



Standard Specification for Mineral Fiber Pipe Insulation¹

This standard is issued under the fixed designation C 547; 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 reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers mineral fiber insulation produced to form hollow cylinders for standard pipe and tubing sizes. The mineral fiber pipe insulation may be molded or precision v-grooved, with one or more walls split longitudinally for use on pipe temperatures up to 1200°F (650°C).

1.2 For satisfactory performance, properly installed protective vapor retarders or barriers should be used on sub-ambient temperature applications to reduce movement of moisture through or around the insulation to the colder surface. Failure to use a vapor barrier can lead to insulation and system damage. Refer to Practice C 921 to aid material selection.

1.3 Flexible mineral fiber wrap products such as perpendicular-oriented fiber insulation rolls, non-precision or manually scored block or board, or flexible boards or blankets used as pipe insulation, are not covered by this specification.

1.4 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.5 The following safety hazards caveat applies to the test methods portion, Section 11, only: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

- C 167 Test Methods for Thickness and Density of Blanket or Batt Thermal Insulations²
- C 168 Terminology Relating to Thermal Insulating Materials²
- C 177 Test Method for Steady-State Heat Flux Measurements and Thermal Transmission Properties by Means of the Guarded-Hot-Plate Apparatus²

C 302 Test Method for Density of Preformed Pipe-Covering-Type Thermal Insulation²

C 335 Test Method for Steady-State Heat Transfer Properties of Horizontal Pipe Insulation²

C 356 Test Method for Linear Shrinkage of Preformed High-Temperature Thermal Insulation Subjected to Soaking Heat²

C 390 Criteria for Sampling and Acceptance of Preformed Thermal Insulation Lots²

C 411 Test Method for Hot-Surface Performance of High-Temperature Thermal Insulation²

C 447 Practice for Estimating the Maximum Use Temperature of Insulations²

C 585 Practice for Inner and Outer Diameters of Rigid Thermal Insulation for Nominal Sizes of Pipe and Tubing (NPS System)²

C 612 Specification for Mineral Fiber Block and Board Thermal Insulation²

C 795 Specification for Thermal Insulation for Use in Contact with Austenitic Stainless Steel²

C 921 Practice for Determining the Properties of Jacketing Materials for Thermal Insulation²

C 1045 Practice for Calculating Thermal Transmission Properties from Steady-State Heat Flux Measurements²

C 1058 Practice for Selecting Temperatures for Evaluating and Reporting Thermal Properties of Thermal Insulation²

C 1104/C1104M Test Method for Determining the Water Vapor Sorption of Unfaced Mineral Fiber Insulation²

E 84 Test Method for Surface Burning Characteristics of Building Materials³

2.2 Other Standards:

UL 723 Tests for Surface Burning of Building Materials, available from Underwriters Laboratories, 333 Pfingsten Road, Northbrook, IL 60062–2026

NFPA 255 Method of Tests of Surface Burning Characteristics of Building Materials, available from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269

CAN/ULC-S102–M88 Standard Method of Test for Surface Burning Characteristics of Building Materials and Assemblies, available from Underwriters Laboratories of

¹ This specification is under the jurisdiction of ASTM Committee C16 on Thermal Insulation and is the direct responsibility of Subcommittee C16.20 on Homogeneous Inorganic Thermal Insulations.

Current edition approved April 10, 2003. Published July 2003. Originally approved in 1964. Last previous edition approved in 2000 as C 547 – 00.

² Annual Book of ASTM Standards, Vol 04.06.

³ Annual Book of ASTM Standards, Vol 04.07.

Canada, 7 Crouse Road, Scarborough, Ontario M1R3A9

3. Terminology

3.1 The definitions in Terminology C 168 shall apply to the terms used in this specification.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *molded*—refers to products preformed via a molding process to yield full-round cylindrical pipe insulation sections.

3.2.2 *precision v-groove*—refers to products fabricated from machined board via a precision cutting process. Machined segments are adhered to a backing to form a full-round cylindrical pipe insulation section. Due to the precision of the process, the product has no gaps when installed.

