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**INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

CJ/T 431-2013

**Helical corrugated steelpipe for drains
(English Translation)**

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard reference to the United States ASTM A760/A760M-10 "Sewage and rainwater with metal corrugated pipe standard specifications" ASTM A1042/A1042M-04 "Sewage and drainage composite corrugated steel pipe standard specification", ASTM A796/A796M-06 "rainwater, Sanitary ware sewage and other buried corrugated steel pipe, standard design of pipe arch structure, "ASTM A929/A929M-01" corrugated steel Standard Specification for Hot-dip Galvanized Steel Sheet ", ASSHTOT249-03" Standard Test Method for Helical Locking Bellows ", combined with our country Body conditions, the preparation of this standard.

This standard proposed by the Ministry of Housing and Urban Standard and Design Institute.

This standard by the Ministry of Housing and Urban Water Supply and Drainage Municipal Standardization Technical Committee centralized.

This standard was drafted. Xintai Tube Co., Ltd. in Heilongjiang Province, Heilongjiang Province Plastics Industry Science Institute.

1 Scope

This standard specifies the terms and definitions, materials, structure, classification and connection, requirements, test of the drainage pipe (hereinafter referred to as pipe) Methods, inspection rules, marking, transport and storage.

This standard applies to the transport medium temperature below 45 °C buried underground town without drainage, industrial drainage projects such as the use of plastic coated steel pipe as well as galvanized steel pipe for rainwater drainage and collection in urban areas and farmland water conveyance.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 228.1 Tensile testing of metallic materials - Part 1. Room temperature test method
GB/T 1040.3 Plastics - Determination of tensile properties - Part 3. Test conditions for films and sheets
GB/T 2518 continuous hot dip galvanized steel sheet and strip
GB/T 2828.1-2003 Sampling procedures for sampling inspection - Part 1. Batch-by-lot inspection by acceptance quality limit (AQL) plan
GB/T 2918 plastic sample conditioning and testing of the standard environment
Thermoplastics pipe rings - Determination of ring stiffness
GB/T 21873 rubber seal to the drain pipe and sewer pipe interface seal material specifications
ISO 13968 Plastics piping and conveying systems - Determination of flexibility of thermoplastic pipe rings (Plasticspipingandducting systems.Determinationofringflexibility)

3 Terms and definitions

The following terms and definitions apply to this document.

Rebar pipe corrugatedsteelpipe to hot-dip galvanized steel strip or coated hot-dip galvanized steel strip as the base material, after several sets of roll rolling corrugated, spiral wound, the Ministry of Linking Shaping screw Grain pipe.

Plastic coated steel strip Hot-dip galvanized steel strip surface by thermal bonding process of bonding plastic film made of steel.

Overlap thickness plasticlaminatedthickness the sum of the thickness of the plastic film and the adhesive resin layer.

Mean inner diameter meaninsidediameter at the same cross-section of the pipe, measure

the inside diameter at 45 ° every turn and take the arithmetic mean of the four measurements rounded up to 0.1 mm.