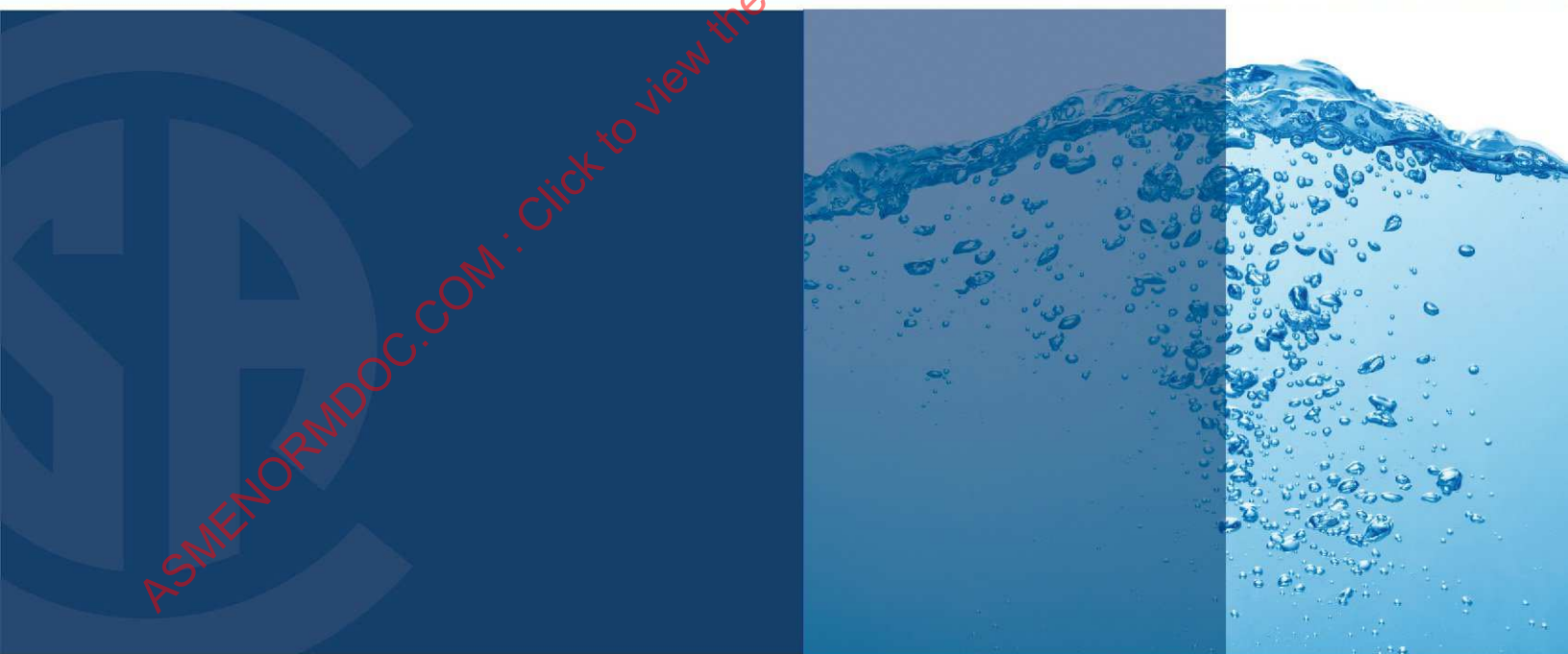




ASME A112.19.1-2024 • CSA B45.2:24
National Standard of Canada
American National Standard



Enamelled cast iron and enamelled steel plumbing fixtures



Legal Notice for Harmonized Standard Jointly Developed by ASME and CSA Group

Intellectual property rights and ownership

As between American Society of Mechanical Engineers (“ASME”) and Canadian Standards Association (Operating as “CSA Group”) (collectively “ASME and CSA Group”) and the users of this document (whether it be in printed or electronic form), ASME and CSA Group are the joint owners of all works contained herein that are protected by copyright, all trade-marks (except as otherwise noted to the contrary), and all inventions and trade secrets that may be contained in this document, whether or not such inventions and trade secrets are protected by patents and applications for patents. The unauthorized use, modification, copying, or disclosure of this document may violate laws that protect the intellectual property of ASME and CSA Group and may give rise to a right in ASME and CSA Group to seek legal redress for such use, modification, copying, or disclosure. ASME and CSA Group reserve all intellectual property rights in this document.

Disclaimer and exclusion of liability

This document is provided without any representations, warranties, or conditions of any kind, express or implied, including, without limitation, implied warranties or conditions concerning this document’s fitness for a particular purpose or use, its merchantability, or its non-infringement of any third party’s intellectual property rights. ASME and CSA Group do not warrant the accuracy, completeness, or currency of any of the information published in this document. ASME and CSA Group make no representations or warranties regarding this document’s compliance with any applicable statute, rule, or regulation.

IN NO EVENT SHALL ASME AND CSA GROUP, THEIR RESPECTIVE VOLUNTEERS, MEMBERS, SUBSIDIARIES, OR AFFILIATED COMPANIES, OR THEIR EMPLOYEES, DIRECTORS, OR OFFICERS, BE LIABLE FOR ANY DIRECT, INDIRECT, OR INCIDENTAL DAMAGES, INJURY, LOSS, COSTS, OR EXPENSES, HOWSOEVER CAUSED, INCLUDING BUT NOT LIMITED TO SPECIAL OR CONSEQUENTIAL DAMAGES, LOST REVENUE, BUSINESS INTERRUPTION, LOST OR DAMAGED DATA, OR ANY OTHER COMMERCIAL OR ECONOMIC LOSS, WHETHER BASED IN CONTRACT, TORT (INCLUDING NEGLIGENCE), OR ANY OTHER THEORY OF LIABILITY, ARISING OUT OF OR RESULTING FROM ACCESS TO OR POSSESSION OR USE OF THIS DOCUMENT, EVEN IF ASME OR CSA GROUP HAVE BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES, INJURY, LOSS, COSTS, OR EXPENSES.

In publishing and making this document available, ASME and CSA Group are not undertaking to render professional or other services for or on behalf of any person or entity or to perform any duty owed by any person or entity to another person or entity. The information in this document is directed to those who have the appropriate degree of experience to use and apply its contents, and ASME and CSA Group accept no responsibility whatsoever arising in any way from any and all use of or reliance on the information contained in this document.

ASME and CSA Group have no power, nor do they undertake, to enforce compliance with the contents of the standards or other documents they jointly publish.

Authorized use of this document

This document is being provided by ASME and CSA Group for informational and non-commercial use only. The user of this document is authorized to do only the following:

If this document is in electronic form:

- load this document onto a computer for the sole purpose of reviewing it;
- search and browse this document; and
- print this document if it is in PDF format.

Limited copies of this document in print or paper form may be distributed only to persons who are authorized by ASME and CSA Group to have such copies, and only if this Legal Notice appears on each such copy.

In addition, users may not and may not permit others to

- alter this document in any way or remove this Legal Notice from the attached standard;
- sell this document without authorization from ASME and CSA Group; or
- make an electronic copy of this document.

If you do not agree with any of the terms and conditions contained in this Legal Notice, you may not load or use this document or make any copies of the contents hereof, and if you do make such copies, you are required to destroy them immediately. Use of this document constitutes your acceptance of the terms and conditions of this Legal Notice.



Standards Update Service

ASME A112.19.1-2024 • CSA B45.2:24 March 2024

Title: *Enamelled cast iron and enamelled steel plumbing fixtures*

To register for e-mail notification about any updates to this publication

- go to www.csagroup.org/store/
- click on **CSA Update Service**

The **List ID** that you will need to register for updates to this publication is **2431095**.

If you require assistance, please e-mail techsupport@csagroup.org or call 416-747-2233.

Visit CSA Group's policy on privacy at www.csagroup.org/legal to find out how we protect your personal information.

ASMENORMDOC.COM : Click to view the full PDF of ASME A112.19.1 CSA B45.2 2024

Canadian Standards Association (operating as “CSA Group”), under whose auspices this National Standard has been produced, was chartered in 1919 and accredited by the Standards Council of Canada to the National Standards system in 1973. It is a not-for-profit, nonstatutory, voluntary membership association engaged in standards development and certification activities.