4. Classification

4.1 Products covered by this specification are classified according to maximum use temperature as follows:

4.1.1 *Type I*—Molded, for use to 850°F (454°C).

Grade A—Requires no heat-up schedule

Grade B—Heat-up schedule is required

4.1.2 *Type II*—Molded, for use to 1200°F (650°C).

Grade A—Requires no heat-up schedule

Grade B—Heat-up schedule is required

4.1.3 *Type III*—Precision v-groove, for use to 1200°F (650°C).

Grade A—Requires no heat-up schedule

Grade B—Heat-up schedule is required

4.1.4 *Type IV*—Molded, for use to 1000°F (538°C).

Grade A—Requires no heat-up schedule

Grade B—Heat-up schedule is required

NOTE 1—Warning: Grade B may not be suitable for applications requiring hot installation capability at the maximum temperature indicated. Products having a Grade B designation are designed to be used with a heat-up schedule. Failure to use a heat-up schedule with Grade B

products may lead to an exothermic reaction. This is dependent on thickness and temperature. Consult the manufacturer or manufacturer's literature for special heat rate considerations.

4.2 Binder decomposition at elevated temperature may be a limiting factor in certain applications. Consult the manufacturer regarding special heat rate considerations.

5. Materials and Manufacturer

5.1 *Composition*—The mineral fiber insulation for pipes shall be manufactured from mineral substance such as rock, slag, or glass, processed from a molten state into fibrous form with binder. Asbestos shall not be used as an ingredient or component part. Some products may also contain adhesive.

5.2 *Jackets (Facings)*—The user of this specification has the option to specify that the insulation be jacketed.

NOTE 2—The user is advised that the maximum use temperature of factory-applied facings and adhesives may be lower than the maximum use temperature of the insulation. The specifier shall ensure that sufficient insulation thickness is installed so none of these accessory items (facings and adhesives) are exposed to temperatures above their maximum use temperature. The products covered by this standard are predominantly inorganic in nature. Organic facings, adhesives and binders are also used in the construction of these products. The resulting composite therefore could have increased combustibility.

6. Physical Requirements

6.1 The product shall conform to the following requirements in addition to those specified in Table 1.

6.2 *Hot Surface Performance:*

6.2.1 The product shall not crack, warp, flame, or glow during hot surface exposure. No evidence of melting or fiber degradation shall be evident upon post test inspection.

6.2.2 The insulation's internal temperature rise (exotherm) shall not exceed the pipe temperature by more than 200°F (111°C).

TABLE 1 Requirements of Mineral Fiber Pipe Insulation (Grades A & B)

Property	Type I (Grades A & B)	Type II (Grades A & B)	Type III (Grades A & B)	Type IV (Grades A & B)
Use temperature, max, °F (°C)	850 (454)	1200 (650)	1200 (650)	1000 (538)
Sag resistance, max, % thickness change	5	5	5	5
Linear shrinkage (length), max, % change after change after soaking heat at maximum use temperature	2	2	2	2
Water vapor sorption, max, % by weight	5	5	5	5
Surface burning characteristics, max				
Flame spread index	25	25	25	25
Smoke developed index	50	50	50	50
Apparent thermal conductivity, max, Btu.in./h.ft ² , °F(W/m.K)				
Mean temperature ^A °F (°C)				
100 (38)	0.25 (0.036)	0.25 (0.036)	0.25 (0.036)	0.25 (0.036)
200 (93)	0.31 (0.045)	0.31 (0.045)	0.31 (0.045)	0.31 (0.045)
300 (149)	0.40 (0.058)	0.37 (0.053)	0.37 (0.053)	0.37 (0.053)
400 (204)	0.51 (0.074)	0.45 (0.065)	0.45 (0.065)	0.45 (0.065)
500 (280)	0.64 (0.092)	0.54 (0.078)	0.54 (0.078)	0.54 (0.078)
600 (316)		0.65 (0.094)	0.65 (0.094)	0.65 (0.094)
700 (371)		0.77 (0.111)	0.77 (0.111)	0.77 (0.111)

^A The user is advised that retrofit applications (where new insulation is being applied over existing) could require knowing the thermal conductivity of the existing layer at mean temperatures above those shown. Consult a manufacturer for data at mean temperatures exceeding those listed.

