



Commanding a Higher Standard<sup>SM</sup>

# THE PHOENIX FORGE GROUP

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## PRODUCT SPECIFICATION BULLETIN

### CERTIFICATION of COMPLIANCE

### PIPE NIPPLES – MARKING SPECIFIC

**SCOPE:** This product specification bulletin applies to 1/8” through 8” NPS Schedule 40, 80, 160, and XX Heavy ASTM A106, A333, and A312 welded and seamless pipe nipples conforming to the dimensional requirements of ASTM A733. Included within the scope of this specification are threaded, weld beveled, grooved, and plain end pipe nipples in standard or special lengths. These pipe nipples are available with black, zinc phosphate coated, hot dip galvanized, or electro-zinc plated finishes.

**STANDARD DIE STAMP MARKINGS:** Nipples with an unthreaded space of 1/2" and longer are marked using low-stress round bottom die stamps. Markings include size, schedule, ASTM/ASME material designation, grade, logo, and heat code. Size markings may be omitted on 1/8", 1/4", and 3/8" pipe size nipples if space is limited due die stamp character size. See below listing for minimum length of nipples that require standard die markings for each corresponding pipe size.

Close and short space nipples with an unthreaded space of less than 1/2” are not die stamped as standard practice. The identification and traceability of close and short space nipples is provided on the labels of each carton of nipples.

**SPECIAL MARKINGS:** Upon customer request, close and short space nipples may be specially marked to provide the applicable identification and traceability by color-code taping, painting, die stamping, or vibro-tool etching each individual nipple.

**CARTON MARKINGS:** Carton labels for all nipples, including close nipples, are marked with the size, schedule, ASTM material designation, grade, logo, heat code, bar code, manufacturing location, and date packed. Carton labels for nipples manufactured in Canada are marked with the country of origin.

### MINIMUM LENGTH OF NIPPLES THAT REQUIRE STANDARD DIE STAMPED MARKINGS

<u>NPS</u>	<u>Shortest Nipple Stamped</u>	<u>NPS</u>	<u>Shortest Nipple Stamped</u>
1/8	1-1/2"	2	3"
1/4	2"	2-1/2	3-1/2"
3/8	2"	3	3-1/2"
1/2	2"	3-1/2	4"
3/4	2"	4	4"
1	2-1/2"	5	4"
1-1/4	2-1/2"	6	5"
1-1/2	2-1/2"	8	5-1/2"

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