CSA Group standards reflect a national consensus of producers and users — including manufacturers, consumers, retailers, unions and professional organizations, and governmental agencies. The standards are used widely by industry and commerce and often adopted by municipal, provincial, and federal governments in their regulations, particularly in the fields of health, safety, building and construction, and the environment.

More than 10 000 members indicate their support for CSA Group’s standards development by volunteering their time and skills to Committee work.

CSA Group offers certification and testing services in support of and as an extension to its standards development activities. To ensure the integrity of its certification process, CSA Group regularly and continually audits and inspects products that bear the CSA Group Mark.

In addition to its head office and laboratory complex in Toronto, CSA Group has regional branch offices in major centres across Canada and inspection and testing agencies in fourteen countries. Since 1919, CSA Group has developed the necessary expertise to meet its corporate mission: CSA Group is an independent service organization whose mission is to provide an open and effective forum for activities facilitating the exchange of goods and services through the use of standards, certification and related services to meet national and international needs.

For further information on CSA Group services, write to
CSA Group
178 Rexdale Boulevard
Toronto, Ontario, M9W 1R3
Canada

A National Standard of Canada is a standard developed by a Standards Council of Canada (SCC) accredited Standards Development Organization, in compliance with requirements and guidance set out by SCC. More information on National Standards of Canada can be found at www.scc.ca.

SCC is a Crown corporation within the portfolio of Innovation, Science and Economic Development (ISED) Canada. With the goal of enhancing Canada’s economic competitiveness and social wellbeing, SCC leads and facilitates the development and use of national and international standards. SCC also coordinates Canadian participation in standards development, and identifies strategies to advance Canadian standardization efforts.

Accreditation services are provided by SCC to various customers, including product certifiers, testing laboratories, and standards development organizations. A list of SCC programs and accredited bodies is publicly available at www.scc.ca.

Standards Council of Canada
600-55 Metcalfe Street
Ottawa, Ontario, K1P 6L5
Canada



Cette Norme Nationale du Canada n’est disponible qu’en anglais.

Although the intended primary application of this Standard is stated in its Scope, it is important to note that it remains the responsibility of the users to judge its suitability for their particular purpose.

®A trademark of the Canadian Standards Association, operating as “CSA Group”

CSA Group

The Canadian Standards Association (operating as “CSA Group”), under whose auspices this National Standard has been produced, was chartered in 1919 and accredited by the Standards Council of Canada to the National Standards system in 1973. It is a not-for-profit, nonstatutory, voluntary membership association engaged in standards development and certification activities.

CSA Group standards reflect a national consensus of producers and users including manufacturers, consumers, retailers, unions and professional organizations, and governmental agencies. The standards are used widely by industry and commerce and often adopted by municipal, provincial, and federal governments in their regulations, particularly in the fields of health, safety, building and construction, and the environment.

More than 10 000 members indicate their support for CSA Group’s standards development by volunteering their time and skills to Committee work.

CSA Group offers certification and testing services in support of and as an extension to its standards development activities. To ensure the integrity of its certification process, CSA Group regularly and continually audits and inspects products that bear the CSA Group Mark.

In addition to its head office and laboratory complex in Toronto, CSA Group has regional branch offices in major centres across Canada and inspection and testing agencies in fourteen countries. Since 1919, CSA Group has developed the necessary expertise to meet its corporate mission: CSA Group is an independent service organization whose mission is to provide an open and effective forum for activities facilitating the exchange of goods and services through the use of standards, certification and related services to meet national and international needs.

For further information on CSA Group services, write to
CSA Group
178 Rexdale Boulevard, Toronto, Ontario, M9W 1R3
Canada

American National Standards Institute

The American National Standards Institute (ANSI), Inc. is the nationally recognized coordinator of voluntary standards development in the United States through which voluntary organizations, representing virtually every technical discipline and every facet of trade and commerce, organized labor and consumer interests, establish and improve the some 10 000 national consensus standards currently approved as American National Standards.

ANSI provides that the interests of the public may have appropriate participation and representation in standardization activity, and cooperates with departments and agencies of U.S. Federal, state and local governments in achieving compatibility between government codes and standards and the voluntary standards of industry and commerce.

ANSI represents the interests of the United States in international nontreaty organizations such as the International Organization for Standardization (ISO) and the International Electrotechnical Commission (IEC). The Institute maintains close ties with regional organizations such as the Pacific Area Standards Congress (PASC) and the Pan American Standards Commission (COPANT). As such, ANSI coordinates the activities involved in the U.S. participation in these groups.

ANSI approval of standards is intended to verify that the principles of openness and due process have been followed in the approval procedure and that a consensus of those directly and materially affected by the standards has been achieved. ANSI coordination is intended to assist the voluntary system to ensure that national standards needs are identified and met with a set of standards that are without conflict or unnecessary duplication in their requirements.

Responsibility of approving American standards rests with the
American National Standards Institute, Inc.
25 West 43rd Street, Fourth floor
New York, NY 10036

***National Standard of Canada
American National Standard***

ASME/CSA Standard

***ASME A112.19.1-2024 • CSA B45.2-24
Enamelled cast iron and enamelled steel
plumbing fixtures***



®A trademark of the Canadian Standards Association
and CSA America Inc., operating as "CSA Group"



*Approved on February 13, 2024 by ANSI
Published in March 2024 by CSA Group
A not-for-profit private sector organization
178 Rexdale Boulevard, Toronto, Ontario, Canada M9W 1R3
1-800-463-6727 • 416-747-4044*

Visit the CSA Group Online Store at www.csagroup.org/store/

*The American Society of Mechanical Engineers (ASME)
Two Park Avenue
New York, NY 10016-5990, USA
1-800-843-2763*

Visit the ASME Online Store at www.asme.org

Commitment for Amendments

This Standard is issued jointly by the American Society of Mechanical Engineers (ASME) and the Canadian Standards Association (Operating as “CSA Group”). Amendments to this Standard will be made only after processing according to the Standards writing procedures of both ASME and CSA Group.

The American Society of Mechanical Engineers (ASME)
Two Park Avenue
New York, NY 10016-5990
USA
1-800-843-2763

Visit the ASME Online Store at
www.asme.org

ISBN 978-0-7918-7666-4
Copyright © 2024 by The American Society of Mechanical Engineers (ASME)

This Standard is available for public review on a continuous basis. This provides an opportunity for additional public input from industry, academia, regulatory agencies, and the public at large.

Published in March 2024 by
CSA Group
A not-for-profit private sector organization
178 Rexdale Boulevard
Toronto, Ontario, Canada
M9W 1R3
1-800-463-6727 or 416-747-4044
Visit the CSA Group Online Store at
www.csagroup.org/store/

ISBN 978-1-4883-4899-0
ICS 91.140.70
© 2024 Canadian Standards Association

All rights reserved. No part of this publication may be reproduced in any form whatsoever without the prior permission of the publisher.

Contents

Technical Committee on Plumbing Fixtures 3

ASME A112 Standards Committee on Plumbing Materials and Equipment 8

Preface 12

1 Scope 15

- 1.1 Overview 15
- 1.2 Inclusions 15
- 1.3 Terminology 15
- 1.4 Units 15

2 Reference publications 16

3 Definitions 17

4 General requirements 19

- 4.1 General 19
 - 4.1.1 Materials 19
 - 4.1.2 Surface finish 19
 - 4.1.3 Quality of work 19
 - 4.1.4 Wall brackets 19
- 4.2 Cast iron thickness 19
- 4.3 Tolerances 19
- 4.4 Enamel 19
 - 4.4.1 General 19
 - 4.4.2 Specular gloss 19
 - 4.4.3 Reflectance 19
 - 4.4.4 Enamel thickness 20
 - 4.4.5 Surface treatments 20
- 4.5 Waste fitting openings and overflows 20
 - 4.5.1 Waste fitting openings 20
 - 4.5.2 Overflows 20
- 4.6 Additional requirements for lavatories and sinks — Openings and mounting surfaces for supply fittings 21
 - 4.6.1 General 21
 - 4.6.2 Factory-supplied lavatory and sink supply fittings 21
 - 4.6.3 Mounting surfaces 21
- 4.7 Additional requirements for bathtubs and shower bases 21
 - 4.7.1 Minimum dimensions for bathtubs 21
 - 4.7.2 Slope to the waste outlet 21
 - 4.7.3 Flanges 21
 - 4.7.4 Slip-resistant surfaces 22
 - 4.7.5 Supply fittings 22
 - 4.7.6 Apron bathtubs 22
- 4.8 Additional requirements for drinking fountains 22
 - 4.8.1 General 22

