

**ARCELORMITTAL TUBULAR
PRODUCTS IASI
Product portfolio
European standards**

ARCELORMITTAL TUBULAR PRODUCTS IASI

1. TUBES FOR INSTALLATIONS

- EN 10255 - Unalloyed steel pipes **...ding and threading**

- EN 10224 - Unalloyed steel tubes **...plings for trasporting water liquids, including drinkable water**

2. TUBES FOR CONSTRUCTIONS

- EN 10210/1/2 Hot finished hollow **...al sections for constructions**

- EN 10219/1/2 Cold formed hollow **...al sections for constructions**

- EN 10220 Steel pipes - welded an **...welded**

3. TUBES FOR PIPING

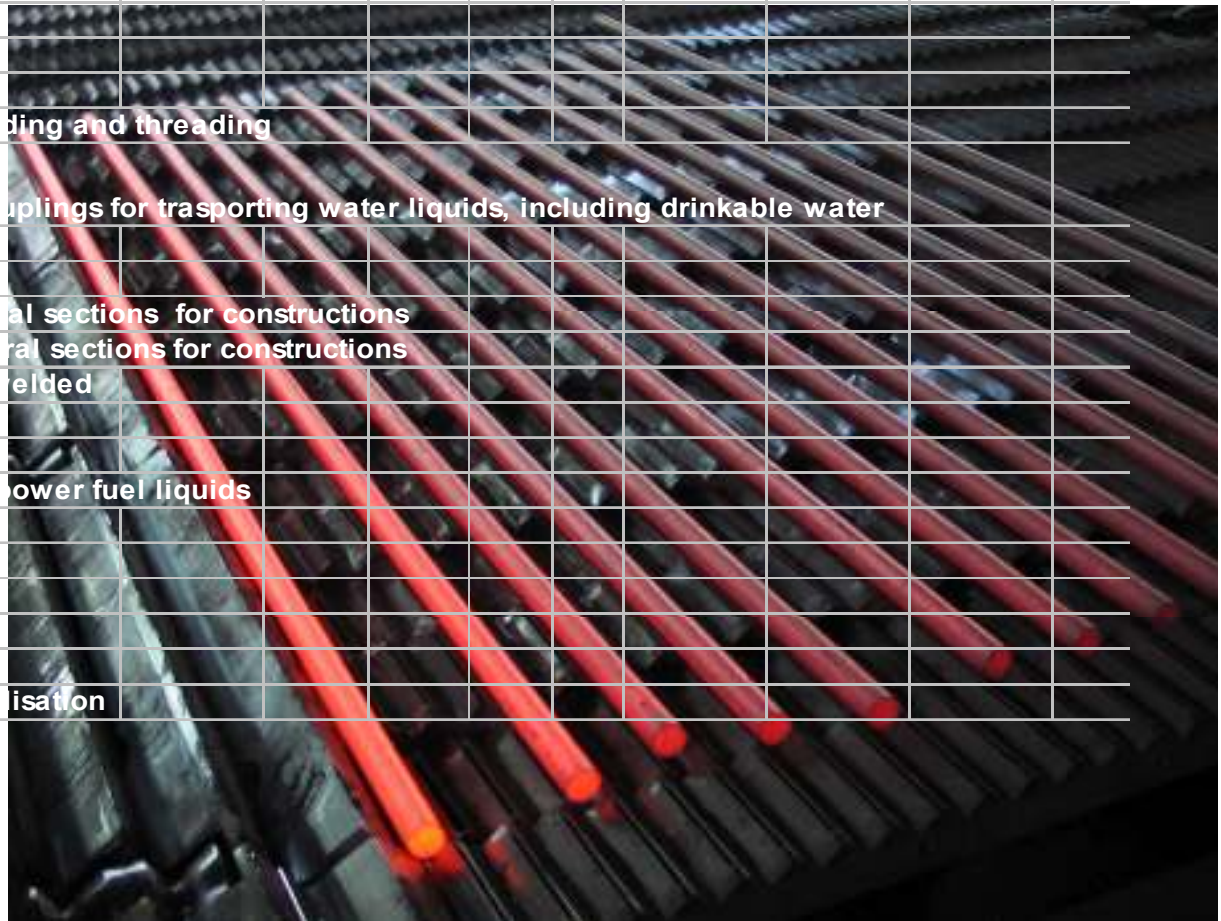
- EN 10208-1 - Steel pipes for cond **...ower fuel liquids**

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- EN 10217-1 - Pipes used for pres

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- EN 10305-3 - Steel pipes for preci **...isation**



