

Specification for Standard Sizes

EN 10255 : 2004 + A1 : 2007 for Non-Alloy Steel Tubes Suitable for Welding and

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 -L1

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	13.90	2.00	0.570	
DN10	3/8"	16.70	17.40	2.00	0.742	
DN15	1/2"	21.00	21.70	2.30	1.080	
DN20	3/4"	26.40	27.10	2.30	1.390	
DN25	1"	33.20	34.00	2.90	2.200	
DN32	1.1/4"	41.90	42.70	2.90	2.820	
DN40	1.1/2"	47.80	48.60	2.90	3.240	
DN50	2"	59.60	60.70	3.20	4.490	
DN65	2.1/2"	75.20	76.30	3.20	5.730	
DN80	3"	87.90	89.40	3.60	7.550	
DN100	4"	113.00	114.90	4.00	10.800	

Dimenstions of Steel Tubes - L2

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	

Dimensions 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
DN6	1/8"	9.80	10.60	2.00	0.404	
DN 8	1/4"	13.20	14.00	2.30	0.641	
DN10	3/8"	16.70	17.50	2.30	0.839	
DN15	1/2"	21.00	21.80	2.60	1.210	
DN20	3/4"	26.50	27.30	2.60	1.560	
DN25	1"	33.30	34.20	3.20	2.410	
DN32	1.1/4"	42.00	42.90	3.20	3.100	
DN40	1.1/2"	47.90	48.80	3.20	3.560	
DN50	2"	59.70	60.80	3.60	5.030	
DN65	2.1/2"	75.30	76.60	3.60	6.420	
DN80	3"	88.00	89.50	4.00	8.360	
DN100	4"	113.10	115.00	4.50	12.200	
DN 125	5"	138.50	140.80	5.00	16.600	
DN150	6"	163.90	166.50	5.00	19.800	

Dimensions of Steel Tubes - Heavy

Nominal Size	INCH	Outside Diameter (mm)		Thickness (mm)	Mass of Black Tube	
		Min.	Max.		Plain or Srewed end	Srev
DN6	1/8"	9.80	10.60	2.60	0.487	
DN 8	1/4"	13.20	14.00	2.90	0.765	
DN10	3/8"	16.70	17.50	2.90	1.020	
DN15	1/2"	21.00	21.80	3.20	1.440	
DN20	3/4"	26.50	27.30	3.20	1.870	
DN25	1"	33.30	34.20	4.00	2.930	
DN32	1.1/4"	42.00	42.90	4.00	3.790	
DN40	1.1/2"	47.90	48.80	4.00	4.370	
DN50	2"	59.70	60.80	4.50	6.190	
DN65	2.1/2"	75.30	76.60	4.50	7.930	
DN80	3"	88.00	89.50	5.00	10.300	
DN100	4"	113.10	115.00	5.40	14.500	

2.Thickness

-8 % with the plus tolerance limited by the mass tolerance, for types L1 and L2

3. Length

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

4. Weight

+10 % , -8 % on Individual tubes for Types L1 & L2

5. Straightness

Straightness Shall not exceed 0.002L (Where L is length of tube)

6. Ends

Grooved end - as per Victaulic Specification -25.01

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

7. Chemical Composition

C - 0.20 %, Mn - 1.40 %, S - 0.030 %, P - 0.035 %

8. Mechanical Properties

UTS-320 To 520 MPa, Yield Strength - 195 MPa (Min.) & Elongation - 20 % (Minimum)

9. Flattening Test

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

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

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

12. Surface Protection

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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)
13.Packing
Hexagonal Type or Customer Requirments
14. Colour Coading
For Extra Light -Pink
For L - Green
For L1- White
For L2 - Brown
For Medium - Blue
For Heavy - Red
15. Mill Test Certificate
We can issue a MTC, Certifying that the tubes supplied comply with this standard-EN 10255 &
Documents as Per EN 10204 : 2004 ,Type 3.1

hreading
ube
ved 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
ube
ved and Sockets
0.574
0.748
1.090
1.400
2.220
2.850
3.280
4.560
5.850
7.720
11.100
ube
ved 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
Used and Sockets
0.407
0.645
0.845
1.220
1.570
2.430
3.130
3.600
5.100
6.540
8.530
12.500
17.100
20.400
Weight (kg/M)
Used and Sockets
0.490
0.769
1.030
1.450
1.880
2.950
3.820
4.410
6.260
8.050
10.500
14.800

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Inspection