- 4.8.2 Drinking fountain supply fittings 22
- 4.9 Accessible design fixtures 22

5 Test methods 22

- 5.1 Acid resistance test 22
 - 5.1.1 Procedure 22
 - 5.1.2 Performance 23
- 5.2 Surface examination 23
 - 5.2.1 Procedure 23
 - 5.2.2 Performance 23
- 5.3 Warpage test 23
 - 5.3.1 Procedure 23
 - 5.3.2 Performance 23
- 5.4 Field-installed tiling-flange seal test 23
 - 5.4.1 Procedure 23
 - 5.4.2 Performance 24
- 5.5 Overflow test — Lavatories and sinks 24
 - 5.5.1 Procedure 24
 - 5.5.2 Performance 24
- 5.6 Structural integrity tests for enamelled steel bathtubs, lavatories, and sinks 24
 - 5.6.1 Bathtubs 24
 - 5.6.2 Lavatories and sinks 26
 - 5.6.3 Surface examination 26

6 Markings, packaging, and literature 27

- 6.1 General 27
 - 6.1.1 Enamelled cast iron and enamelled steel fixtures 27
 - 6.1.2 Markings requirements 27
 - 6.1.3 Permanent markings 27
 - 6.1.4 Adhesive labels 27
- 6.2 Non-standard fixtures 27
- 6.3 Field-installed flanges 27
- 6.4 Packaging 28
- 6.5 Wall-mounted fixtures 28

-
- Annex A (informative) — Unit conversion criteria 37

Technical Committee on Plumbing Fixtures

C. J. Lagan	American Standard Brands/LWTA, Piscataway, New Jersey, USA <i>Category: Producer Interest</i>	<i>Chair</i>
M. Guard	Regulosity LLC, Milwaukee, Wisconsin, USA <i>Category: General Interest</i>	<i>Vice-Chair</i>
C. Wright	Ontario Pipe Trades, Dundalk, Ontario, Canada <i>Category: User Interest</i>	<i>Vice-Chair</i>
L. Adams	City of Edmonton, Edmonton, Alberta, Canada <i>Category: Regulatory Authority</i>	
J. Adili	ULSE LLC, Northbrook, Illinois, USA	<i>Non-voting</i>
A. Ahuja	Masco Canada Ltd., St. Thomas, Ontario, Canada	<i>Non-voting</i>
W. T. Ball	WCM Industries Inc., Colorado Springs, Colorado, USA	<i>Non-voting</i>
J. E. Bertrand	Watts Water Technologies Inc., Avon, Ohio, USA <i>Category: Producer Interest</i>	
A. Brhelle	Masco Canada, St. Thomas, Ontario, Canada	<i>Non-voting</i>
J. Briggs	NSF International, Ann Arbor, Michigan, USA	<i>Non-voting</i>
T. Burke	Victoria + Albert Baths Ltd., Telford, Shropshire, United Kingdom	<i>Non-voting</i>
R. Burnham	Zurn Industries LLC, Erie, Pennsylvania, USA <i>Category: Producer Interest</i>	

M. Campos	ICC Evaluation Service LLC, Brea, California, USA	<i>Non-voting</i>
W. E. Chapin	Professional Code Consulting LLC, Cullman, Alabama, USA	<i>Non-voting</i>
S. Chen	Masco R&D, Taylor, Michigan, USA	<i>Non-voting</i>
E. Cometa	CSA Group Testing and Certification Inc., Toronto, Ontario, Canada	<i>Non-voting</i>
D. J. Compton	Thetford Corp., Ann Arbor, Michigan, USA	<i>Non-voting</i>
J. Confrey	Falcon Water Technologies, Los Angeles, California, USA	
A. De Francesca	City of Toronto, Toronto, Ontario, Canada <i>Category: Regulatory Authority</i>	
P. Despatis	Régie du bâtiment du Québec, Montréal, Québec, Canada <i>Category: Regulatory Authority</i>	
N. Dickey	Hansgrohe Inc., Alpharetta, Georgia, USA	<i>Non-voting</i>
Y. Duchesne	Régie du bâtiment du Québec, Québec, Québec, Canada	<i>Non-voting</i>
K. Ernst	Oakville Stamping and Bending Ltd., Oakville, Ontario, Canada <i>Category: Producer Interest</i>	
F. Fernández	Toto USA Inc., Ontario, California, USA <i>Category: Producer Interest</i>	
M. E. Fish	Zurn Industries LLC, Cary, North Carolina, USA	<i>Non-voting</i>
M. R. Gibeault	Kohler Co. Plumbing Division, Kohler, Wisconsin, USA	<i>Non-voting</i>

D. Gleiberman	Sloan, Los Angeles, California, USA	<i>Non-voting</i>
D. Grenier	BainUltra Inc., Lévis, Québec, Canada	<i>Non-voting</i>
N. Haynes	Region of Waterloo, Kitchener, Ontario, Canada <i>Category: User Interest</i>	
L. Himmelblau	Chicago Faucets Geberit Manufacturing Division, Des Plaines, Illinois, USA <i>Category: Producer Interest</i>	
E. Ho	IAPMO Group, Markham, Ontario, Canada	<i>Non-voting</i>
E. Hood	H. H. Angus and Associates Ltd., Toronto, Ontario, Canada <i>Category: User Interest</i>	
K. S. Hui	Ontario Ministry of Municipal Affairs, Toronto, Ontario, Canada <i>Category: Regulatory Authority</i>	
J. Knapton	Southern Alberta Institute of Technology, Calgary, Alberta, Canada <i>Category: General Interest</i>	
T. Knull	Alberta Municipal Affairs, Lethbridge, Alberta, Canada <i>Category: Regulatory Authority</i>	
J. M. Koeller	Koeller and Company, Yorba Linda, California, USA <i>Category: General Interest</i>	
F. Lemieux	Health Canada, Ottawa, Ontario, Canada <i>Category: Regulatory Authority</i>	
D. Liang	CSA Group, Toronto, Ontario, Canada	<i>Non-voting</i>
R. Liao	Xiamen Lota International Co. Ltd., Xiamen, Fujian, China	<i>Non-voting</i>

J. Loera	Fluidmaster Inc., San Juan Capistrano, California, USA	<i>Non-voting</i>
J. MacDonald	BLANCO Canada Inc., Brampton, Ontario, Canada	<i>Non-voting</i>
D. Marbry	Fluidmaster Inc., San Juan Capistrano, California, USA <i>Category: Producer Interest</i>	
R. Mata	International Code Council, Washington, District of Columbia, USA	<i>Non-voting</i>
T. J. McCann	Department of National Defence, Ottawa, Ontario, Canada <i>Category: User Interest</i>	
J. McDonald	Fortune Brands — Global Plumbing Group, North Olmsted, Ohio, USA	<i>Non-voting</i>
K. Moriel	City of Brampton, Brampton, Ontario, Canada	<i>Non-voting</i>
A. I. Murra	Abraham Murra Consulting, Santa Margarita, California, USA <i>Category: General Interest</i>	
R. Neff	Delta Faucet Company, Indianapolis, Indiana, USA <i>Category: Producer Interest</i>	
B. Nichols	City of Brampton, Brampton, Ontario, Canada	<i>Non-voting</i>
D. Orton	NSF International, Ann Arbor, Michigan, USA	<i>Non-voting</i>
P. Paré	Consumer Representative, Lemoyne, Québec, Canada	<i>Non-voting</i>
R. Pickering	Eastern Research Group Inc. (ERG), Morrisville, North Carolina, USA	<i>Non-voting</i>
S. M. Rawalpindiwala	Kohler, Wisconsin, USA <i>Category: Producer Interest</i>	

