



Designation: B746/B746M – 25

Standard Specification for Corrugated Aluminum Alloy Structural Plate for Field-Bolted Pipe, Pipe-Arches, and Arches¹

This standard is issued under the fixed designation B746/B746M; 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.

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

1. Scope

1.1 This specification covers corrugated aluminum alloy structural plate used in the construction of pipe, pipe-arches, arches, underpasses, box culverts, and special shapes for field assembly. Appropriate fasteners are also described. The pipe, arches, and other shapes are generally used for drainage purposes, pedestrian and vehicular underpasses, and utility tunnels. Aluminum box culvert shapes are covered in Specification B864/B864M.

1.2 This specification does not include requirements for bedding, backfill, or the relationship between earth cover load and plate thickness of the pipe. Experience has shown that the successful performance of this product depends upon the proper selection of plate thickness, type of bedding and backfill, controlled manufacture in the plant, and care in the installation. The purchaser must correlate the above factors and also the corrosion and abrasion requirements of the field installation with the plate thickness. The structural design of corrugated aluminum structural plate pipe and the proper installation procedures are given in Practices B790/B790M and B789/B789M, respectively. A procedure for using life-cycle cost analysis techniques to evaluate alternate drainage system designs using corrugated metal pipe is given in Practice A930.

1.3 The values stated in either inch-pound units or SI units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, each system shall be used independently of the other.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

¹ This specification is under the jurisdiction of ASTM Committee B07 on Light Metals and Alloys and is the direct responsibility of Subcommittee B07.08 on Corrugated Aluminum Pipe and Corrugated Aluminum Structural Plate.

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2. Referenced Documents

2.1 ASTM Standards:²

- A153/A153M Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware
- A307 Specification for Carbon Steel Bolts, Studs, and Threaded Rod 60 000 PSI Tensile Strength
- A449 Specification for Hex Cap Screws, Bolts and Studs, Steel, Heat Treated, 120/105/90 ksi Minimum Tensile Strength, General Use
- A563/A563M Specification for Carbon and Alloy Steel Nuts (Inch and Metric)
- A930 Practice for Life-Cycle Cost Analysis of Corrugated Metal Pipe Used for Culverts, Storm Sewers, and Other Buried Conduits
- A1113/A1113M Specification for Corrugated Steel Structural Plate, Polymer-Coated, for Field-Bolted Pipe, Pipe-Arches, and Arches
- B209/B209M Specification for Aluminum and Aluminum-Alloy Sheet and Plate
- B221 Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes
- B221M Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes (Metric)
- B666/B666M Practice for Identification Marking of Aluminum and Magnesium Products
- B695 Specification for Coatings of Zinc Mechanically Deposited on Iron and Steel
- B789/B789M Practice for Installing Corrugated Aluminum Structural Plate Pipe for Culverts and Sewers
- B790/B790M Practice for Structural Design of Corrugated Aluminum Pipe, Pipe-Arches, and Arches for Culverts, Storm Sewers, and Other Buried Conduits
- B864/B864M Specification for Corrugated Aluminum Box Culverts
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

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



F467 Specification for Nonferrous Nuts for General Use
 F467M Specification for Nonferrous Nuts for General Use (Metric)
 F468 Specification for Nonferrous Bolts, Hex Cap Screws, Socket Head Cap Screws, and Studs for General Use
 F468M Specification for Nonferrous Bolts, Hex Cap Screws, and Studs for General Use (Metric)
 F568M Specification for Carbon and Alloy Steel Externally Threaded Metric Fasteners (Metric) (Withdrawn 2012)³
 F593 Specification for Stainless Steel Bolts, Hex Cap Screws, and Studs
 F594 Specification for Stainless Steel Nuts
 F738M Specification for Stainless Steel Metric Bolts, Screws, and Studs (Withdrawn 2014)³
 F836M Specification for Style 1 Stainless Steel Metric Nuts (Metric) (Withdrawn 2023)³
 F3393 Specification for Zinc-Flake Coating Systems for Fasteners

2.2 American National Standards:⁴

B18.2.1 Square and Hex Bolts and Screws, Inch Series
 B18.2.2 Square and Hex Nuts
 B18.2.3.6M Bolts, Metric, Heavy Hex
 B18.2.4.6M Hex Nuts, Heavy, Metric

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *arch*, *n*—a part circle shape spanning an open invert between the footings on which it rests.

