



Standard Specification for Concrete Pipe for Irrigation or Drainage (Metric)¹

This standard is issued under the fixed designation C 118M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ε) indicates an editorial change since the last revision or reappraisal.

1. Scope

1.1 This specification covers nonreinforced concrete pipe to be used for the conveyance of irrigation water with working pressures, including hydraulic transients, as shown in **Table 1** and for use in drainage.

1.2 This specification is the SI counterpart of Specification C 118.

NOTE 1—This specification is for manufacturing and purchase only and does not include requirements for bedding, backfill, installation, or field repairs. The owner is cautioned that he must correlate field conditions with the characteristics of the pipe specified and provide inspection during installation.

2. Referenced Documents

2.1 ASTM Standards:²

- C 33 Specification for Concrete Aggregates
- C 150 Specification for Portland Cement
- C 497M Test Methods for Concrete Pipe, Manhole Sections, or Tile [Metric]
- C 595 Specification for Blended Hydraulic Cements
- C 618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
- C 822 Terminology Relating to Concrete Pipe and Related Products
- C 989 Specification for Ground Granulated Blast-Furnace Slag for Use in Concrete and Mortars
- C 1116 Specification for Fiber-Reinforced Concrete and Shotcrete

3. Terminology

3.1 *Definitions*—For definitions of terms relating to concrete pipe, see Terminology C 822.

4. Classification

4.1 Pipe manufactured according to this specification shall be known as “ASTM Standard Concrete Irrigation Pipe,”

¹ This specification is under the jurisdiction of ASTM Committee C13 on Concrete Pipe and is the direct responsibility of Subcommittee C13.01 on Non-Reinforced Concrete Sewer, Drain and Irrigation Pipe.

Current edition approved Dec. 1, 2005. Published January 2006. Originally approved in 1980. Last previous edition approved in 2005 as C 118M – 05.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard’s Document Summary page on the ASTM website.

TABLE 1 Standard Dimensions, Working Pressure, and Test Requirements for Standard Concrete Irrigation Pipe^A

Internal Designated Diameter, mm	Thickness of Wall, T, mm	Working Pressure, ^B kPa	Minimum Internal Hydrostatic Test Pressure, kPa	Minimum Three-Edge-Bearing Load, kN/linear m
150	22	90	345	19.0
200	25	90	345	19.5
250	29	90	345	20.5
300	32	75	310	22.0
350	35	75	310	23.5
375	38	75	310	24.0
400	38	75	310	25.0
450	44	75	310	26.5
500	50	75	275	27.0
525	54	75	275	27.5
600	57	75	275	29.0

^A For hydrostatic test requirements, refer to 10.5.

^B Higher working pressures are not prohibited up to a maximum of 120 kPa for 150 through 200-mm diameters, 105 kPa for 250 through 300-mm diameters, and 90 kPa for 350 through 600-mm diameters. In these cases, the strength of the pipe shall be increased to give a minimum internal hydrostatic test pressure of at least four times the design working pressure when tested as specified in 10.5.

“ASTM Standard Concrete Drainage Pipe,” or “ASTM Heavy-Duty Concrete Drainage Pipe.”

5. Basis of Acceptance

5.1 The acceptability of the pipe shall be determined by the results of the tests prescribed in this specification, if and when required and by inspection to determine whether the pipe conforms to this specification as to design and freedom from defects.

6. Materials

6.1 *Concrete*—The concrete shall consist of cementitious materials, mineral aggregates, and water.

6.2 Cementitious Materials:

6.2.1 *Cement*—Cement shall conform to the requirements for portland cement of Specification C 150 or shall be portland blast-furnace slag cement, or slag-modified portland cement, or portland-pozzolan cement conforming to the requirements of Specification C 595, except that the pozzolan constituent in the Type IP portland-pozzolan cement shall be fly ash.

6.2.2 *Fly Ash*—Fly ash shall conform to the requirements of Specification C 618, Class F or Class C.

6.2.3 *Ground Granulated Blast Furnace Slag (GGBFS)*—GGBFS shall conform to the requirements of Grade 100 or 120 of Specification C 989.

6.2.4 *Allowable Combinations of Cementitious Materials*—The combination of cementitious materials used in the concrete shall be one of the following:

- 6.2.4.1 Portland cement only,
- 6.2.4.2 Portland blast furnace slag cement only,
- 6.2.4.3 Slag modified portland cement only,
- 6.2.4.4 Portland pozzolan cement only,
- 6.2.4.5 A combination of portland cement and fly ash,
- 6.2.4.6 A combination of portland cement and ground granulated blast-furnace slag, or
- 6.2.4.7 A combination of portland cement, fly ash (not to exceed 25 % of the total cementitious weight) and ground granulated blast furnace slag (not to exceed 25 % of the total cementitious weight).

6.3 *Aggregates*—Aggregates shall conform to Specification **C 33**, except that the requirements for gradation shall not apply.