S. A. Remedios	Remedios Consulting, London, Ontario, Canada <i>Category: User Interest</i>	
S. Rouleau	Intertek, Ste-Marie, Québec, Canada	<i>Non-voting</i>
S. Shang	China Building Material Test and Certification Group (Shaanxi) Co. Ltd., Shaanxi, China	<i>Non-voting</i>
M. Sigler	International Code Council, Orlando, Florida, USA	<i>Non-voting</i>
W. Smith	American Society of Plumbing Engineers (ASPE), Montgomery, Alabama, USA <i>Category: General Interest</i>	
S. Tanner	U.S. Environmental Protection Agency, Washington, DC, USA <i>Category: General Interest</i>	
K. Thompson	Plumbing Manufacturers International, McLean, Virginia, USA	<i>Non-voting</i>
T. Valente	CSA Group, Cleveland, Ohio, USA	<i>Non-voting</i>
J. C. Watson	International Association of Plumbing and Mechanical Officials (IAPMO), Westchester, Illinois, USA	<i>Non-voting</i>
C. White	ASSE International, Mokena, Illinois, USA	<i>Non-voting</i>
F. Zhang	China Building Material Test and Certification Group (Shaanxi) Co. Ltd., Shaanxi, China	<i>Non-voting</i>
M. Khalil	CSA Group, Toronto, Ontario, Canada	<i>Project Manager</i>

ASME A112 Standards Committee on Plumbing Materials and Equipment

W. M. Smith	American Society of Plumbing Engineers (ASPE), Montgomery, Alabama, USA	<i>Chair</i>
S. M. Rawalpindiwala	Kohler Co. Plumbing Division, Kohler, Wisconsin, USA	<i>Vice-Chair</i>
A. L. Guzman Rodriguez	American Society of Mechanical Engineers, New York, New York, USA	<i>Secretary</i>
J. A. Ballanco	JB Engineering and Code Consulting PC, Munster, Indiana, USA	
J. E. Bertrand	Watts Water Technologies Inc., Avon, Ohio, USA	
T. Burger	ASSE International, Mokena, Illinois, USA	
R. Burnham	Zurn Industries LLC, Erie, Pennsylvania, USA	
M. Campos	ICC Evaluation Service LLC, Brea, California, USA	
S. L. Cavanaugh	Cavanaugh Consulting, Santa Fe, New Mexico, USA	<i>Contributing Member</i>
W. E. Chapin	Professional Code Consulting LLC, Cullman, Alabama, USA	
A. Ciechanowski	NSF International, Ann Arbor, Michigan, USA	<i>Alternate</i>
P. V. DeMarco	IAPMO Group, Dayton, New Jersey, USA	
N. E. Dickey	Hansgrohe Inc., Alpharetta, Georgia, USA	

G. S. Duren	Code Compliance Inc., South Pasadena, Florida, USA	
A. R. Emmerson	Consultant, Arlington Heights, Illinois, USA	
K. Ernst	Oakville Stamping and Bending Ltd., Oakville, Ontario, Canada	
R. L. George	Plumb-Tech Design and Consulting Services LLC, Newport, Michigan, USA	
M. R. Gibeault	Kohler Co. Plumbing Division, Kohler, Wisconsin, USA	<i>Alternate</i>
D. Gleiberman	Sloan Valve Co., Los Angeles, California, USA	
M. Guard	Regulosity LLC, Wauwatosa, Wisconsin, USA	
C. Haldiman	Watts Water Technologies Inc., North Andover, Massachusetts, USA	<i>Alternate</i>
G. W. Harrison	Consultant/Plumbing Instructor, Edmond, Oklahoma, USA	
L. Himmelblau	The Chicago Faucet Company, Des Plaines, Illinois, USA	
J. Kendzel	American Supply Association, Itasca, Illinois, USA	<i>Contributing Member</i>
J. M. Koeller	Koeller and Co., Yorba Linda, California, USA	
C. J. Lagan	American Standard/LIXIL, Piscataway, New Jersey, USA	
J. W. Lauer	Sloan Valve Co., Anaheim, California, USA	<i>Alternate</i>
W. LeVan	Cast Iron Soil Pipe Institute, Auburn, Alabama, USA	

D. Liang	CSA Group, Toronto, Ontario, Canada	<i>Contributing Member</i>
D. Marbry	Fluidmaster Inc., San Juan Capistrano, California, USA	
R. Mata	American Society of Plumbing Engineers, Mentor, Ohio, USA	
S. J. McDanal	Jay R. Smith Manufacturing Co., Montgomery, Alabama, USA	<i>Alternate</i>
L. A. Mercer	IAPMO Group, Valley City, Ohio, USA	
W. B. Morris	Charlotte Pipe and Foundry, Charlotte, North Carolina, USA	<i>Alternate</i>
A. I. Murra	Abraham Murra Consulting, Oakville, Ontario, Canada	
D. Orton	NSF International, Ann Arbor, Michigan, USA	
D. Parney	Cast Iron Soil Pipe Institute, Mundelein, Illinois, USA	<i>Alternate</i>
R. Pickering	Eastern Research Group Inc. (ERG), Morrisville, North Carolina, USA	<i>Contributing Member</i>
A. Poon	Delta Faucet Company, Indianapolis, Indiana, USA	
B. Ramkarran	Infinity Drain Ltd., Amityville, New York, USA	<i>Contributing Member</i>
S. A. Remedios	Remedios Consulting, London, Ontario, Canada	
M. Sigler	International Code Council, Orlando, Florida, USA	
G. L. Simmons	Charlotte Pipe and Foundry, Charlotte, North Carolina, USA	

S. Tanner	U.S. Environmental Protection Agency, Washington, DC, USA	<i>Contributing Member</i>
K. Thompson	Plumbing Manufacturers International, McLean, Virginia, USA	<i>Alternate</i>
J. Watson	International Association of Plumbing and Mechanical Officials (IAPMO), Westchester, Illinois, USA	
M. Weiss	Plumbing & Drainage Institute (PDI), Polson, Montana, USA	
W. C. Whitehead	Whitehead Consulting Services, Red Oak, Texas, USA	
M. Khalil	CSA Group, Toronto, Ontario, Canada	<i>Project Manager</i>

Preface

This is the fourth edition of ASME A112.19.1 • CSA B45.2, *Enamelled cast iron and enamelled steel plumbing fixtures*. It supersedes the previous editions published in 2018, 2013, and 2008.

The following are major changes to this edition:

- a) addition of instructions for wall-mounted fixtures installations;
- b) addition of requirements for supply fittings;
- c) modifications to the shower base flanges requirements; and
- d) modifications to definitions in Clause [3](#).

This harmonized Standard was developed in response to an industry request for a Standard for evaluation of plumbing fixtures that would be acceptable for use in both Canada and the United States. Harmonized standards for plumbing fixtures made of other materials are also available or under development.

This Standard is considered suitable for use for conformity assessment within the stated scope of the Standard.

This Standard was prepared by the ASME A112 Standards Committee on Plumbing Materials and Equipment and the CSA Technical Committee on Plumbing Fixtures. The CSA Technical Committee operates under the jurisdiction of the CSA Strategic Steering Committee on Construction and Civil Infrastructure.

This Standard has been approved by the American National Standards Institute (ANSI) as an American National Standard on February 13, 2024.

This Standard has been developed in compliance with Standards Council of Canada requirements for National Standards of Canada. It has been published as a National Standard of Canada by CSA Group.

ASME Notes:

- 1) *This standard was developed under procedures accredited as meeting the criteria for American National Standards and it is an American National Standard. The Standards Committee that approved the code or standard was balanced to assure that individuals from competent and concerned interests have had an opportunity to participate. The proposed Standard was made available for public review and comment that provides an opportunity for additional public input from industry, academia, regulatory agencies, and the public-at-large.*
- 2) *ASME does not “approve,” “rate,” or “endorse” any item, construction, proprietary device, or activity.*
- 3) *ASME does not take any position with respect to the validity of any patent rights asserted in connection with any items mentioned in this document, and does not undertake to insure anyone utilizing a standard against liability for infringement of any applicable letters patent, nor assume any such liability. Users of a standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, is entirely their own responsibility.*
- 4) *Participation by federal agency representative(s) or person(s) affiliated with industry is not to be interpreted as government or industry endorsement of this standard.*
- 5) *ASME accepts responsibility for only those interpretations of this document issued in accordance with the established ASME procedures and policies, which precludes the issuance of interpretations by individuals.*

- 6) ASME issues written replies to inquiries concerning interpretation of technical aspects of this Standard. All inquiries regarding this Standard, including requests for interpretations, should be addressed to:

Secretary, A112 Standards Committee
The American Society of Mechanical Engineers
Two Park Avenue
New York, NY 10016-5990

A request for interpretation should be clear and unambiguous. The request should

- cite the applicable edition of the Standard for which the interpretation is being requested.
- phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. The inquirer may also include any plans or drawings, which are necessary to explain the question; however, they should not contain proprietary names or information.