TABLE 2 Requirements of Mineral Fiber Pipe Insulation (Grade A Only)

Property	Type I (Grade A)	Type II (Grade A)	Type III (Grade A)	Type IV (Grade A)
Maximum Internal Temp. Rise (Grade A Only), °F (°C)	200 (111)	200 (111)	200 (111)	200 (111)

6.3 Non-fibrous (Shot) Content:

6.3.1 The non-fibrous content of a rock- or slag-based product shall not exceed 30 % by weight.

7. Standard Shapes, Sizes, and Dimensions

7.1 The basic shape of mineral fiber pipe insulation forms a right annular cylinder, which is radially slit on at least one side of the cylinder axis. It is furnished in sections or segments designed to fit standard sizes of pipe and tubing.

7.2 Typical available thicknesses range from nominal ½-in. (13 mm) to nominal 6-in. (152 mm), single or double layer, in ½-in. increments for most pipe and tubing sizes.

7.3 Individual dimensions for inner diameter and wall thickness shall conform to Practice C 585.

7.4 Standard section or segment length shall be 3 ft (0.91m) or as agreed upon between the buyer and seller.

8. Dimensional Tolerances

8.1 Length equals $\pm \frac{1}{8}$ -in. (3 mm).

8.2 When installed on a nominal pipe or tubing size as defined in Practice C 585, the insulation shall fit snugly and have tight longitudinal and circumferential joints.

8.3 The inner and outer bore of the insulation shall be concentric to the outer surface. The deviation from concentricity shall not exceed $\frac{3}{16}$ in. (5 mm).

9. Workmanship

9.1 The insulation shall not have defects that will adversely affect installation or service quality.

10. Sampling

10.1 When specified in the purchase order or contract, sampling and acceptance shall be in accordance with Criteria C 390.

11. Test Methods

11.1 The properties in this specification shall be determined in accordance with the following test methods, with jacketing excluded unless stated otherwise.

11.1.1 *Density and Dimensions*—Test Method C 302.

11.1.2 *Linear Shrinkage*—Test Method C 356.

11.1.3 *Thermal Conductivity*—Test Method C 335.

11.1.3.1 Thermal performance shall be characterized on a 3-in. NPS $\times$ 2-in. pipe insulation size. Thermal performance must be assessed on actual pipe insulation sections. Data obtained on flat samples, using Test Method C 177, shall not be used to state compliance with this specification.

11.1.3.2 Practice C 1058 may be used to obtain recommended test temperature combinations for testing purposes.

11.1.3.3 As specified in C 1045, the range of test conditions must include at least one test where the hot surface temperature is greater than, or equal to, the hot limit of the temperature range of desired data and at least one test where the cold surface temperature is less than, or equal to, the cold limit of the temperature range desired. At least two additional tests shall be distributed somewhat evenly over the rest of the temperature range.

11.1.3.4 Final analysis of the thermal data shall be conducted in accordance with C 1045 to generate a thermal conductivity versus temperature relationship for the specimen.

11.1.3.5 The final step of C 1045 analysis is to calculate the thermal conductivity using the equations generated at a set of mean temperatures for comparison to the specification.

NOTE 3—Caution: While it is recommended that the specification data be presented as thermal conductivity versus temperature, several existing specifications may contain mean temperature data from tests conducted at specific hot and cold surface temperatures. In these cases, the conductivity as a function of temperature from the C 1045 analysis may provide different results. To insure that the data is compatible, a C 680 analysis, using the thermal conductivity versus temperature relationship from C 1045 and the specific hot and cold surface temperatures, is required to determine the effective thermal conductivity for comparison to the specification requirements.

11.1.4 *Water Vapor Sorption*—Test Method C 1104/ C 1104M.

11.1.5 *Surface Burning Characteristics*—Test Method E 84.

11.1.5.1 Flat specimens otherwise identical in composition to pipe insulation shall be used. This applies to plain and factory-jacketed products, with and without self-sealing longitudinal lap closure systems.

11.1.5.2 Test Methods UL 723 or NFPA 255 may be substituted for Test Method E 84. These methods are largely considered synonymous by most building officials.