TUBES FOR INSTALLATIONS

EN 10255

Unalloyed steel pipes for welding and threading

Dimensions : \varnothing : 1/4" (13.5mm) - 5" (139.7mm)

g : 2.3 mm - 5 mm

l : 6 m or 6.4 m +100/-0 mm or \pm 50mm

Series : H; M; L; L1; L2

Steel : S195T; S235JR

Manufacturing process : longitudinally welded

-hot reduced up to \varnothing 2 1/2"(76.1mm); weld factor v=1

-cold formed for \varnothing 3" (88.9mm) -5"(139.7) mm; weld factor v=0.9

Protection:

- black with temporary alkaline protection (min.30 days)

- externally painted (min.6 months in sheltered environment)(min 20-25 μ m)

- galvanized(min.55 μ m)

Ends processing: plain

threaded \varnothing 1/2"-4"

Tightness test:

for \varnothing 1/4 "- 3" NDT 100% (hydrostatic test not possible)

for \varnothing 4 "- 5" hydrostatic test 100% at 50 bar or

for \varnothing 4 "- 5" NDT on weld

Tolerances :

with wall thickness :

\pm 10% for series M,H si tip L

-8% for L1 si L2 types

with weight :

\pm 7.5% in bundles of 10 t

+ 10% -8% in individual pipes,

Weld seam removed:

externally 100%

internally from pipes

Documents:

trial report type 2.1

trial report type 2.2(by request)



ArcelorMittal Tubular Products lasi							
EN 10255; S195T; S235JR steel; black							
Outside Diameter	thread size	OD		wall	weight		pieces per bundle
		max.	min.	T	plain end	socketed	
D	R	mm	mm	mm	kg/m	kg/m	
H - heavy series							
13.5	1/4	14	13.2	2.9	0.765	-	271
17.2	3/8	17.5	16.7	2.9	1.02	-	217
21.3	1/2	21.8	21	3.2	1.44	1.45	169
26.9	3/4	27.3	26.5	3.2	1.87	1.88	127
33.7	1	34.2	33.3	4.0	2.93	2.95	91
42.4	1 1/4	42.9	42	4.0	3.79	3.82	61
48.3	1 1/2	48.8	47.9	4.0	4.37	4.41	61
60.3	2	60.8	59.7	4.5	6.19	6.26	37
76.1	2 1/2	76.6	75.3	4.5	7.93	8.05	37
88.9	3	89.5	88	5.0	10.3	10.5	19
114.3	4	115	113.1	5.4	14.5	14.8	19
139.7	5	140.8	138.5	5.4	17.9	-	19
M - medium series							
13.5	1/4	14	13.2	2.3	0.641	-	271
17.2	3/8	17.5	16.7	2.3	0.839	-	217
21.3	1/2	21.8	21	2.6	1.21	1.22	169
26.9	3/4	27.3	26.5	2.6	1.56	1.57	127
33.7	1	34.2	33.3	3.2	2.41	2.43	91
42.4	1 1/4	42.9	42	3.2	3.10	3.13	61
48.3	1 1/2	48.8	47.9	3.2	3.56	3.6	61
60.3	2	60.8	59.7	3.6	5.03	5.1	37
76.1	2 1/2	76.6	75.3	3.6	6.42	6.54	37
88.9	3	89.5	88	4.0	8.36	8.53	19
114.3	4	115	113.1	4.5	12.2	12.5	19
139.7	5	140.8	138.5	5.0	16.6	-	19

ArcelorMittal Tubular Products lasi							
EN 10255; S195T, S235 JR steel; black							
Outside Diameter	thread size	OD		wall	weight		pieces per bundle
		max.	min.	T	plain end	socketed	
D	R	mm	mm	mm	kg/m	kg/m	
type L -light L							
21.3	1/2	21.7	21	2.3	1.08	1.09	169
26.9	3/4	27.1	26.4	2.3	1.40	1.41	127
33.7	1	34	33.2	2.9	2.20	2.22	91
42.4	1 1/4	42.7	41.9	2.9	2.82	2.85	61
48.3	1 1/2	48.6	47.8	2.9	3.25	3.29	61
60.3	2	60.7	59.6	3.2	4.51	4.58	37
76.1	2 1/2	76	75.2	3.2	5.75	5.87	37
88.9	3	88.7	87.9	3.2	6.76	6.93	19
114.3	4	113.9	113	3.6	9.83	10.1	19
139.7	5	140.8	138.5	4.5	15.0		19
type L1-light L1							
21.3	1/2	21.7	21	2.3	1.08	1.09	169
26.9	3/4	27.1	26.4	2.3	1.39	1.4	127
33.7	1	34	33.2	2.9	2.20	2.22	91
42.4	1 1/4	42.7	41.9	2.9	2.82	2.85	61
48.3	1 1/2	48.6	47.8	2.9	3.24	3.28	61
60.3	2	60.7	59.6	3.2	4.49	4.56	37
76.1	2 1/2	76.3	75.2	3.2	5.73	5.85	37
88.9	3	89.4	87.9	3.6	7.55	7.72	19
114.3	4	114.9	113	4.0	10.8	11.1	19
type L2-light L2							
33.7	1	33.8	33.2	2.6	1.98	2	91
42.4	1 1/4	42.5	41.9	2.6	2.54	2.57	61
48.3	1 1/2	48.4	47.8	2.9	3.23	3.27	61
60.3	2	60.2	59.6	2.9	4.08	4.15	37
76.1	2 1/2	76	75.2	3.2	5.71	5.83	37
88.9	3	88.7	87.9	3.2	6.72	6.89	19
114.3	4	113.9	113	3.6	9.75	10	19