ASME procedures provide for reconsideration of any interpretation when or if additional information that might affect an interpretation is available. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME Committee.

Interpretations are published on the ASME Web site under the Committee Pages at <http://www.asme.org/codes/> as they are issued.

CSA Notes:

- 1) Use of the singular does not exclude the plural (and vice versa) when the sense allows.
- 2) Although the intended primary application of this Standard is stated in its Scope, it is important to note that it remains the responsibility of the users of the Standard to judge its suitability for their particular purpose.
- 3) This publication was developed by consensus, which is defined by CSA Policy governing standardization — Code of good practice for standardization as “substantial agreement. Consensus implies much more than a simple majority, but not necessarily unanimity”. It is consistent with this definition that a member may be included in the Technical Committee list and yet not be in full agreement with all clauses of this Standard.
- 4) To submit a request for interpretation of this Standard, please send the following information to inquiries@csagroup.org and include “Request for interpretation” in the subject line:
 - a) define the problem, making reference to the specific clause, and, where appropriate, include an illustrative sketch;
 - b) provide an explanation of circumstances surrounding the actual field condition; and
 - c) where possible, phrase the request in such a way that a specific “yes” or “no” answer will address the issue.

Committee interpretations are processed in accordance with the CSA Directives and guidelines governing standardization and are available on the Current Standards Activities page at standardsactivities.csagroup.org.

- 5) This Standard is subject to review within five years from the date of publication. Suggestions for its improvement will be referred to the appropriate committee. To submit a proposal for change, please send the following information to inquiries@csagroup.org and include “Proposal for change” in the subject line:
 - a) Standard designation (number);
 - b) relevant clause, table, and/or figure number;
 - c) wording of the proposed change; and
 - d) rationale for the change.
- 6) Attention is drawn to the possibility that some of the elements of this Standard may be the subject of patent rights. CSA is not to be held responsible for identifying any or all such patent rights. Users

of this Standard are expressly advised that determination of the validity of any such patent rights is entirely their own responsibility.

ASMENORMDOC.COM : Click to view the full PDF of ASME A112.19.1 CSA B45.2 2024

ASME A112.19.1-2024 • CSA B45.2:24

Enamelled cast iron and enamelled steel plumbing fixtures

1 Scope

1.1 Overview

This Standard covers enamelled cast iron and enamelled steel plumbing fixtures, and specifies requirements for materials, construction, performance, testing, and markings.

1.2 Inclusions

This Standard covers the following plumbing fixtures:

- a) bathtubs;
- b) drinking fountains and water coolers;
- c) lavatories;
- d) shower bases; and
- e) sinks:
 - i) bar sinks;
 - ii) clinic sinks;
 - iii) kitchen sinks;
 - iv) laboratory sinks;
 - v) laundry sinks;
 - vi) service sinks; and
 - vii) utility sinks.

1.3 Terminology

In this Standard, “shall” is used to express a requirement, i.e., a provision that the user is obliged to satisfy in order to comply with the Standard; “should” is used to express a recommendation or that which is advised but not required; and “may” is used to express an option or that which is permissible within the limits of the Standard.

Notes accompanying clauses do not include requirements or alternative requirements; the purpose of a note accompanying a clause is to separate from the text explanatory or informative material.

Notes to tables and figures are considered part of the table or figure and may be written as requirements.

Annexes are designated normative (mandatory) or informative (non-mandatory) to define their application.

1.4 Units

SI units are the units of record in Canada. In this Standard, the yard/pound units are shown in parentheses. The values stated in each measurement system are equivalent in application; however, each system is to be used independently. Combining values from the two measurement systems can result in non-conformance with this Standard.

All references to gallons are to U.S. gallons.

For information on the unit conversion criteria used in this Standard, see Annex [A](#).

2 Reference publications

This Standard refers to the following publications, and where such reference is made, it shall be to the edition listed below, including all amendments published thereto.

CSA Group

B125.3:22

Plumbing fittings

B651-12 (R2017)

Accessible design for the built environment

C22.2 No. 0.15:15 (R2020)

Adhesive labels

ASME (American Society of Mechanical Engineers)/CSA Group

ASME A112.18.1-2018/CSA B125.1-18

Plumbing supply fittings

ASME A112.18.2-2020/CSA B125.2:20

Plumbing waste fittings

ASME A112.19.2-2018/CSA B45.1-18

Ceramic plumbing fixtures

ASTM International (American Society for Testing and Materials)

C282-20

Standard Test Method for Acid Resistance of Porcelain Enamels (Citric Acid Spot Test)

C346-87 (2018)

Standard Test Method for 45-deg Specular Gloss of Ceramic Materials

E1347-06 (2020)

Standard Test Method for Color and Color-Difference Measurement by Tristimulus Colorimetry

F462-79 (2007)

Standard Consumer Safety Specification for Slip-Resistant Bathing Facilities

ICC/ANSI (International Code Council/American National Standards Institute)

A117.1-2017

Accessible and Usable Buildings and Facilities

UL (Underwriters Laboratories Inc.)

969 (2023)

Standard for Marking and Labeling Systems

3 Definitions

The following definitions shall apply in this Standard:

Air gap — the unobstructed vertical distance, through the open atmosphere, between the lowest opening of a water supply and the flood level of the fixture.

Apron bathtub — a bathtub with an exposed external wall.

Note: *The exposed external wall is sometimes called a skirt.*

Bathing surface — the portion of the sump of a bathtub on which, in accordance with common usage or design, a bather might step or stand while bathing or showering, and which is exclusive of ledges or rims.

Defect —

Blister — a hollow raised portion of the enamel surface of a cast iron or steel fixture.

Large blister — a blister with a dimension greater than 6 mm (0.24 in).

Medium blister — a blister whose largest dimension is between 1 and 6 mm (0.04 and 0.24 in).

Small blister — a blister whose largest dimension is less than 1 mm (0.04 in).

Chip — a blemish in the enamel exposing the undercoat or base metal.

Crack — a fracture in the surface or the substrate material of a fixture.

Craze (crazing) — separate and numerous hairlines in the enamel surface.

Note: *The lines can vary in length and can be up to several centimetres long.*

Hairline — a line within the enamel surface whose width does not exceed 0.05 mm (0.002 in).

Dimple — a depression in the enamel surface.

Lump — a raised portion of the enamel surface.

Speck — a particle of foreign matter that produces areas of contrasting colour on the enamel surface of a fixture.

Large speck — a speck with a dimension greater than 0.80 mm (0.031 in).

Medium speck — a speck whose largest dimension is between 0.40 and 0.80 mm (0.016 and 0.031 in).

Small speck — a speck whose largest dimension is greater than 0.25 mm (0.010 in) but less than 0.40 mm (0.016 in).

Spot — an area of contrasting colour.

Enamelled cast iron — a product cast from molten iron and coated with enamel fused to the metal (see **Porcelain enamel**).

Note: *The enamel coating is hard, glossy, opaque, and acid-resistant, and, in combination with the solid cast iron base, produces a rigid, durable product.*

Enamelled steel — steel that can be satisfactorily porcelain enamelled, including the following:

- a) special-purpose enamelling iron or steel of low metalloid and copper content that is specially manufactured and processed for the production of porcelain-enamelled fixtures;
- b) special steels designed for porcelain-enamel application; and
- c) cold-rolled steel.

Finish — the texture and condition of a surface (excluding colour).

Fitting — a device that controls and guides the flow of water.

Note: See ASME A112.18.1/CSA B125.1 and CSA B125.3 for definitions of specific types of fittings.

Fixture — a device that receives water, waste matter, or both and directs these substances into a drainage system.

Note: See ASME A112.19.2/CSA B45.1 for definitions of specific types of fixtures.

Flood level — the level at which water will overflow a fixture.

Inspection window — a circular opening 76 mm (3.0 in) in diameter cut into a sheet of flexible material and used to count the number of defects in the opening (see Table 1).

Lavatory — a washbowl or basin.

Ledge back — a flat elevated surface at the back of a lavatory, sink, or laundry sink, not more than 51 mm (2.0 in) higher than the rim and extending the full length of the fixture, on which the supply fitting can be mounted and small articles can be placed, or a similar construction with a centre panel suitable for mounting a supply fitting.