3.1.2 *box culvert*, *n*—a rectangular box with short-radius in upper corners and a long-radius crown. It can be with full invert or with footing pads.

3.1.3 *fabricator*, *n*—the producer of the components for the finished product.

3.1.4 *flat plate*, *n*—sheet or plate used to fabricate structural plate.

3.1.5 *manufacturer*, *n*—the producer of the flat plate and accessories.

3.1.6 *pipe*, *n*—a conduit having full circular shape; also, in a general context, all structure shapes covered by this specification.

3.1.7 *pipe-arch*, *n*—an arch shape with an approximate semicircular crown, small-radius corners, and large-radius invert.

3.1.8 *pipe, horizontal ellipse*, *n*—an elliptically shaped pipe with the horizontal diameter approximately 20 % greater than the nominal diameter.

3.1.9 *pipe, vertically elongated*, *n*—an elliptically shaped pipe with the vertical diameter up to 10 % greater than the nominal diameter.

3.1.10 *purchaser*, *n*—the purchaser of the finished product.

3.1.11 *special shape*, *n*—a shape, other than described elsewhere in this section, suitable for fabrication with structural plate.

3.1.12 *structural plate*, *n*—a corrugated and curved plate which is field assembled with other structural plates to form the required structure.

3.1.13 *supplier*, *n*—the seller of the finished product when other than the fabricator.

3.1.14 *vehicular underpass*, *n*—a high arch shape with an approximate semicircular crown, large-radius sides, small-radius corners between sides and invert, and large-radius invert.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information as necessary to adequately describe the desired product:

4.1.1 Name of material (aluminum alloy structural plate and accessories),

4.1.2 Description of structure (see Section 3),

4.1.3 Number of structures,

4.1.4 ASTM designation and year of issue, as B746— for inch-pound units or B746M— for SI units,

4.1.5 Dimensions of structure (diameter or span and rise, and length, and so forth) (see 7.2),

4.1.6 Thickness of plate (see 7.1),

4.1.7 Type of bolts; whether aluminum, stainless steel, or steel bolts are required or permitted. If not specified, steel bolts and nuts shall be furnished (see 5.3 and Note 2),

4.1.8 End treatment (bevel, skew, grade or slope corrections, or other special provision if required by the project plans or specifications),

4.1.9 Special requirements (including extrusion reinforcement locations and shapes), if required, and

4.1.10 Certification, if required.

NOTE 1—Typical ordering descriptions are as follows: (1) Structural plates and fasteners for two aluminum alloy structural plate pipes, in accordance with ASTM B746—, 180 in. dia., 0.100 in. plate thickness, each 140 ft nominal centerline length with end treatment as shown on plans. (2) Structural plates and fasteners for one aluminum alloy structural plate pipe arch, in accordance with ASTM B746—, 3860 mm span by 2460 mm rise, 3.81 mm plate thickness, 27.0 m nominal centerline length with square ends.

5. Materials

5.1 *Flat Plate*—Insofar as applicable, flat plate shall conform to the requirements of Specification B209/B209M. The plates shall be fabricated from alloy 5052-H141. The mechanical properties for alloy 5052-H141 shall conform to the requirements of Table 1.

5.2 *Extrusions*—The extrusions for circumferential or longitudinal stiffeners, or secondary structural components, shall be fabricated from aluminum alloys 6061-T6 or 6063-T6 conforming to Specification B221 or B221M.

5.3 *Assembly Fasteners*—Except as provided elsewhere in this section, bolts and nuts shall be either zinc, aluminum, or one of the alternate permissible coatings as specified in Specification A1113/A1113M (polymer, zinc flake or thermally

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.