TUBES FOR INSTALLATIONS

EN 10224- Unalloyed steel tubes and couplings for transporting water liquids, including drinkable water

Dimensions : \varnothing : 26.9mm - 219.1 mm

g : 2.3 mm - 8 mm

l : 6 m or 12 m +100/-0 mm or \pm 50mm

Steel: L235 ; L275 ; L355

Manufacturing process : longitudinally welded

-hot reduced up to \varnothing 76.1mm; weld factor $v=1$

-cold formed for \varnothing 88.9mm -219.1 mm; weld factor $v=0.9$

-cold formed and warm treated \varnothing 88.9 mm(by request)

-cold formed with weld seam annealed for \varnothing 139.7-219.1 mm (by request)

Protection : black with temporary alkaline protection (min.30 days)
externally painted

(min.6 months in sheltered environment)(min 20-25 μ m)

galvanized (min.55 μ m)

Ends processing: perpendicularly cut

chamfered from $\varnothing \geq 60.3$ mm & g ≥ 3.6 mm

Tightness test:

NDT 100% for \varnothing 26.9-114.3 mm

hydrostatic test at 70 bar for \varnothing 101.6 -219.1mm

Non destructive test of weld : NDT 100%

NDT 100% for \varnothing 26.9-114.3 mm

NDT on weld from \varnothing 139.7 -219.1 mm

Tolerances :

with wall thickness :

$\pm 12.5\%$ or ± 0.4 mm which is higher

with diameter :

$\pm 1\%$ with minimum value of ± 0.5 mm

with ovality :

max. 2% from nominal diameter

with straightness:

0.2% of total length

Weld seam removed: externally 100%

internally from pipes of $\varnothing \geq 1"$ (33.7) mm

Documents:

trial report type 2.2

inspection certificate type 3.1 or type 3.2 (by request)

(chemical analysis; traction; tightness;

nondestructive test of weld)

ArcelorMittal Tubular Products lasi							
EN 10224, L235; L275; L355 steel, black				EN 10224, L235; L275; L355 steel, black			
Outside	wall	weight	pieces per	Outside	wall	weight	pieces per
Diameter	thickness		bundles	Diameter	thickness		bundles
D	T			D	T		
mm	mm	kg/m	6m	mm	mm	kg/m	6m
26.9	2.3	1.4	127	101.6	3.2	7.77	19
	2.6	1.56	127		3.6	8.7	19
	2.9	1.72	127		4	9.63	19
	3.2	1.87	127		4.5	10.8	19
33.7	2.6	1.99	91		5	11.9	19
	2.9	2.2	91		5.6	13.3	19
	3.2	2.41	91		6.3	14.8	19
	3.6	2.67	91	114.3	3.2	8.77	19
	4.0	2.93	91		3.6	9.83	19
42.4	2.6	2.55	61		4	10.9	19
	2.9	2.82	61		4.5	12.2	19
	3.2	3.09	61		5	13.5	19
	3.6	3.44	61		5.6	15	19
	4.0	3.09	61		6.3	16.8	19
48.3	2.6	2.93	61	139.7	3.6	12.1	10
	2.9	3.25	61		4	13.4	10
	3.2	3.56	61		4.5	15.1	10
	3.6	3.97	61		5	16.6	10
	4.0	4.37	61		5.6	18.5	10
60.3	2.6	3.7	37		6.3	20.7	10
	2.9	4.11	37	159	4	15.3	10
	3.2	4.51	37		4.5	17.1	10
	3.6	5.03	37		5	19	10
	4.0	5.55	37		5.6	21.2	10
76.1	2.6	5.12	37		6.3	23.7	10
	2.9	5.69	37		7.1	26.6	10
	3.2	6.26	37	168.3	3.6	14.6	7
	3.6	7	37		4	16.2	7
	4.0	7.74	37		4.5	18.2	7
88.9	3.2	6.76	19		5	20.1	7
	3.6	7.57	19		5.6	22.5	7
	4.0	8.38	19		6.3	25.2	7
	4.5	9.37	19		7.1	28.2	7
	5.0	10.3	19	219.1	4	21.2	7
					4.5	23.8	7
					5	26.4	7
					5.6	29.5	7
					6.3	33.1	7
					7.1	37.1	7
					8	41.6	7