Overflow — a conduit that is integral or attached to a fixture and whose function is to remove liquid from a fixture after the fixture has been filled past the desired level.

Porcelain enamel — a vitreous or glossy inorganic coating that is bonded to the metal by fusion at a high temperature.

Rim — the unobstructed open edge of a fixture.

Satin finish — a very smooth surface with low or dull reflective properties.

Shelf back — a flat elevated surface at the back of a lavatory, sink, or laundry sink more than 51 mm (2.0 in) higher than the rim and extending the full length of the fixture, on the top or front of which the supply fitting can be mounted and small articles can be placed, or a similar construction with a centre panel formed into the shelf suitable for mounting a supply fitting on either a horizontal or inclined surface.

Spill level — the level at which water will flow out of one bowl into another bowl of the same fixture.

Visible surface — a surface of a fixture that is readily visible to an observer in a normal standing position after the fixture is installed.

Visible after installation — a surface that remains visible (not necessarily from a normal standing position) after the fixture is installed.

4 General requirements

4.1 General

4.1.1 Materials

All materials shall be free from deficiencies that affect the fixture's intended purpose.

4.1.2 Surface finish

Fixtures shall have a surface free from defects to the extent specified in Table 1 when evaluated in accordance with Clause 5.2.

4.1.3 Quality of work

Fixtures shall not have any exposed sharp or jagged edges, burrs, cracks, or other defects that might affect their use and serviceability (see Clause 5.2).

4.1.4 Wall brackets

Wall brackets shall be used when lavatories are supported by cast iron legs.

4.2 Cast iron thickness

Cast iron shall be at least 3 mm (0.13 in) thick when measured at least 25 mm (1.0 in) from the edge of the fixture.

4.3 Tolerances

Unless otherwise specified in this Standard, the tolerance on dimensions of 200 mm (8 in) and greater shall be $\pm 3\%$. The tolerance on dimensions less than 200 mm (8 in) shall be $\pm 5\%$.

In this Standard, dimensions specified as "minimum" or "maximum" shall not be reduced below the specified minimum or increased above the specified maximum by application of a tolerance. If a dimensional range is specified and the word "minimum" or "maximum" does not appear, the upper and lower limits shall not be considered critical and the appropriate tolerance shall apply.

4.4 Enamel

4.4.1 General

Enamelled surfaces shall be enamelled using acid-resisting enamel thoroughly fused to the cast iron or steel. The enamel shall be of uniform colour and free from defects that affect the appearance or can affect the serviceability of the fixture.

4.4.2 Specular gloss

Enamelled surfaces visible after installation shall be glossy to the extent that they shall have a 45° (0.79 rad) specular gloss of not less than 45 when tested in accordance with ASTM C346.

4.4.3 Reflectance

If the enamel is white, its reflectance shall be not less than 72% when measured in accordance with ASTM E1347.

4.4.4 Enamel thickness

The thickness of the enamel, measured on a flat surface at least 25 mm (1.0 in) from any edge of the fixture, shall be at least 0.64 mm (0.025 in) for cast iron and 0.13 mm (0.005 in) for steel.

4.4.5 Surface treatments

Before they are enamelled, surfaces shall be treated with ground coat. After enamelling, any surface subject to rework that exposes base metal shall be factory treated with rust inhibitor. All other steel surfaces shall be treated with at least one coat of filler, ground coat, or paint.

4.5 Waste fitting openings and overflows

4.5.1 Waste fitting openings

4.5.1.1 General

Fixtures shall

- a) have a waste fitting opening (outlet), the centre of which shall be located at the lowest point of the fixture; and
- b) drain to the waste outlet.

4.5.1.2 Waste outlets — Dimensions

Except when proprietary (i.e., non-standard) waste fittings are provided by the manufacturer, the dimensions of waste outlets shall be as shown in Figure 1.

4.5.1.3 Factory-supplied waste fittings

Factory-supplied waste fittings shall comply with ASME A112.18.2/CSA B125.2.

4.5.2 Overflows

4.5.2.1 Lavatories and sinks

4.5.2.1.1 General

Overflows may be provided at the option of the manufacturer. When overflows are provided, the manner in which they are positioned shall be at the option of the manufacturer.

4.5.2.1.2 Overflow installation

When provided, overflows in sinks intended for washing dishes and food preparation (e.g., kitchen and bar sinks) shall not be concealed and shall be accessible for disassembly and cleaning after installation.

4.5.2.1.3 Performance

Overflows shall comply with Clause 5.5.

4.5.2.2 Bathtubs

Overflows in bathtubs may be provided at the option of the manufacturer. When overflows are provided, their dimension, location, and position in relation to the waste outlet in the fixture shall be as shown in Figure 7.

Variations in location, geometry, diameter, and angle of orientation of the overflow opening shall be acceptable when factory-provided waste and overflow fittings are provided.

Note: Some plumbing codes require bathtub overflows.

4.6 Additional requirements for lavatories and sinks — Openings and mounting surfaces for supply fittings

4.6.1 General

When provided, openings and mounting surfaces for lavatory and sink supply fittings shall be as shown in Figures 2 to 6, except when proprietary (i.e., non-standard) supply fittings are provided by the manufacturer.

4.6.2 Factory-supplied lavatory and sink supply fittings

Factory-supplied lavatory and sink supply fittings shall comply with ASME A112.18.1/CSA B125.1.

4.6.3 Mounting surfaces

Mounting surfaces for supply fittings that rely on an air gap for backflow protection shall be not more than 13 mm (0.5 in) below the flood level rim.

Note: Care should be taken to ensure the minimum air gap specified in ASME A112.18.1/CSA B125.1 or in the applicable plumbing code is not compromised when supply fittings are installed on fixtures with mounting surfaces below the flood level rim.

4.7 Additional requirements for bathtubs and shower bases

4.7.1 Minimum dimensions for bathtubs

The minimum dimensions for bathtubs shall be as shown in Figure 7.

4.7.2 Slope to the waste outlet

Bathtubs and shower bases shall have a maximum slope of 4% to the waste outlet.

Note: There should be a minimum slope of 1% to the waste outlet.

4.7.3 Flanges

4.7.3.1 Installation against a wall

Bathtubs and shower bases intended for installation against a wall shall incorporate a flange raised at least 8 mm (0.3 in) above the rim or threshold and comply with Clauses 4.7.3.3 to 4.7.3.5.

4.7.3.2 Installation against and securing to a wall

Shower bases intended for installation against and securing to a wall shall incorporate a continuously raised flange at least 25 mm (1.0 in) above the threshold and comply with Clauses 4.7.3.3 to 4.7.3.5.

4.7.3.3 Flanges requirements

The flange shall be

- integral with the bathtub or shower base;
- added to an island tub or shower base in the factory; or
- field-installed and in compliance with Clause 5.4.

4.7.3.4 Field-installed flanges

Bathtubs and shower bases using field-installed flanges shall be marked in accordance with Clause [6.3](#).

4.7.3.5 Hole or corner treatment

The bottom of any hole in the flange or corner treatment shall be not less than 8 mm (0.3 in) above the rim or threshold.

4.7.4 Slip-resistant surfaces

The slip-resistant surfaces of bathtubs and shower bases shall comply with ASTM F462 and have the dimensions shown in Figure [8](#). Alternative slip-resistant patterns shall be considered acceptable provided coverage begins within 50 mm (2.0 in) of the basin radius as shown in Figure [8](#) d).

4.7.5 Supply fittings

Factory-supplied supply fittings shall comply with ASME A112.18.1/CSA B125.1.

4.7.6 Apron bathtubs

The tolerance on the length of apron bathtubs shall be ± 13 mm (± 0.5 in).

4.8 Additional requirements for drinking fountains

4.8.1 General

Drinking fountains shall

- a) include a supply fitting, which shall be at least 25 mm (1.0 in) above the flood level rim; and
- b) comply with the dimensions shown in Figure [9](#).

Note: Drinking fountain supply fittings are also known as drinking fountain bubblers.

4.8.2 Drinking fountain supply fittings

Drinking fountain supply fittings shall comply with ASME A112.18.1/CSA B125.1, including the toxicity requirements.

Note: ASME A112.18.1/CSA B125.1 also includes lead content requirements.

