

TUBE	SIZE		OD (SPECIFIED)		WLL THICKNESS (MM)	WEIGHT OF TUBE (Kg / Mtr)		PRESSURE BAR
	INCH	NB	MIN	MAX		BLACK	S/S	
L I G H T	1/2"	15	21	21.4	2	0.947	0.956	50
	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	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
M E D I U M	4"	100	113	113.9	3.6	9.75	10	50
	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
	3"	80	88.1	89.5	4	8.37	8.54	50
	4"	100	113.3	114.9	4.5	12.2	12.5	50
H E A V Y	5"	125	138.7	140.6	5	16.6	17.1	50
	6"	150	164.1	166.1	5	19.7	20.3	50
	1/2"	15	21.1	21.7	3.2	1.44	1.45	50
	3/4"	20	26.6	27.2	3.2	1.87	1.88	50
	1"	25	33.4	34.2	4	2.94	2.96	50
	1 1/4"	32	42.1	42.9	4	3.8	3.83	50
	1 1/2"	40	48	48.8	4	4.38	4.42	50
	2"	50	59.8	60.8	4.5	6.19	6.26	50
	2 1/2"	65	75.4	76.6	4.5	7.93	8.05	50
	3"	80	88.1	89.5	5	10.3	10.5	50
4"	100	113.3	114.9	5.4	14.5	14.8	50	
5"	125	138.7	140.6	5.4	17.9	18.4	50	
6"	150	164.1	166.1	5.4	21.3	21.9	50	

TOLERANCES

- 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 = ± 4%, for single tube =+10% / -8%•
- 4.THICKNESS** : Light Welded Tube:+ Unlimited ,-8 percent
: Medium and heavy Tube:+ Unlimited ,-10%
- 5.ENDS** : Cut cleanly and nominally square with the axis of the tube and free from excessive burrs.
- 6.CHEMICAL COMPOSITION** : % Max: S - 0.045% & P - 0.045%,CE-0.40%
- 7.MECHANICAL** : UTS - 320 to 460 N/mm², YS - 195 N/mm²,(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 other than in the weld.
- 9.BEND TEST** : Applicable to tubes upto and including nominal size of 50 mn.
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 AS 4792
- 12.THREADING** : All Thread shall comply with AS 1722.1
- 13.COLOR CODING** : For Light ---- Brown
For Medium---Blue
For Heavy Red
- 14.MILL TEST CERTIFICATE:-** We can issue a MTC, Certifying that the tubes supplied comply with this standard.