TUBES FOR CONSTRUCTIONS

EN 10210-1 and EN 10210-2

Hot finished hollow structural sections for constructions

Dimensions: : \varnothing : 21.3mm - 88.9mm

g : 2.3 mm - 5 mm

l : 6 m or 6.4 m +100/-0 mm or \pm 50mm

Steel : S235 JR; S275 JO; S355 JO

Manufacturing process : longitudinally welded

- hot stretched reduced up to \varnothing 76.1mm

- cold formed and warm treated for \varnothing 88.9 mm

Protection :

- black with temporary alkaline protection (min.30 days)

- externally lacquered

(min.6 months in sheltered environment)(min.20-25 μ m)

- galvanized(min.55 μ m)

Non-destructive testing of weld: NDT 100%

Tolerances :

with wall thickness :

-10% ; positive deviation is limited by the weight tolerance

with diameter :

\pm 1% with minimum value of \pm 0.5 mm

ovality :

max. 2% of the nominal diameter

rectilinity :

0.2% of total length

weight :

\pm 6% per individual legths;

Weld seam removal:

externally 100%

internally from pipes with

Documents:

trial report type 2.2

inspection certificate type 3.1

or type 3.2 (by request)

(chemical analysis ; traction;



By request we can manufacture tubes with other wall thickness dimensions (acc. EN 10220)

ArcelorMittal Tubular Products lasi			
EN 10210, S235JR, S275 JO steel, black			
Outside	wall	weight	pieces per
Diameter	thickness		bundles
D	T		
mm	mm	kg/m	
21.3	2.3	1.08	169
	2.6	1.2	169
	3.2	1.43	169
26.9	2.3	1.4	127
	2.6	1.56	127
	3.2	1.87	127
33.7	2.6	1.99	91
	3.2	2.41	91
	4.0	2.93	91
42.4	2.6	2.55	61
	3.2	3.09	61
	4.0	3.79	61
48.3	2.6	2.93	61
	3.2	3.56	61
	4.0	4.37	61
60.3	2.6	3.7	37
	3.2	4.51	37
	4.0	5.55	37
76.1	2.6	4.71	37
	3.2	5.75	37
	4.0	7.11	37
88.9	3.2	6.76	19
	4.0	8.38	19
	5.0	10.3	19

TUBES FOR CONSTRUCTIONS

EN 10219-1 and EN 10219-2

Cold formed hollow structural sections for constructions
Circular section

Dimensions : \varnothing : 42.4mm - 219.1mm

T : 2.3 mm - 8 mm

l : 6 -12 m +100/-0 mm or \pm 50mm

Steel: S235 JR; S275 JO; S355 JO

Manufacturing process : longitudinally welded
 cold formed

Protection :

- black with temporary alkaline protection (min.30 days)
- externally lacquered (min.6 months in sheltered environment)(min.20-25 μ m)
- galvanized(min.55 μ m)

Non-destructive testing of weld:

NDT 100% for \varnothing 42.4-88.9 mm

hydrotested at 50 bar for \varnothing 101.6 -219.1mm

Tolerances :

with wall thickness :

\pm 10% for T \leq 5 mm

\pm 0.5 mm for T>5mm

with diameter :

\pm 1% with minimum value of \pm 0.5 mm

ovalitaty :

max. 2% of the nominal diameter

straightness:

0.2% of total length

weight :

\pm 6% per individual legths;

Weld seam removal: externally 100%

internally (by request)

Documents:

trial report type 2.2 (without non-destructive testing of weld)

inspection certificate type 3.1 or type 3.2 (by request)

(chemical analysis ; traction; non-destructive test of weld)

By request we can manufacture tubes with other wall thickness dimensions (acc. EN 10220)



