Specification for Standard S

EN 10217-I : 2019 - Welded Steel Tubes for Pressure Pu

Cold-Formed Circular Hollow Section Tubes (Round Tubes)

Designation	Outside Diameter (mm) - Range & Tolerance	
CF-CHS	13.50 -To-219.10 MM & 1 % of Size (OD) With Minimum of ± 0.5 MM	1.80 -T 1.80 -To-

Chemical and Mechnical Properties as per E

Steel Name	Mechnical Properties					
	Steel Number	Yield Strength MPa (Min)	Elongation % (Min.)		Tensile Strength MPa (Min)	C % Max.
			Long. %	Trans. %		
P195TR1	1.0107	195	27	25	320-440	0.130
P235TR1	1.0257	235	25	23	360-500	0.160
P265TR1	1.0258	265	21	19	410-570	0.200

1. Length	-0/+50 MM or Mutual Agreement be
2. Out-of-Roundness CHS	± 2 % for hollow sections having diameter to thickness ratio and the p
7. Straightness	Tube Length shall not exceed 0.0
8. Mass(m) per unit length	Apply Provisior

9. 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

10. Flattening Test

for above NPS 2'' - Welded tubes shall be flattened with the weld placed alternately at 0 deg. or
to the direction of the the force .

for Weld Test- Flatten up to 75 % of original Dia of the tubes result no cracks apperance on weld

For Material other than weld - Flatten up to 60 % of original tube OD result no cracks appearanc
metal other than in the weld portion

11. Leack Tightness Test

a.- Online NDT (Eddy Current) or

b. - Hydro Testing at 70 bar Pressure and holding time Minimum 5 Second

12 . Bend Test

Bend Test is applicable for Specified Diameter (D) from 17.20 to 60.30 mm through correspondin

D	17.2	21.3	26.9	33.7	42.4	48.3
Bending Radius	50	65	85	100	150	170

13. Surface Protcetion

Bare Black Tube (Uncoated)

HDG - Galvanized As per EN ISO 1461 and EN 10240 -A1,A2,A3 & B1,B2,B3 Quality

Oil-Based Painted Tubes (OBPT)

Water-Base Painted Tube - Acid Removal (WBPTAR)

Water-Base Painted Tube - Non Acid Removal (WBPTNR)

14.Packing

Hexagonal Type or Customer Requirments

15. Colour Coading

For Light - Brown

For Medium - Blue

For Heavy - Red

16. Mill Test Certificate

We can issue a MTC, Certifying that the tubes supplied comply with this standard-EN 10217-I : 20

Documents as Per EN 10204 : 2004 ,Type 3.1

izes

urposes (Steel Quality TR1)

Wall Thickness (mm) - Range & Tolerance

o-6.30 MM & ± 10 % of Wall Thickness for Thickness ≤5.0 mm
·6.30 MM & ± 8 % of Wall Thickness for Thickness 5<T≤ 40 mm

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Chemical Composition %

Si Max	Mn %	P % Max	S % Max	Mo % Max	Cr+Cu+Mo+Ni Max. %
0.350	0.700	0.025	0.020	0.080	0.700
0.350	1.200	0.025	0.020	0.080	0.700
0.400	1.400	0.025	0.020	0.080	0.700

etween Manufacturer and Purchaser

not exceeding 100, otherwise shall be agree between APM
urchaser

015L , Where L is Length of tube

ı of ENV 1022

90 deg.

Portion
e in the

ıg radius

60.3							
220							

)19 & Inspection