Designation: F1055 – 16a (Reapproved 2022)

An American National Standard

Standard Specification for Electrofusion Type Polyethylene Fittings for Outside Diameter Controlled Polyethylene and Crosslinked Polyethylene (PEX) Pipe and Tubing[1]

This standard is issued under the fixed designation F1055; 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.

1. Scope*

1.1 This specification covers electrofusion polyethylene fittings for use with outside diameter-controlled polyethylene pipe, covered by Specifications D2513, D2737, D3035, F714, F2623, F2769 and crosslinked polyethylene (PEX), covered by Specifications F876 and F2788/F2788M. Requirements for materials, workmanship, and testing performance are included. All requirements for joining PE electrofusion fittings to PE pipe shall also apply to joining PE electrofusion fittings to PEX pipe. Where applicable in this specification "pipe" shall mean "pipe" or "tubing."

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 The following safety hazards caveat pertains only to the test method portion, Section 9, of this specification: *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

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.*

2. Referenced Documents

2.1 *ASTM Standards:*[2]

D638 Test Method for Tensile Properties of Plastics

D1598 Test Method for Time-to-Failure of Plastic Pipe Under Constant Internal Pressure

D1599 Test Method for Resistance to Short-Time Hydraulic Pressure of Plastic Pipe, Tubing, and Fittings

D1600 Terminology for Abbreviated Terms Relating to Plastics

D2513 Specification for Polyethylene (PE) Gas Pressure Pipe, Tubing, and Fittings

D2737 Specification for Polyethylene (PE) Plastic Tubing

D3035 Specification for Polyethylene (PE) Plastic Pipe (DR-PR) Based on Controlled Outside Diameter

D3350 Specification for Polyethylene Plastics Pipe and Fittings Materials

F412 Terminology Relating to Plastic Piping Systems

F714 Specification for Polyethylene (PE) Plastic Pipe (DR-PR) Based on Outside Diameter

F876 Specification for Crosslinked Polyethylene (PEX) Tubing

F905 Practice for Qualification of Polyethylene Saddle-Fused Joints

F1473 Test Method for Notch Tensile Test to Measure the Resistance to Slow Crack Growth of Polyethylene Pipes and Resins

F2623 Specification for Polyethylene of Raised Temperature (PE-RT) Systems for Non-Potable Water Applications

F2788/F2788M Specification for Metric and Inch-sized Crosslinked Polyethylene (PEX) Pipe

F2769 Specification for Polyethylene of Raised Temperature (PE-RT) Plastic Hot and Cold-Water Tubing and Distribution Systems

2.2 *PPI Standards:*[3]

PPI TR-3 Policies and Procedures for Developing Hydrostatic Design Basis (HDB), Pressure Design Basis (PDB), Strength Design Basis (SDB), and Minimum Required Strength (MRS) Rating for Thermoplastic Piping Materials or Pipe

PPI TR-4 HDB/SDB/PDB/MRS Listed Materials, PPI Listing of Hydrostatic Design Basis (HDB), Strength Design

[1] This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.10 on Fittings.

Current edition approved Nov. 1, 2022. Published November 2022. Originally approved in 1987. Last previous edition approved in 2016 as F1055 – 16a. DOI: 10.1520/F1055-16AR22.

[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.

[3] Available from Plastics Pipe Institute (PPI), 105 Decker Court, Suite 825, Irving, TX 75062, http://www.plasticpipe.org.

***A Summary of Changes section appears at the end of this standard**

Basis (SDB), and Minimum Required Strength (MRS) Rating for Thermoplastic Piping Materials or Pipe

2.3 *ISO Standards:*[4]

ISO 13954 Plastics pipe and fittings – Peel decohesion test for polyethylene (PE) electrofusion assemblies of nominal diameter greater than or equal to 90 mm

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology F412, and abbreviations are in accordance with Terminology D1600, unless otherwise specified.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *electrofusion*—a heat fusion joining process where the heat source is an integral part of the fitting, such that when electric current is applied, heat is produced that melts and joins the plastics.

3.2.2 *fusion interface*—surface in the heat fusion process where the plastic materials of the products being joined bond together.

3.2.3 *fusion zone length*—total length of the melted material in the fitting cross-section under evaluation.