4.9 Accessible design fixtures

Fixtures designed to be accessible shall comply with the dimensional requirements specified in CSA B651 or ICC/ANSI A117.1, as applicable.

5 Test methods

5.1 Acid resistance test

5.1.1 Procedure

The acid resistance test shall be conducted as follows:

- a) Prepare a solution made of 1 part citric acid crystals to 10 parts water, by weight.
- b) Store the solution for at least 3 h at a temperature of 27 ± 6 °C (80 ± 10 °F).
- c) Apply the solution to clean areas of the enamel, in pools consisting of several drops.
- d) Cover the solution with a watch glass and hold it in place for 15 ± 2 min.

- e) At the end of the 15 ± 2 min period, wash and dry the enamel.

5.1.2 Performance

The acid resistance of the enamel shall comply with the Class A requirements of ASTM C282.

5.2 Surface examination

5.2.1 Procedure

Visible surfaces shall be examined for defects by the unaided eye at a distance of approximately 610 mm (2 ft), using a light source of partially diffused daylight supplemented, if necessary, with diffused artificial light, giving an illuminance on the surface between 1076 and 2152 lx (100 and 200 foot-candles).

Note: “Unaided eye” includes vision assisted by corrective lenses normally worn by the person inspecting the specimen.

5.2.2 Performance

Defects shall not exceed the maximum specified in Table 1 (see Clause 4.12).

5.3 Warpage test

5.3.1 Procedure

The specimen shall be placed on a flat and level surface to ascertain the amount of deviation from the horizontal plane that exists at its edges.

A feeler gauge of a thickness equal to the total warpage allowed in Clause 5.3.2 shall not slide under the specimen unless forced.

If the specimen rocks on two opposite corners, the horizontal plane shall be determined by inserting a feeler gauge, as thick as the total warpage allowed, under a corner that does not touch the flat and level surface. The feeler gauge shall be inserted not more than 1.6 mm (0.063 in). Forcing the specimen down on this gauge, a second feeler gauge of the same thickness shall not slide under the specimen at any other point.

5.3.2 Performance

When measured in accordance with Clause 5.3.1, the warpage at

- a) the edges of the fixture that are set against the wall or floor, or into cabinets or countertops, shall not exceed 5 mm/m (0.06 in/ft); and
- b) all other edges of the fixture shall not exceed 7.5 mm/m (0.09 in/ft).

5.4 Field-installed tiling-flange seal test

5.4.1 Procedure

The tiling-flange seal test shall be conducted as follows:

- a) Set up the specimen in accordance with the manufacturer’s instructions.
- b) Apply a continuous water spray to the flange seal at the joint with the fixture as follows:
 - i) using a 30° full jet spray nozzle;
 - ii) for 30 min;
 - iii) from a distance of 1.2 m (4 ft) from the face of the spray nozzle;

- iv) at an angle of 45°;
 - v) at a flow rate of 11.4 L/min (3.0 gpm); and
 - vi) at a temperature of 40 ± 5 °C (104 ± 9 °F).
- c) Inspect the specimen for water transmission through the joint to the back of the flange.

Note: Full Jet®, narrow angle 30° series, part No. 1/2 GG 3030, manufactured by Spraying Systems Co., North Avenue at Schmale Road, P.O. Box 7900, Wheaton, IL 60189, has been used for this test.

5.4.2 Performance

There shall be no water leakage through the flange and fixture joint.

5.5 Overflow test — Lavatories and sinks

5.5.1 Procedure

The overflow test shall be conducted as follows:

- a) Install the specimen using a waste fitting that complies with ASME A112.18.2/CSA B125.2.
- b) Supply water to the specimen at the maximum flow rate specified in ASME A112.18.1/CSA B125.1 for flow rate testing of a supply fitting appropriate for the specimen. If the specimen is a laundry or utility sink, the rate of water supply to the major compartment shall be at least 15 L/min (4 gpm) and to the minor compartment (if any) at least 9 L/min (2.4 gpm).
- c) Close the waste outlet.
- d) Measure the elapsed time from the onset of water flowing into the overflow opening until the water begins to flow over the flood level of the specimen.

5.5.2 Performance

The specimen shall drain for at least 5 min from the onset of water flowing into the overflow opening without overflowing its flood level rim.

5.6 Structural integrity tests for enamelled steel bathtubs, lavatories, and sinks

5.6.1 Bathtubs

5.6.1.1 Apparatus

The apparatus for testing the structural integrity of bathtubs shall be as follows:

- a) three micrometer dial gauges graduated to 0.03 mm (0.001 in);
- b) a loading device capable of applying a 1.3 kN (292 lbf) load without shock to the centre of the specimen bottom; and

Note: Calibrated weights or a suitable mechanical or hydraulic load applicator may be used.

- c) a 130 × 250 mm (5 × 10 in) pad to distribute the load over a 32 500 mm² (50.0 in²) area. The pad shall consist of a sheet of sponge rubber 19 mm (0.75 in) thick (Shore A durometer of 8 to 14), topped with a plate of plywood or stiffer material having a minimum thickness of 19 mm (0.75 in). The thickness of this plate shall be such that there is not more than 0.25 mm (0.01 in) deflection of the ends when the load is applied.

5.6.1.2 Set-up

The specimen shall be mounted in a wood frame simulating normal installation, as follows:

- a) The frame shall allow for clearance under the specimen for the dial gauges.
- b) The manufacturer's installation instructions shall be used for spacing the 2 × 4 dimensional lumber of the frame and for fastening the specimen to the frame.

- c) The top of the frame shall be at least 305 mm (12 in) higher than the top of the installed specimen.
- d) If legs or other component parts of the specimen are within 3 mm (0.13 in) of the floor line after installation, then rigid vertical support shall be provided.
- e) If the front apron of the specimen is not touching the test frame, then the apron shall be supported in a continuous bed of plaster of Paris.

5.6.1.3 Procedure

The structural test for bathtubs shall be conducted as follows:

- a) Maintain the temperature of the test area and specimen at 24 ± 6 °C (75 ± 10 °F).
- b) Inspect the finished surface of the specimen for cracks and other defects. Note all defects and damage.
- c) Centre the distribution pad over the horizontal centrelines of the specimen waste outlet with the 254 mm (10 in) dimension along the length of the waste outlet. Determine the waste outlet centrelines by using its average length and width.
- d) Place the three micrometer dial gauges on a rigid base beneath the longitudinal centreline of the waste outlet, with one gauge directly beneath the centre of the distribution pad and the other two within 51 mm (2.0 in) of each end of the bottom of the waste outlet.
- e) Ensure the areas where the tips of the gauges bear on the specimen are sufficiently flat and smooth that a small lateral movement of the specimen will not change the gauge reading by more than 0.03 mm (0.001 in).
- f) Prepare the bearing areas by grinding the undersurface or by rigidly fastening a small, flat, level plate to the specimen.
- g) If the waste outlet of the specimen interferes with the placement of the gauges, insert a standard spud into the outlet and use the flat surface on the spud for gauge bearing.
- h) Preload the specimen by applying a load of 1.3 kN (292 lbf) on the centre of the distribution pad for 5 min. Remove the load and take the initial dial gauge readings.
- i) Reload the specimen using the 1.3 kN (292 lbf) load and take gauge readings immediately following the load application, and again 5 min later.
- j) Remove the load and take gauge readings immediately following removal and again 10 min later.
- k) Calculate the average deflection of the specimen and supports by averaging the deflections measured by the two end gauges.
- l) Calculate the centre deflection (at the waste outlet) by subtracting the average deflection calculated in Item k) from the deflection measured by the centre gauge.
- m) After removal of the load, inspect the surface of the specimen for cracks in accordance with Clause [5.6.3](#). Note any other damage resulting from the testing.

5.6.1.4 Performance

5.6.1.4.1 General

When examined in accordance with Clause [5.6.3](#), bathtubs shall show no damage to the inner or outer surfaces as a result of testing. Cracking of the inner or outer surfaces, or separation of reinforcing members, shall be considered damage.

5.6.1.4.2 Centre deflection

Centre deflection 5 min after the load specified in Clauses [5.6.1.1](#) and [5.6.1.3](#) is applied shall be not greater than 3.18 mm (0.125 in). The residual centre deflection 10 min after the load is removed shall be not greater than 0.08 mm (0.003 in).