ArcelorMittal Tubular Products lasi			
EN 10219, S235JR, S275 JO steel, black			
Outside Diameter	wall thickness	weight	pieces per bundles
D	T		6m
mm	mm	kg/m	
42.4	2	1.99	61
	2.5	2.91	61
	3	2.91	61
48.3	2	2.28	61
	2.5	2.82	61
	3	3.35	61
60.3	4	4.37	61
	2	2.88	37
	2.5	3.56	37
76.1	3	4.24	37
	4	5.55	37
	2	3.65	37
88.9	2.5	4.54	37
	3	5.41	37
	4	7.11	37
101.6	4	8.38	19
	5	10.3	19
	6	12.3	19
114.3	6.3	12.8	19
	3	7.29	19
	4	9.63	19
139.7	5	11.9	19
	6	14.1	19
	6.3	12.8	19
168.3	3	8.23	19
	4	10.9	19
	5	13.5	19
219.1	6	16	19
	6.3	16.8	19
	4	13.4	10
188.3	5	16.6	10
	6	19.8	10
	6.3	20.7	10
219.1	4	16.2	7
	5	20.1	7
	6	24	7
219.1	6.3	25.2	7
	5	26.4	7
	6	31.5	7
219.1	6.3	33.1	7
	8	41.6	7

TUBES FOR CONSTRUCTIONS

EN 10219-1 and EN 10219-2

Cold formed hollow structural sections for constructions
Square and rectangular sections

Dimensions : HxB: 20x20- 60x60 mm: 80x40 mm

T : 1.5 mm - 4 mm

l : 6 - 10 m +100/-0 mm sau ± 50mm

Steel : S235 JR; S275 JO; DC01

Manufacturing process : longitudinally welded
 cold formed

Protection :

- black with temporary alkaline protection (min.30 days)
- externally lacquered
 (min.6 months in sheltered environment)(min.20-25 µm)
- galvanized(min.55 µm)

Tolerances :

with wall thickness :

±10% for T ≤ 5 mm

with H,B dimensions:

± 1% with minimum

concavity/convexity:

max 0.8% with minimum

squareness of side :

90 gr. ±1 gr

twist (v):

2 mm plus 0.5 mm/m length

straightness:

0.15% of total length

weight:

± 6% per individual lengths

Documents:

trial report type 2.2



ArcelorMittal Tubular Products lasi							
EN 10219, S235JR, S275 JO steel, black							
Size		wall	weight	Size		wall	weight
		thickness				thickness	
H	B	T	M	H	B	T	M
mm	mm	mm	kg/m	mm	mm	mm	kg/m
20	20	1.5	0.83	45	45	2	2.62
		2	1.05			3	3.77
30	10	1.5	1.05			4	4.83
25	25	1.5	1.06	50	40	2	2.62
		2	1.36			2.5	3.21
30	20	1.5	1.06			3	3.77
		2	1.36	60	30	2	2.62
30	30	1.5	1.3			2.5	3.21
		2	1.68			3	3.77
		2.5	20.3	50	50	2	2.93
		3	2.36			2.5	3.6
40	20	1.5	1.3			3	4.25
		2	1.68			3.5	4.86
		2.5	20.3			4	5.45
		3	2.36	60	40	1.5	2.24
35	35	1.5	1.53			2	2.93
		2	1.99			2.5	3.6
		2.5	2.42			3	4.25
		3	2.83			3.5	4.86
40	30	1.5	1.53	70	40	2.5	3.99
		2	1.99			3	4.72
		2.5	2.42	60	60	2	3.56
		3	2.83			2.5	4.39
50	20	2	1.99			3	5.19
40	40	1.5	1.77			3.5	5.96
		2	2.31			4	6.71
		2.5	2.82	80	40	2	3.56
		3	3.3			2.5	4.39
		4	4.2			3	5.19
50	30	1.5	1.77			3.5	5.96
		2	2.31			4	6.71
		2.5	2.82				
		3	3.3				
60	20	2	2.31				
		2.5	2.82				
		3	3.3				
50	35	2	2.46				
		3	3.54				