4. Materials and Manufacture

4.1 This specification covers fittings made from polyethylene compounds as defined in Specification D3350.

4.1.1 Polyethylene material compounds suitable for use in the manufacture of electrofusion fittings under this specification shall meet Specification D3350 and shall meet Specification D3350 classification and property requirements shown in Table 1 and shall have PPI TR-4 HDB and HDS listings at 73 °F (23 °C) and HDB listings at 140 °F (60 °C).

4.2 *Rework Material*—Clean rework polyethylene material of the same resin, free of any wire or contaminants generated from the fitting manufacturer's own production, may be used by the same manufacturer, as long as the fittings produced conform to the requirements of this specification.

4.3 *Heating Mechanism*—The heat mechanism shall be of materials and design not detrimental to the performance of the fitting or the pipe to which it is intended to be joined. Heating mechanisms, such as wires or materials other than polyethylene, shall not exit the fitting in an area exposed to internal pressure. Heat mechanisms shall be of a design that ensures that wire terminations are toward the outer edges of the fusion zone length and away from the pressure containing area. Examples of acceptable and unacceptable wire terminations are shown in Figs. 1-5.

4.4 *Pipe with Layers:*

4.4.1 Pipe that has an exterior layer of material for color, or UV resistance, or oxygen transmission resistance, or as a removable layer to keep the base pipe outer surface clean is acceptable when such layers comply with the applicable pipe specification. When the exterior layer is a material other than the base pipe material, complete removal of the exterior layer prior to electrofusion joining is required in order to achieve proper fusion.

4.4.2 When the exterior layer is removed, the outside diameter of the base pipe shall meet the outside diameter dimension and tolerance requirements of the applicable pipe specification.

4.4.3 *Mid-wall layer pipes*—Electrofusion fittings for pipe that has a mid-wall layer are outside of the scope of this standard. Pipe that has a mid-wall layer shall not be used to qualify fittings to this standard.

5. Performance Requirements

5.1 The following requirements are for electrofusion joints that have been joined using the manufacturer's recommended joining procedures. These requirements must be met by each electrofusion joint design, on each size and type of pipe material for which the manufacturer recommends use of his fitting. Any revisions to the electrofusion joint design or processing by the manufacturer after the initial testing requires retesting to ensure these requirements can still be met. Fittings intended for use in the distribution of natural gas or liquid petroleum gas shall also meet the requirements of Specification D2513.

5.1.1 Assemblies using PEX pipes joined with electrofusion fittings shall be limited to the HDS rating of the PE material of the fitting as per 4.1.1 with a maximum usage temperature of 140 °F.

[4] Available from International Organization for Standardization (ISO), ISO Central Secretariat, BIBC II, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, http://www.iso.org.

TABLE 1 Specification D3350 Classification Requirements of Polyethylene Electrofusion Fitting Materials

Physical Properties	Cell Classification and Properties for Polyethylene Materials	
	PE2708	PE4710
Density	2	4
Melt Index	3 or 4	4
Flexural Modulus	≥4	≥5
Tensile Strength	≥3	≥4
Slow Crack Growth Resistance (F1473)	7	7
Hydrostatic Strength Classification	3	4
Color and UV Stabilizer	C or E	C or E
HDB at 73°F (23°C), psi (MPa)	1250 (8.62)	1600 (11.03)

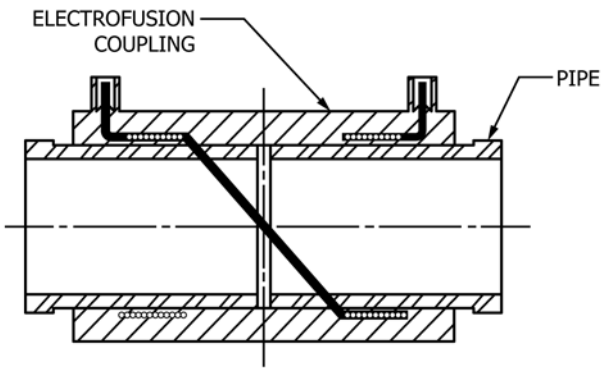

FIG. 1 Correct Wire Termination Coupling–Single Coil