

Specification for Standard Sizes						
AS/NZS 1074 : 1989 - for Steel Tubes and Tubulars for Ordinary Service						
Tolerance						
1. Outside Diameter						
Dimensions of Steel Tubes - Extra Light (XLGT)						
Nominal Size	INCH	Outside Diameter (mm)		Thickness (mm)	Mass of Black T	
		Min.	Max.		Plain or Srewed end	Srev
DN15	1/2"	20.8	21.2	1.80	0.866	
DN20	3/4"	26.1	26.6	2.00	1.228	
DN25	1"	32.9	33.5	2.00	1.563	
DN32	1.1/4"	41.6	42.2	2.00	1.993	
DN40	1.1/2"	47.5	48.1	2.30	2.609	
DN50	2"	59.3	59.9	2.30	3.290	
DN65	2.1/2"	74.6	75.4	2.30	4.186	
DN80	3"	87.7	88.5	2.60	5.533	
DN90	3.1/2"	100.3	100.9	2.60	6.347	
DN100	4"	112.6	113.5	3.20	8.767	
DN125	5"	136.5	138.8	3.00	10.113	
DN150	6"	161.9	164.5	3.00	11.992	
Dimensions of Steel Tubes -Light						
Nominal Size	INCH	Outside Diameter (mm)		Thickness (mm)	Mass of Black T kg/M	
		Min.	Max.		Plain or Srewed end	Srev
DN 8	1/4"	13.20	13.60	1.80	0.515	
DN10	3/8"	16.70	17.10	1.80	0.670	
DN15	1/2"	21.00	21.40	2.00	0.947	
DN20	3/4"	26.40	26.90	2.30	1.380	
DN25	1"	33.20	33.80	2.60	1.980	
DN32	1.1/4"	41.90	42.50	2.60	2.540	
DN40	1.1/2"	47.80	48.40	2.90	3.230	
DN50	2"	59.60	60.20	2.90	4.080	
DN65	2.1/2"	75.20	76.00	3.20	5.710	
DN80	3"	87.90	88.70	3.20	6.720	
DN100	4"	113.00	113.90	3.60	9.750	
Dimenstions of Steel Tubes - Medium						
Nominal Size	INCH	Outside Diameter (mm)		Thickness (mm)	Mass of Black T kg/M	
		Min.	Max.		Plain or Srewed end	Srev
DN 8	1/4"	13.30	13.90	2.30	0.641	
DN10	3/8"	16.80	17.40	2.30	0.839	
DN15	1/2"	21.00	21.70	2.60	1.210	

DN20	3/4"	26.60	27.20	2.60	1.560	
DN25	1"	33.40	34.20	3.20	2.410	
DN32	1.1/4"	42.10	42.90	3.20	3.100	
DN40	1.1/2"	48.00	48.80	3.20	3.570	
DN50	2"	59.80	60.80	3.60	5.030	
DN65	2.1/2"	75.40	76.60	3.60	6.430	
DN80	3"	88.10	89.50	4.00	8.370	
DN100	4"	113.30	114.90	4.50	12.200	
DN 125	5"	138.70	140.60	5.00	16.600	
DN150	6"	164.10	166.10	5.00	19.700	

Dimensions of Steel Tubes - Heavy

Nominal Size	INCH	Outside Diameter (mm)		Thickness (mm)	Mass of Black T kg/M	
		Min.	Max.		Plain or Srewed end	Srev
DN 8	1/4"	13.30	13.90	2.90	0.765	
DN10	3/8"	16.80	17.40	2.90	1.020	
DN15	1/2"	21.00	21.70	3.20	1.440	
DN20	3/4"	26.60	27.20	3.20	1.870	
DN25	1"	33.40	34.20	4.00	2.940	
DN32	1.1/4"	42.10	42.90	4.00	3.800	
DN40	1.1/2"	48.00	48.80	4.00	4.380	
DN50	2"	59.80	60.80	4.50	6.190	
DN65	2.1/2"	75.40	76.60	4.50	7.930	
DN80	3"	88.10	89.50	5.00	10.300	
DN100	4"	113.30	114.90	5.40	14.500	
DN 125	5"	138.70	140.60	5.40	17.900	
DN150	6"	164.10	166.10	5.40	21.300	

2.Thickness

	Light	Medium	Heavy	
	-8%	-10%	-10%	
	+ Unlimited	+ Unlimited	+ Unlimited	

3. Length

-0/+50 MM or Mutual Agreement between Manufacturer and Purchaser

4. Weight

+10 % /-8 % (Single Tube)

5.Straightness

0.2 % of the Hollow Tube Length

6. Ends

Plain end, Grooved end, Thread end, Bevel end.

Grooved end - as per Victaulic Specification -25.01

Thread end - as per BSP (British Standard Pipe)- Thread is 55 degree

7. Chemical Composition

	S-0.045 % , P-0.045 % , & CE -0.40 %
8. Mechanical Properties	
UTS-320 To 460 MPa, Yield Strength - 195 MPa (Min). & Elongation - 20 % (Minimum)	
9. Flattening Test	
For Weld Test - Flatten up to 75 % of original OD of Tube result no cracks appearance in weld portion of the tube	
For Material - Flatten up to 60 % of original OD of tube result no Cracks appearance in metal other than in the weld portion	
10. Leack Tightness Test	
a.- Online NDT (Eddy Current) or	
b. - Hydro Testing at 50 bar Pressure and holding time Minimum 5 Second	
11 . Bend Test	
Applicable to tubes upto and including nominal size of 50 mm	
a.- Ungalvanized tube shall be capable of being bent cold without cracking through 180 degree round former having radius 6 times of the Outside Dia of Tube	
b.- Galvanized tube shall be capable of being bent cold without cracking through 90 degree round former having radius 8 Times of the Outside Dia of tube	
12. Surface Protction	
Bare Black Tube (Uncoated)	
HDG - Galvanized As per AS 1650/4792/4680 (as per AS 4792- Minimum Zinc Coating-300 g/m2)	
Oil-Based Painted Tubes (OBPT)	
Water-Base Painted Tube - Acid Removal (WBPTAR)	
Water-Base Painted Tube - Non Acid Removal (WBPTNR)	
13.Packing	
Hexagonal Type or Customer Requirments	
14. Colour Coading	
	For Extra Light - Green
	For Light - Brown/Yellow
	For Medium - Blue
	For Heavy - Red
15. Mill Test Certificate	
We can issue a MTC, Certifying that the tubes supplied comply with this standard-AS/NZ 1074 :	

Tube
Med and Sockets
0.887
1.259
1.603
2.042
2.674
3.372
4.290
5.672
6.506
8.986
10.366
12.292
Tube
Med and Sockets
0.519
0.676
0.956
1.390
2.000
2.570
3.270
4.150
5.830
6.890
10.000
Tube
Med and Sockets
0.645
0.845
1.220

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