dimensions that are
 executed from DC 01

ArcelorMittal Tubular Products Iasi

EN 10220

Diametru D	Grosimea de perete ,T, mm													
	2	2.3	2.6	2.9	3.2	3.6	4	4.5	5	5.4	5.6	6.3	7.1	8
Masa kg/m														
13.5	-	0.636	0.699	0.758	0.813									
17.2	-	0.845	0.936	1.02	1.1									
21.3	-	1.08	1.2	1.32	1.43									
26.9	-	1.4	1.56	1.72	1.87									
33.7	-	1.78	1.99	2.2	2.41	2.67	2.93							
42.4	-	2.27	2.55	2.82	3.09	3.44	3.79							
48.3	2.28	2.61	2.93	3.25	3.56	3.97	4.37							
51	2.42	2.76	3.1	3.44	3.77	4.21	4.64							
54	2.56	2.93	3.3	3.65	4.01	4.47	4.93							
57	2.71	3.1	3.49	3.87	4.25	4.74	5.23							
60.3	2.88	3.29	3.7	4.11	4.51	5.03	5.55	6.19						
63.5	3.03	3.47	3.9	4.33	4.76	5.32	5.87	6.55						
70	3.35	3.84	4.32	4.8	5.27	5.9	6.51	7.27						
73	3.5	4.01	4.51	5.01	5.51	6.16	6.81	7.6						
76.1	3.65	4.19	4.71	5.24	5.75	6.44	7.11	7.95						
88.9				6.15	6.76	7.57	8.38	9.37	10.3	11.1	11.5	12.8		
101.6				7.06	7.77	8.7	9.63	10.8	11.9	12.8	13.3	14.8		
108				7.52	8.27	9.27	10.3	11.5	12.7	13.7	14.1	15.8		
114.3					8.77	9.83	10.9	12.2	13.5	14.5	15	16.8		
133						11.5	12.7	14.3	15.8	17	17.6	19.7		
139.7						12.1	13.4	15	16.6	17.9	18.5	20.7		
141.3						12.2	13.5	15.2	16.8	18.1	18.7	21		
159						13.8	15.3	17.1	19	20.5	21.2	23.7	26.6	
168.3						14.6	16.2	18.2	20.1	21.7	22.5	25.2	28.2	
219.1								23.8	26.4	28.5	29.5	33.1	37.1	41.6

TUBES FOR PIPING

EN 10208-1

Steel tubes for conducting power fuel liquids

Dimensions : \varnothing : 33.7 mm - 219.1mm

g : 2.3 mm - 8 mm

l : 6 m -12 m +100/-0 mm or \pm 50mm

Steel : L210GA; L235GA; L245GA; L290GA

Manufacturing process : longitudinally welded

- hot reduced up to $\varnothing \leq 76.1$ mm

- cold formed and warm treated for $\varnothing 88.9$ mm

- cold formed with weld seam annealed for $\varnothing 114.3$ -219.1 mm

Protection :

black with temporary alkaline protection (min.30 days)

externally painted (min.6 months in sheltered environment)(min 20-25 μ m)

Tightness :

NDT 100% for $\varnothing 33.7$ -88.9 mm

hydrostatic test at max.207 bar for $\varnothing 114.3$ -219.1mm

Non destructive test of weld :

NDT 100% for $\varnothing 33.7$ -88.9 mm

NDT on weld from 114.3 -219.1 mm

Tolerances :

with wall thickness :

+ 1 mm/ -0.5 mm

with diameter :

\pm 0.5 mm or \pm 0.5% D(which is higher), but max \pm 1.6 mm

with ovality :

included in diameter for D \leq 60 mm (for pipe body and end)

2% for D > 60mm for the pipe body

1.5% for D > 60mm for the pipe end

with straightness:

\leq 0.2% of total length

with weight :

+ 10% or -3.5%

Weld seam removed: externally

internally

Ends processing:

perpendicularly cut

chamfered from $\varnothing \geq 60.3$ mm and g ≥ 3.6 mm

Documents:

trial report type 2.2

inspection certificate type 3.1 or type 3.2 (by request)

(chemical analysis on charge; traction;

flattening; tightness; nondestructive test of weld)