11.1.5.3 For Canada, test in accordance with CAN/ULC-S102-M88.

11.1.6 *Hot Surface Performance*—Test Method C 411 and Standard Practice C 447.

11.1.6.1 A 3-in. (75-mm) nominal pipe size or larger shall be used. A test specimen shall be at least 36-in. (914-mm) in length. All types shall be tested at 6-in. (150-mm) nominal thickness, in either single or multiple layer configurations.

11.1.6.2 All products shall be tested without jacketing, with the exception of products where the jacket is an integral part necessary to hold the insulation together such as precision v-groove. The test pipe shall be at the Type I, Type II, Type III, or Type IV temperature specified in 4.1, when the insulation is applied. For Class B material any special requirement for heat-up shall be specified by the manufacturer shall be used.

11.1.6.3 Immediately upon application to the pipe, the internal temperature rise shall be measured as prescribed in the Hot Surface Performance section of Standard Practice C 447.

11.1.7 *Sag Resistance:*

11.1.7.1 *Scope*—This procedure is used to determine thickness loss as a result of exposure to maximum service during the hot surface performance test.

11.1.7.2 *Significance and Use*—Products having excessive thickness loss at elevated temperature could yield less than expected in-service performance.

11.1.7.3 *Definition*—Sag is defined as the extent of thickness loss due to material fatigue or decomposition due to elevated temperature.

11.1.7.4 *Procedure*—For the sag determination, measure the thickness of the test length before and after 96-h hot surface exposure. A pin gage suitable for this is described by Test Methods C 167. The measurement shall be taken at the top longitudinal center of the horizontally mounted test specimen. The pin gage shall be vertically inserted through the insulation to obtain tip contact with the hot pipe surface. The pin gage shall be read with a steel rule to the nearest 1/32-in. (1 mm). Calculate the thickness sag as follows:

$$\% \text{ change} = ((t_1 - t_2)/t_1) \times 100 \quad (1)$$

where:

t_1 = starting thickness, and

t_2 = thickness after 96 h.

11.1.7.5 *Precision and Bias*—See Method C 167, “Standard Test Methods for Thickness and Density of Blanket or Batt Thermal Insulations”.

11.1.8 *Non-fibrous Content (Shot)*—For rock or slag based products non-fibrous content shall be determined in accordance with Test Method C 1335.

11.1.9 *Stress Corrosion Performance*—Compliance with Specification C 795 is necessary only when requested to assess corrosivity when the insulation is applied to austenitic stainless steel pipe.

12. Qualification Requirements

12.1 The following requirements shall be employed for the purpose of product qualification:

12.1.1 Density and dimensions,

12.1.2 Linear shrinkage,

12.1.3 Apparent thermal conductivity,

12.1.4 Surface burning characteristics,

12.1.5 Hot surface performance,

12.1.6 Sag resistance,

12.1.7 Water vapor sorption, and

12.1.8 Non-fibrous content (shot).

13. Inspection

13.1 When agreed upon between the purchaser and manufacturer or supplier, the inspection of material shall be made at either the point of shipment or the point of delivery. The following requirements are generally employed for the purposes of acceptance and sampling of lots, on shipments of qualified insulation:

13.1.1 Dimensional tolerances, and Workmanship.

13.2 *Rejection*—Material that fails to conform to the requirements of this specification may be rejected. Rejection should be reported to the manufacturer or supplier promptly and in writing. The manufacturer and supplier have the right to verify rejected products.

14. Packaging and Package Marking

14.1 *Packaging*—Mineral fiber preformed pipe insulation shall be packaged in the manufacturer’s standard commercial container unless otherwise agreed upon between the buyer, seller, and the manufacturer.

14.2 Unless otherwise specified, each container shall be marked with the manufacturer’s lot or date code identification, and facing, if any, on the material in the container. When specified in the purchase order or contract, each container shall also be marked with the appropriate Specification C 547 type and maximum use temperature.

15. Keywords

15.1 mineral fiber thermal insulation; molded; physical properties; pipe insulation; precision v-groove; thermal properties

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).