6.4 *Admixtures and Blends*—Admixtures and blends shall only be used with the approval of the owner.

6.5 *Synthetic Fibers*—Collated fibrillated virgin polypropylene fibers are not prohibited in concrete pipe as a nonstructural manufacturing material. Only Type III synthetic fibers designed and manufactured specifically for use in concrete and conforming to the requirements of Specification **C 1116** shall be accepted.

7. Design

7.1 *Design Tables*—Design requirements shall be in accordance with **Table 1** for standard concrete irrigation pipe or with the applicable part of **Table 2** for concrete drainage pipe. Wall thicknesses used shall be not less than the values shown, except as affected by the tolerances herein specified and by the provision for alternative design.

7.2 *Modified Design*—Manufacturers shall submit to the owner for approval prior to manufacture, wall thicknesses other than those shown in **Table 1** or **Table 2**. Such pipe shall meet all of the test and performance requirements specified by the owner in accordance with Section **10**.

7.3 *Laying Lengths*—Unless otherwise specified by the owner when calling for bids, maximum lengths of individual

units of drainage pipe shall not exceed 750 mm for sizes 100 mm through 150 mm, or 900 mm for sizes 200 mm through 375 mm, and 1200 mm for larger sizes.

8. Joints

8.1 The joints of both irrigation and drainage pipe shall be of such design and the ends of the concrete pipe sections so formed that the pipe can be laid together to make a continuous line of pipe compatible with the permissible variations given in Section **11**.

8.1.1 The joints of concrete drain tile shall conform to **8.1** without the use of mortar or other jointing material and allow water to enter without permitting the entrance of deleterious amounts of solids.

9. Concrete Mixture

9.1 The aggregates shall be sized, graded, proportioned, and thoroughly mixed with such proportions of cementitious materials and water as will produce a homogeneous concrete mixture of such quality that the pipe will conform to the test and design requirements of this specification.

10. Physical Requirements

10.1 *Test Specimens*—Specimens for tests shall be full-size pipe which shall in every respect conform to the inspection requirements prescribed in this specification.

10.2 *Number and Type of Tests Required:*

10.2.1 The specimens to be tested shall be selected at random by the owner at the place of manufacture, and shall be tested in advance of shipment. The manufacturer shall furnish specimens for purpose of tests, without charge, up to 0.5 % of the number of pipe of each size included in the order, except that in no case shall less than two specimens be furnished, the manufacturer bearing all expense of testing each pipe. Should a larger number of specimens be tested upon demand of the owner or manufacturer, then the cost of such additional test specimens and the expense of testing shall be borne by the party making such demand.

10.2.2 The owner shall specify the proportion of irrigation pipe specimens that shall be subjected to the three-edge-bearing load tests, and the proportion that shall be subjected to the hydrostatic test.

10.2.3 All drainage pipe to be tested shall be subjected to the three-edge-bearing load tests, and one half of the number of pipe so tested shall be subjected to the Test Method A or Test Method B absorption test in accordance with Test Methods **C 497M**, or other absorption test approved by the owner.

10.3 *External Load Test Requirements*—The pipe, when tested in accordance with Test Methods **C 497M** shall sustain the load prescribed in **Table 1** or **Table 2** for each respective size and class of pipe.

10.3.1 It is not prohibited to fill depressions of exterior surface irregularities with plaster of paris to equalize the bearing surfaces. If mutually agreed upon between the manufacturer and owner, other types of bearings such as hard rubber blocks or sand-filled high-pressure hose are acceptable. The user of this specification is advised that sand or other loose fine material may be spread along the length of the crown of the pipe to equalize the upper bearing.

TABLE 2 Physical Test Requirements for Standard and Heavy-Duty Concrete Drainage Pipe^A

Internal Designated Diameter, mm	Standard Drainage Pipe		Heavy-Duty Drainage Pipe	
	Thickness of Wall, mm	Minimum Three-Edge-Bearing Load, kN/linear m	Thickness of Wall, mm	Minimum Three-Edge-Bearing Load, kN/linear m
100	19	17.5	19	20.5
125	19	18.0	19	20.5
150	22	19.0	22	20.5
200	25	19.5	25	22.0
250	29	20.5	29	22.5
300	32	22.0	32	25.0
350	35	23.5	38	27.0
375	38	24.0	38	29.0
400	38	25.0	41	30.5
450	44	26.5	50	34.0
500	50	27.0	57	36.5
525	54	27.5	57	39.0
600	57	29.0	63	44.0

^A For absorption test requirements, refer to **10.4**.

10.3.2 The load shall be applied continuously until the strength specified in **Table 1** or 2 is reached. The pipe shall not be allowed to stand under load longer than is required to apply the load and to observe and record it. The pipe shall be surface-dry when tested. Tests shall not be made on frozen pipe.

