

**EN 10255:2004+A1:2007 FOR
BLACK AND HOT DIPPED GALVANIZED STEEL PIPES.**

TUBE	SIZE		OD (SPECIFIED)		WALL THICKNESS(MM)	WEIGHT OF TUBE(Kg/Mtr)		PRESSURE BAR
	INCH	NB	MIN	MAX		BLACK	S/S	
T Y P E - L	1/2"	15	21.0	21.7	2.3	1.08	1.09	50
	3/4"	20	26.4	27.1	2.3	1.40	1.41	50
	1"	25	33.2	34.0	2.9	2.20	2.22	50
	1 1/4"	32	41.9	42.7	2.9	2.82	2.85	50
	1 1/2"	40	47.8	48.6	2.9	3.25	3.29	50
	2"	50	59.6	60.7	3.2	4.51	4.58	50
	2 1/2"	65	75.2	76.0	3.2	5.75	5.87	50
	3"	80	87.9	88.7	3.2	6.76	6.93	50
	3 1/2"	90	100.3	101.2	3.6	8.70	8.88	50
	4"	100	113.0	113.9	3.6	9.83	10.1	50
	5"	125	138.5	140.8	4.5	15.00	15.5	50
6"	150	163.9	166.5	4.5	17.80	18.4	50	
T Y P E - L1	1/2"	15	21.0	21.7	2.3	1.08	1.09	50
	3/4"	20	26.4	27.1	2.3	1.39	1.40	50
	1"	25	33.2	34.0	2.9	2.20	2.22	50
	1 1/4"	32	41.9	42.7	2.9	2.82	2.85	50
	1 1/2"	40	47.8	48.6	2.9	3.24	3.28	50
	2"	50	59.6	60.7	3.2	4.49	4.56	50
	2 1/2"	65	75.2	76.3	3.2	5.73	5.85	50
	3"	80	87.9	89.4	3.6	7.55	7.72	50
T Y	1/2"	15	21.0	21.4	2.0	0.947	0.956	50
	3/4"	20	26.4	26.9	2.3	1.38	1.39	50



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P E - L2	1"	25	33.2	33.8	2.6	1.98	2.00	50
	1 1/4"	32	41.9	42.5	2.6	2.54	2.57	50
	1 1/2"	40	47.8	48.4	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	76.0	3.2	5.71	5.83	50
	3"	80	87.9	88.7	3.2	6.72	6.89	50
	4"	100	113.0	113.9	3.6	9.75	10.00	50
M E D I U M	1/2"	15	21.1	21.8	2.6	1.21	1.22	50
	3/4"	20	26.5	27.3	2.6	1.56	1.57	50
	1"	25	33.3	34.2	3.2	2.41	2.43	50
	1 1/4"	32	42.0	42.9	3.2	3.1	3.13	50
	1 1/2"	40	47.9	48.8	3.2	3.56	3.6	50
	2"	50	59.7	60.8	3.6	5.03	5.1	50
	2 1/2"	65	75.3	76.6	3.6	6.42	6.54	50
	3"	80	88.0	89.5	4.0	8.36	8.53	50
	4"	100	113.1	115.0	4.5	12.2	12.5	50
	5"	125	138.5	140.8	5.0	16.6	17.1	50
	6"	150	163.9	166.5	5.0	19.8	20.4	50
H E A V Y	1/2"	15	21.1	21.8	3.2	1.44	1.45	50
	3/4"	20	26.5	27.3	3.2	1.87	1.88	50
	1"	25	33.3	34.2	4.0	2.93	2.95	50
	1 1/4"	32	42.0	42.9	4.0	3.79	3.82	50
	1 1/2"	40	47.9	48.8	4.0	4.37	4.41	50
	2"	50	59.7	60.8	4.5	6.19	6.26	50

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2 1/2"	65	75.3	76.6	4.5	7.93	8.05	50
3"	80	88.0	89.5	5.0	10.3	10.5	50
4"	100	113.1	115.0	5.4	14.5	14.8	50
5"	125	138.5	140.8	5.4	17.9	18.4	50
6"	150	163.9	166.5	5.4	21.3	21.9	50

TOLERANCE

- 1. OUTSIDE DIAMETER.** : As per the above Table
- 2. STRAIGHTNESS** : Straightness shall not exceed 0.002 L.
- 3. MASS** : ± 7.5 % on bundles of 10 tons or more, for M and H series and Type L
: +10% -8% on individual tubes for Types L1 and L2.
- 4. THICKNESS** : ± 10 % for M and H series & Type L

: -8% with the plus tolerance limited by the mass tolerance, for Types L1 and L2.
- 5. ENDS** : Cut cleanly and nominally square with the axis of the tube and free from excessive burrs.
- 6. CHEMICAL COMPOSITION** : % Max: C - 0.20%, Mn - 1.40%, S - 0.03% & P - 0.035%
- 7. MECHANICAL PROPERTIES** : UTS - 320 to 520 N/mm², YS - 195 N/mm² (minimum) & %EL- 20 (minimum).

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8. FLATTENING TEST

: The flattening test shall be applied to bare tubes with specified outside diameter greater than 60.3mm. Welded tubes shall be flattened with the weld placed alternately at 0° or 90° to the direction of the Flattening force.
 : For Weld Test - Flatten up to 75% of original tube OD.No cracks in the weld.
 : For Material other than Weld-Flatten up to 60% of original tube OD. No cracks in the metal other than in the weld..

9. BEND TEST

: Bend test up to 60.3mm OD. Radius at the bottom of the groove of the former shall be as per below table . The tubes shall show no cracks visible without magnifying aids.

Diameter (D)	21.3	26.9	33.7	42.4	48.3	60.3
Bending Radius	65	85	100	150	170	220

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

:As per EN 10240A1

12. THREADING

: For 1/2" to 3/4" - 14 TPI and from 1" to 6" - 11

TPI Check with standard ring and plug gauges.

13.MARKING

: We can do on line stenciling as per this stanadrd & as per customer needs at one meter interval



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14. PACKING :Hexagonal Type

15.COLOR COADING: For Type L --- Green

For Type L1 --- White

For Type L2----Brown

For Heavy----- Red

For Medium-----Blue

16. MILL TEST CERTIFCATE:- We can issue a MTC, Certifying that the tubes supplied comply with this standard.