.500	11.750	65.48	19.24	361.54	56.71	3.34
	0.625	11.500	81.01	23.80	438.67	68.81	3.34
	0.688	11.374	88.71	26.07	475.68	74.62	3.34
	0.750	11.250	96.21	28.27	510.93	80.15	3.34
	0.875	11.000	111.08	32.64	578.52	90.75	3.34
	1.000	10.750	133.41	38.27	678.52	103.75	3.34
14	0.250	13.500	36.75	10.80	255.30	36.47	3.66
	0.312	13.376	45.65	13.41	314.38	44.91	3.66
	0.375	13.250	54.62	16.05	372.76	53.25	3.66
	0.500	13.000	72.16	21.20	483.76	69.11	3.66
	0.625	12.750	89.36	26.26	588.53	84.08	3.66
	0.688	12.624	97.91	28.77	639.05	91.29	3.66
	0.750	12.500	106.23	31.21	687.32	98.19	3.66
	0.875	12.250	122.77	36.07	780.35	111.48	3.66
	1.000	12.000	138.97	40.83	867.86	123.98	3.66

PIPE PILE SIZES & PROPERTIES

OUTER DIAMETER	WALL THICKNESS	INSIDE DIAMETER	WEIGHT	CROSS SECTION AREA	I	S	COATING AREA
in.	in.	in.	lbs./ft.	in. ²	in. ⁴	in. ³	ft. ² /ft.
16	0.250	15.500	42.09	12.37	383.66	47.96	4.19
	0.312	15.376	52.32	15.37	473.25	59.16	4.19
	0.375	15.250	62.64	18.40	562.08	70.26	4.19
	0.500	15.000	82.85	24.34	731.94	91.49	4.19
	0.625	14.750	102.72	30.18	893.52	111.69	4.19
	0.688	14.624	112.62	33.09	971.90	121.49	4.19
	0.750	14.500	122.27	35.93	1047.08	130.88	4.19
	0.875	14.250	141.48	41.57	1192.90	149.11	4.19
	1.000	14.000	160.35	47.12	1331.25	166.41	4.19
18	0.250	17.500	47.44	13.94	549.14	61.02	4.71
	0.312	17.376	58.99	17.33	678.24	75.36	4.71
	0.375	17.250	70.65	20.76	806.63	89.63	4.71
	0.500	17.000	93.54	27.48	1053.17	117.02	4.71
	0.625	16.750	116.09	34.11	1289.07	143.23	4.71
	0.688	16.624	127.32	37.41	1404.03	156.00	4.71
	0.750	16.500	138.30	40.64	1514.64	168.29	4.71
	0.875	16.250	160.18	47.07	1730.18	192.24	4.71
	1.000	16.000	181.73	53.40	1936.00	215.11	4.71
20	0.250	19.500	52.78	15.51	756.43	75.64	5.24
	0.312	19.376	65.66	19.29	935.25	93.53	5.24
	0.375	19.250	78.67	23.12	1113.47	111.35	5.24
	0.500	19.000	104.23	30.62	1456.86	145.69	5.24
	0.625	18.750	129.45	38.04	1786.97	178.70	5.24
	0.688	18.624	142.03	41.73	1948.41	194.84	5.24
	0.750	18.500	154.34	45.35	2104.13	210.41	5.24
	0.875	18.250	178.89	52.56	2408.69	240.87	5.24
	1.000	18.000	203.11	59.68	2700.98	270.10	5.24
24	0.375	23.250	94.71	27.83	1942.30	161.86	6.28
	0.500	23.000	125.61	36.91	2549.35	212.45	6.28
	0.625	22.750	156.17	45.89	3136.93	261.41	6.28
	0.688	22.624	171.45	50.38	3425.82	285.49	6.28
	0.750	22.500	186.41	54.77	3705.45	308.79	6.28
	0.875	22.250	216.31	63.56	4255.34	354.61	6.28
	1.000	22.000	245.87	72.24	4787.00	398.92	6.28
	0.375	27.250	110.74	32.54	3105.11	221.79	7.33
28	0.500	27.000	146.99	43.19	4084.80	291.77	7.33
	0.625	26.750	182.90	53.74	5037.65	359.83	7.33
	0.688	26.624	200.87	59.02	5507.87	393.42	7.33
	0.750	26.500	218.48	64.19	5964.16	426.01	7.33
	0.875	26.250	253.72	74.55	6864.81	490.34	7.33
	1.000	26.000	288.63	84.81	7740.09	552.86	7.33

Custom lengths, gauges and grades available upon request.
Piling products produced from domestic materials with MTRs.

Please inquire about rolling schedule and lead times.
Project specific rollings available.



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