

**SPECIFICATION FOR STANDARD SIZES  
AS 1074 : 1989 FOR BLACK AND HOT DIPPED GALVANIZED STEEL PIPES.**

TUBE	SIZE		OD (SPECIFIED)		WALL THICKNESS (MM)	WEIGHT OF TUBE(Kg/Mtr)		PRESSURE
	INCH	NB	MIN	MAX		BLACK	S/S	
	1/2"	15	21	21.4	2	0.947	0.956	50
L I G H T	3/4"	20	26.4	26.9	2.3	1.38	1.39	50
	1"	25	33.2	33.8	2.6	1.98	2	50
	1 1/4"	32	41.9	42.5	2.6	2.54	2.57	50
	1 1/2"	40	47.8		2.9	3.23	3.27	50
	2"	50	59.6	60.2	2.9	4.08	4.15	50
	2 1/2"	65	75.2	76	3.2	5.71	5.83	50
	3"	80	87.9	88.7	3.2	6.72	6.89	50
	4"	100	113	113.9	3.6	9.75	10	50
M E D I U M	1/2"	15	21.1	21.7	2.6	1.21	1.22	50
	3/4"	20	26.6	27.2	2.6	1.56	1.57	50
	1"	25	33.4	34.2	3.2	2.41	2.43	50
	1 1/4"	32	42.1	42.9	3.2	3.1	3.13	50
	1 1/2"	40	48	48.8	3.2	3.57	3.61	50
	2"	50	59.8	60.8	3.6	5.03	5.1	50
	2 1/2"	65	75.4	76.6	3.6	6.43	6.55	50

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	<b>3"</b>	<b>80</b>	<b>88.1</b>	<b>89.5</b>	<b>4</b>	<b>8.37</b>	<b>8.54</b>	<b>50</b>
	<b>4"</b>	<b>100</b>	<b>113.3</b>	<b>114.9</b>	<b>4.5</b>	<b>12.2</b>	<b>12.5</b>	<b>50</b>
	<b>5"</b>	<b>125</b>	<b>138.7</b>	<b>140.6</b>	<b>5</b>	<b>16.6</b>	<b>17.1</b>	<b>50</b>
<b>H E A V Y</b>	<b>1/2"</b>	<b>15</b>	<b>21.1</b>	<b>21.7</b>	<b>3.2</b>	<b>1.44</b>	<b>1.45</b>	<b>50</b>
	<b>3/4"</b>	<b>20</b>	<b>26.6</b>	<b>27.2</b>	<b>3.2</b>	<b>1.87</b>	<b>1.88</b>	<b>50</b>
	<b>1"</b>	<b>25</b>	<b>33.4</b>	<b>34.2</b>	<b>4</b>	<b>2.94</b>	<b>2.96</b>	<b>50</b>
	<b>1</b>	<b>32</b>	<b>42.1</b>	<b>42.9</b>	<b>4</b>	<b>3.8</b>	<b>3.83</b>	<b>50</b>
	<b>1</b>	<b>40</b>	<b>48</b>	<b>48.8</b>	<b>4</b>	<b>4.38</b>	<b>4.42</b>	<b>50</b>
	<b>2"</b>	<b>50</b>	<b>59.8</b>	<b>60.8</b>	<b>4.5</b>	<b>6.19</b>	<b>6.26</b>	<b>50</b>
	<b>2</b>	<b>65</b>	<b>75.4</b>	<b>76.6</b>	<b>4.5</b>	<b>7.93</b>	<b>8.05</b>	<b>50</b>
	<b>3"</b>	<b>80</b>	<b>88.1</b>	<b>89.5</b>	<b>5</b>	<b>10.3</b>	<b>10.5</b>	<b>50</b>
	<b>4"</b>	<b>100</b>	<b>113.3</b>	<b>114.9</b>	<b>5.4</b>	<b>14.5</b>	<b>14.8</b>	<b>50</b>
	<b>5"</b>	<b>125</b>	<b>138.7</b>	<b>140.6</b>	<b>5.4</b>	<b>17.9</b>	<b>18.4</b>	<b>50</b>
	<b>6"</b>	<b>150</b>	<b>164.1</b>	<b>166.1</b>	<b>5.4</b>	<b>21.3</b>	<b>21.9</b>	<b>50</b>

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**TOLERANCE**

- 1) **OUTSIDE DIAMETER.** : As per the above Table
- 2) **STRAIGHTNESS** : 0.2 % of the length
- 3) **MASS** : For quantities of 150 Mtr. and over of one size =  $\pm 4\%$ , for single tube  
=+10% /-8%.
- 4) **THICKNESS** : Light Welded Tube-+ Unlimited ,-8 percent  
: Cut cleanly and nominally square with the axis of the tube and free from  
excessive burrs
- 5) **CHEMICAL COMPOSITION** : % Max: S - 0.045% & P - 0.045%,CE-0.4

**7. MECHANICAL** : UTS - 320 to 460 N/mm<sup>2</sup>, YS - 195 N/mm<sup>2</sup> (minimum) & %EL- 20(minimum).

**8. FLATTENING TEST**

a) : For Weld Test - Flatten up to 75% of original tube OD.No cracks in the weld.

b) :For Material-Flatten up to 60% of original tube OD. No cracks in the metal than in the weld.

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**9. 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° round former having radius 6 times the outside dia of tube.
- b) Galvanized tube shall be capable of being bent cold without cracking through 90° round former having radius 8 times the outside dia of tube.

**10) LEAK TIGHTNESS TEST:-**

- a) :On line NDT(Eddy Current)
- b) :Hydro testing at pressure as per above Table and holding time Min. 5 Second.

**11. ZINC COATING (GALVANIZING)**

:As per AS1650