10.4 *Absorption Test*—Test specimens shall be subjected to the boiling absorption test in accordance with Test Methods **C 497M**. For Test Method A, three test specimens shall be taken from each pipe unit to be tested; one of the pieces shall be taken from one end of the pipe, another piece from the opposite end, and the third piece from near the center. For Test Method A, each test specimen shall be free of visible cracks, shall have a minimum area of not less than 130 cm² as measured on one surface. The average absorption of the three specimens shall be considered to be the absorption for that pipe. The absorption of concrete drainage pipe as determined by the boiling absorption test shall not exceed 9 % for Test Method A or 8.5 % for Test Method B.

10.5 *Hydrostatic Tests*:

10.5.1 Irrigation pipe, when tested in accordance with the hydrostatic test procedures of Test Methods **C 497M**, shall sustain an internal hydrostatic pressure of 70 kPa for 10 min without excessive leakage through the wall of the pipe. Moisture appearing on the surface of the pipe in the form of patches or beads adhering to the surface shall not be considered as excessive leakage. Slow-forming beads of water from pinholes that result in minor dripping and slight pinhole spurts that will not interfere with the use of the pipe in service will not be cause for rejection.

10.5.2 The pipe shall not fail when, after completion of the portion of the test described in **10.5.1**, the pressure is increased to the minimum hydrostatic pressure specified in **Table 1**.

10.6 *Retests*—Irrigation pipe shall be acceptable under the load and hydrostatic test requirements when all test specimens conform to the test requirements. Drainage pipe shall be acceptable under the load and absorption test requirements when all the test specimens conform to the test requirements. Should any of the initial test specimens fail to meet the test requirements, the manufacturer will be allowed a retest on two additional specimens for each initial specimen that failed, and the tested lot will be acceptable only if all retest specimens meet the test requirements. In the event these retest specimens do not fully conform to the test requirements, the entire lot shall be rejected without further test. The manufacturer shall bear all the expense of retesting.

11. Permissible Variations

11.1 *Internal Diameter*—See **Table 3**. At the manufacturer's option, the internal diameter shall be one of two alternatives, the Designated Diameter or the Converted English Diameter. Pipe sections that are intended to be jointed to each other shall be furnished with the same internal diameter alternative. The internal diameter of pipe manufactured to the Designated Diameters shall vary from the Designated Diameter not more than ±5 mm for 150 mm pipe and smaller, ±7 mm for 200 mm pipe to 450 mm pipe, and ±8 mm for 500 mm pipe and larger. The internal diameter of pipe manufactured to the Converted English Diameter shall vary from the Converted English

TABLE 3 Internal Diameters

Designated Diameter, mm	Equivalent English Diameter, in	Converted English Diameter, mm
100	4	102
125	5	127
150	6	152
200	8	203
250	10	254
300	12	305
350	14	356
375	15	381
400	16	406
450	18	457
500	20	508
525	21	533
600	24	610

Diameter not more than ±5 mm for 152 mm pipe and smaller, ±7 mm for 203 mm pipe to 457 mm pipe, and ±8 mm for 508 mm pipe and larger. For pipe manufactured to Converted English Diameters, the corresponding Designated Diameter shown in **Table 3** shall apply for all other requirements of this specification.

11.2 *Wall Thickness*—The minimum wall thickness of the pipe shall be not more than 5 % or 2 mm, whichever is greater, less than the wall thickness specified in **Table 1** or **Table 2** for the applicable class of pipe, or as specified in an approved alternative design.

12. Workmanship and Finish

12.1 Pipe shall be substantially free of fractures and surface roughness.

13. Repairs

13.1 Pipe repaired because of occasional imperfections in manufacturing or accidental injury during handling and will be acceptable if, in the opinion of the owner, the repairs are sound and properly finished and cured and the repaired pipe conforms to the requirements of this specification.

14. Inspection

14.1 The quality of all materials and the finished pipe shall be subject to inspection and approval by the owner.

15. Rejection

15.1 Individual pipe units shall be subject to rejection on account of failure to conform to any of the specification requirements or on account of any of the following:

15.1.1 Fractures or cracks passing through the wall except for an end crack that does not exceed the depth of the joint, or a fracture that at its deepest point does not exceed the depth of the joint nor extend more than 10 % around the circumference of the joint.

15.1.2 Defects that indicate mixing and molding, not in compliance with **9.1**.

15.1.3 The complete absence of distinct web-like markings from the external surface of the pipe made by any process in which the forms are removed immediately after the concrete has been placed, which is indicative of a deficiency of water in the concrete mix, unless all specimens submitted for test that

do not have such web-like markings shall have passed the physical tests herein required.

16. Product Marking

16.1 The letter “H” shall be stamped with waterproof ink, or other permanent manner, on all heavy-duty concrete drainage pipe.

17. Keywords

17.1 absorption; acceptance criteria; concrete; design; drainage; hydrostatic; irrigation; joints; manufacture; nonreinforced; pipe; pressure; tests; three-edge bearing

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