5.6.2 Lavatories and sinks

5.6.2.1 Apparatus

The apparatus for testing the structural integrity of lavatories and sinks shall consist of

- a) a loading device capable of applying a 445 or 890 N (100 or 200 lbf) load without shock to the centre of the specimen bottom; and

Note: Calibrated weights or a suitable mechanical or hydraulic load applicator may be used.

- b) pads for distributing the load, as follows:
 - i) for fixtures with a span of 762 mm (30.0 in) or more, a 190 × 200 mm (7.5 × 8.0 in) pad to distribute the load over a 38 700 mm² (60.0 in²) area. The pad shall consist of a sheet of sponge rubber 19 mm (0.75 in) thick (Shore A durometer of 8 to 14), topped with a plate of plywood or stiffer material having a minimum thickness of 19 mm (0.75 in); and
 - ii) for fixtures with a span of less than 762 mm (30.0 in), a pad as specified in Item b) i) except its dimensions shall be 130 × 150 mm (5 × 6 in) and it shall distribute the load over a 19 500 mm² (30.0 in²) area.

5.6.2.2 Set-up

The specimen shall be mounted in accordance with Clause [5.6.1.2](#).

5.6.2.3 Procedure

The structural test for enamelled lavatories and sinks shall be conducted as follows:

- a) Maintain the temperature of the test area and specimen at 24 ± 6 °C (75 ± 10 °F).
- b) Inspect the surfaces of the specimen. Note all defects and damage.
- c) Centre the distribution pad over the centre of the specimen bottom.
- d) Preload the specimen as follows:
 - i) For specimens with a span of 762 mm (30.0 in) or more, apply a load of 890 N (200 lb) at the centre of the distribution pad.
 - ii) For specimens with a span of less than 762 mm (30.0 in), apply a load of 445 N (100 lb) at the centre of the distribution pad.
 - iii) For double-compartment sinks, test each bowl based on its span in accordance with the applicable requirements specified in Item i) or ii) for a single fixture of comparable dimensions.
- e) Leave the load in place for 5 min and then remove the load to permit the specimen to settle in the frame for 2 min.
- f) Reload the specimen in accordance with Item d). Remove the load after 5 min and again permit the specimen to settle in the frame for 2 min.
- g) Reload the specimen in accordance with Item d). Remove the load after 10 min.
- h) Inspect the finished surface of the specimen in accordance with Clause [5.6.3](#).

5.6.2.4 Performance

When examined in accordance with Clause [5.6.3](#), lavatories and sinks shall show no damage to the inner or outer surfaces as a result of structural integrity tests. Cracking of the inner or outer surfaces, or separation of reinforcing members, shall be considered damage.

5.6.3 Surface examination

The surfaces of the specimen shall be examined as follows:

- a) Maintain the temperature of the inspection area and specimen at 24 ± 6 °C (75 ± 10 °F).
- b) Wash the specimen with soap and water, rinse, and dry.

- c) After drying, apply an ink solution consisting of 50% (by volume) water-soluble black ink in tap water (or an ink of a contrasting colour if the fixture is a colour other than white) with a sponge.
- d) Wipe any excess ink solution off the surface with a damp cloth and allow the specimen to dry.
- e) Examine the surface for chipping, cracking, crazing, or any other change in accordance with Clause [5.2.1](#).

6 Markings, packaging, and literature

6.1 General

6.1.1 Enamelled cast iron and enamelled steel fixtures

Enamelled cast iron and enamelled steel fixtures shall be marked with the manufacturer's name, registered trademark, or, in the case of private labelling, the name of the customer for whom the fixture was manufactured. Additional markings shall be in accordance with Clauses [6.3](#) and [6.4](#), as applicable.

6.1.2 Markings requirements

Markings shall be permanent, legible, and visible after installation.

6.1.3 Permanent markings

Acceptable means of applying permanent markings shall include firing on, etching, sand blasting, stamping with a permanent (non-water-soluble) ink, and casting in.

6.1.4 Adhesive labels

Adhesive labels that comply with CSA C22.2 No. 0.15 or UL 969 shall also be considered permanent when placed on a surface that is not normally submerged in water. The exposure conditions specified in Clause 7.1 of UL 969 shall apply.

6.2 Non-standard fixtures

Fixtures that require proprietary (i.e., non-standard) components (e.g., supply fittings or waste fittings) shall

- a) indicate in the packaging or the accompanying literature that such components are provided by the manufacturer; and
- b) be accompanied by literature that identifies the proper replacement parts.

6.3 Field-installed flanges

Bathtub and shower bases that use field-installed flanges, using a flange kit, shall have a non-permanent label stating

“Do not install this fixture against a wall unless the appropriate flange is first installed”.*

Flange kits shall include all necessary parts and fasteners, and shall include installation instructions.

* The equivalent French wording is « Ne pas fixer cet appareil au mur à moins que la bride appropriée n'ait été préalablement installée ».

6.4 Packaging

Packaging for enamelled cast iron and enamelled steel plumbing fixtures shall be marked with the

- a) manufacturer's name, registered trademark, or, in the case of private labelling, the name of the customer for whom the fixture was manufactured; and
- b) model number.

6.5 Wall-mounted fixtures

Wall-mounted fixtures shall include instructions for proper installation of the fixtures and minimum structural support requirements.

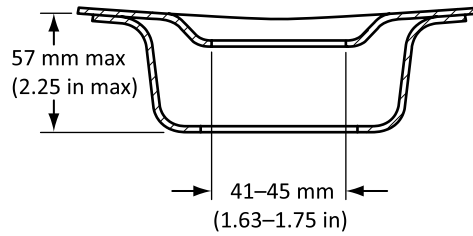
Table 1
Maximum allowable number of defects on fixtures
(See Clauses [3](#), [4.1.2](#), and [5.2.2](#).)

This Table depicts the maximum allowable number of defects permitted for any fixture being inspected. The first column lists the types of defects (e.g., specks, dimples, lumps) that can be observed during an inspection. The second and middle column specifies the maximum number of each type of defect permitted per inspection window. The third and final column specifies the maximum number of each type of defect permitted per fixture.

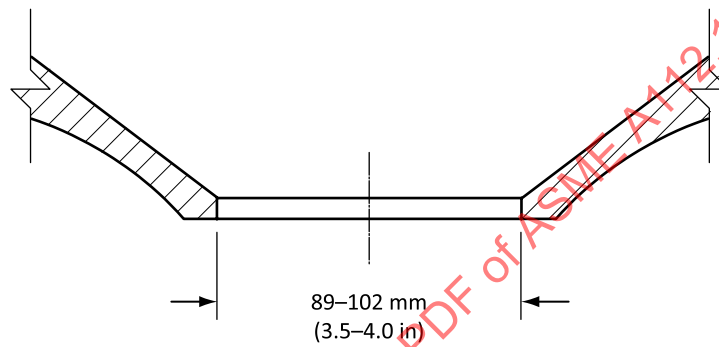
Defect	Maximum number per inspection window	Maximum number per fixture
Spot	4	No limit
Small speck	4	No limit
Medium speck	2	8
Large speck	1	5
Dimple	2	8
Lump	2	8
Large blisters	0	0
Medium blisters	0	0
Small blisters	2	4
Cracks	0	0
Chips	0*	0*

* Chips measuring 2.5 mm (0.10 in) or less in their largest dimension that are located on caulked surfaces or in the nailing flange area and intended to be covered by sheathing shall be disregarded.

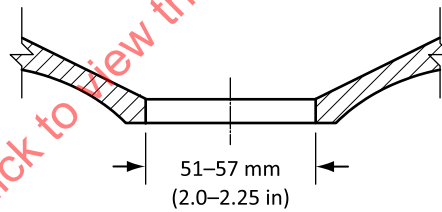
Figure 1
Waste outlet dimensions
 (See Clause [4.5.1.2.](#))



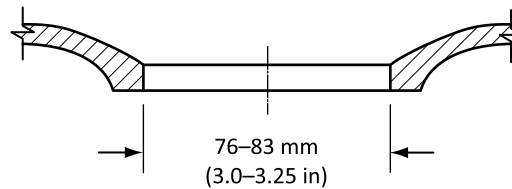
a) Lavatory



b) Kitchen sink*



c) Laundry sink*



d) Service sink

(Continued)