ArcelorMittal Tubular Products lasi								
EN 10208, L210GA; L235GA, L245GA ; L290GA steel, black								
Outside	wall	weight	pieces per		Outside	wall	weight	pieces per
Diameter	thickness		bundles		Diameter	thickness		bundles
D	T				D	T		6m /
mm	mm	kg/m			mm	mm	kg/m	12m
33.7	2.3	1.78	91		139.7	3.2	10.8	10
	2.6	2.27	91			3.6	12.1	10
	2.9	2.51	91			4	13.4	10
	3.2	2.75	91			4.5	15	10
	3.6	3.05	91			5	16.6	10
	4	3.35	91			5.6	18.5	10
42.4	2.3	2.27	61			6.3	20.7	10
	2.6	2.55	61		168.3	3.6	14.6	7
	2.9	2.82	61			4	16.2	7
	3.2	3.09	61			4.5	18.2	7
	3.6	3.44	61			5	20.1	7
	4	3.79	61			5.6	22.5	7
48.3	2.3	2.61	61			6.3	25.2	7
	2.6	2.93	61			7.1	28.2	7
	2.9	3.25	61		219.1	4	21.2	7
	3.2	3.56	61			4.5	23.8	7
	3.6	3.97	61			5	26.4	7
	4	4.37	61			5.6	29.5	7
60.3	2.3	3.29	37			6.3	33.1	7
	2.6	3.7	37			7.1	37.1	7
	2.9	4.11	37			8	41.6	7
	3.2	4.51	37					
	3.6	5.03	37					
	4	5.55	37					
76.1	2.6	4.71	37					
	2.9	5.24	37					
	3.2	5.75	37					
	3.6	6.44	37					
	4	7.11	37					
	4.5	7.95	37					
88.9	2.9	6.15	19					
	3.2	6.76	19					
	3.6	7.57	19					
	4	8.38	19					
	4.5	9.37	19					
	5	10.3	19					
114.3	3.2	8.77	19					
	3.6	9.83	19					
	4	10.9	19					
	4.5	12.2	19					
	5	13.5	19					
	5.6	15	19					
	6.3	16.8	19					



TUBES FOR PRESSURE

EN 10217-1 Pipes used for pressure

Dimensions : \varnothing : 21.3 mm - 219.1mm

g : 2.3 mm - 8 mm

l : 6 m -12 m +100/-0 mm or \pm 50mm

Steel: P235TR1

Manufacturing process : longitudinally welded

- hot reduced up to $\varnothing \leq 76.1$ mm; weld factor $v=1$

- cold formed for $\varnothing 88.9$ -219.1 mm; weld factor $v=0.9$

- cold formed and warm treated for $\varnothing 88.9$ mm; weld factor $v=1$

- cold formed with weld seam annealed for $\varnothing 139.7$ -219.1 mm; weld factor $v=0.9$

Protection: black with temporary alkaline protection (min.30 days)

externally painted (min.6 months in sheltered environment)(min.20-25 μ m)

galvanized(min.55 μ m)

Tightness:

NDT 100% for $\varnothing 42.4$ -114.3 mm

hydrostatic test at 70 bar for $\varnothing 101.6$ -219.1mm

Non destructive test of weld : NDT 100%

NDT 100% for $\varnothing 42.4$ -114.3 mm

NDT on weld from 139.7 -219.1 mm

Tolerances :

with wall thickness :

$\pm 10\%$ or ± 0.3 mm, which is higher, for $T \leq 5$

$\pm 8\%$ or ± 2 mm, which is smaller, for $T > 5$ -mm

with diameter:

$\pm 1\%$ or ± 0.5 mm, which is higher

straightness:

0.2% of total length

weight:

$\pm 6\%$ on individual lengths

Weld seam removed: externally 100%

internally

Ends processing: perpendicularly cut

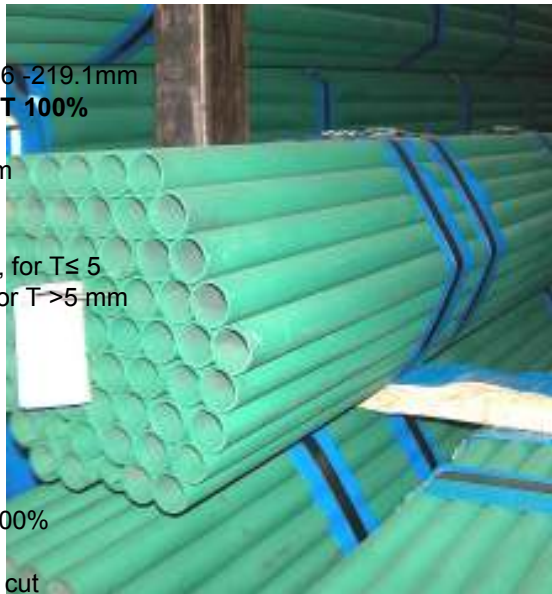
chamfered from $\varnothing \geq 60.3$ mm and $g \geq 3.6$ mm

Documents:

trial report type 2.2

inspection certificate type 3.1 or inspection certificate 3.2 (by request)

(chemical analysis; traction; tightness; nondestructive test of weld)



ArcelorMittal Tubular Products lasi							
EN 10217-1, P235TR1 steel, black				EN 10217-1, P235TR1 steel, black			
Outside	wall	weight	pieces per	Outside	wall	weight	pieces per
Diameter	thickness		bundles	Diameter	thickness		bundles
D	T			D	T		
mm	mm	kg/m		mm	mm	kg/m	6m/
17.2	2.3	0.845	217	101.6	3.2	7.77	19
	2.6	0.936	217		3.6	8.7	19
	2.9	1.02	217		4	9.63	19
21.3	2.3	1.08	169		4.5	10.8	19
	2.6	1.2	169		5	11.9	19
	2.9	1.32	169		5.6	13.3	19
	3.2	1.43	169		6.3	14.8	19
26.9	2.3	1.4	127	114.3	3.2	8.77	19
	2.6	1.56	127		3.6	9.83	19
	2.9	1.72	127		4	10.9	19
	3.2	1.87	127		4.5	12.2	19
33.7	2.6	1.99	91		5	13.5	19
	2.9	2.2	91		5.6	15	19
	3.2	2.41	91		6.3	16.8	19
	3.6	2.67	91	139.7	3.6	12.1	10
	4.0	2.93	91		4	13.4	10
42.4	2.6	2.55	61		4.5	15.1	10
	2.9	2.82	61		5	16.6	10
	3.2	3.09	61		5.6	18.5	10
	3.6	3.44	61		6.3	20.7	10
	4.0	3.09	61	159	4	15.3	10
48.3	2.6	2.93	61		4.5	17.1	10
	2.9	3.25	61		5	19	10
	3.2	3.56	61		5.6	21.2	10
	3.6	3.97	61		6.3	23.7	10
	4.0	4.37	61		7.1	26.6	10
60.3	2.6	3.7	37	168.3	3.6	14.6	7
	2.9	4.11	37		4	16.2	7
	3.2	4.51	37		4.5	18.2	7
	3.6	5.03	37		5	20.1	7
	4.0	5.55	37		5.6	22.5	7
76.1	2.6	5.12	37		6.3	25.2	7
	2.9	5.69	37		7.1	28.2	7
	3.2	6.26	37	219.1	4	21.2	7
	3.6	7	37		4.5	23.8	7
	4.0	7.74	37		5	26.4	7
88.9	3.2	6.76	19		5.6	29.5	7
	3.6	7.57	19		6.3	33.1	7
	4.0	8.38	19		7.1	37.1	7
	4.5	9.37	19		8	41.6	7
	5.0	10.3	19				

TUBES FOR PRECISION

EN 10305-3 Steel pipes for precision utilisation

Dimensions : \varnothing : 14 mm - 76mm

T : 1 mm - 2 mm

l : 6 m +100/-0 mm or \pm 50mm

Steel: DC01-DC03

Manufacturing process : longitudinally welded

- cold rolled (S3)

Delivery status :

CR1 - not treated, but appropriate for final annealing

Protection: black with temporary alkaline protection (max.30 days)

oiling (1- 3 months)

Tolerances :

with wall thickness:

T \leq 1.5 mm : \pm 0.15 mm

T >1.5 mm: \pm 0.1T or \pm 0.35 mm,
which is a smaller value

with diameter:

according to the tolerance
indicated for each range of dimensions

straightness:

max 0.002 of total length

Weld seam removed:

externally 100%

internally (by request for \varnothing > 40 mm)

Ends processing: straight cut

Documents:

trial test type 2.2

inspection certificate type 3.1

(chemical analysis; traction; visual examination)



ArcelorMittal Tubular Products Iasi					
EN 10305-3, DC-01; DC-03 steel, black					
Diametrul ext. D		grosime de perete T			
cu limite de toleranta		1	1.25	1.5	2
12		0.271	0.331	0.388	0.493
14	\pm 0.12	0.321	0.393	0.462	0.592
16		0.37	0.455	0.536	0.691
18		0.419	0.516	0.61	0.789
20	\pm 0.15	0.469	0.578	0.684	0.888
22		0.518	0.64	0.758	0.986
25		0.592	0.732	0.869	1.13
26		0.616	0.763	0.906	1.18
28		0.666	0.825	0.980	1.280
30		0.715	0.886	1.05	1.38
32	\pm 0.20	0.765	0.948	1.13	1.48
33		0.789	0.979	1.17	1.53
34		0.814	1.01	1.20	1.58
35			1.04	1.24	1.63
36			1.07	1.28	1.68
38			1.13	1.35	1.78
40			1.19	1.42	1.87
42				1.50	1.97
45	\pm 0.25			1.61	2.12
47				1.72	2.27
50				1.79	2.37
51				1.83	2.42
54				1.94	2.56
57	\pm 0.30			2.05	2.71
60				2.16	2.86
63.5				2.29	3.03
68				2.46	3.25
76	\pm 0.35			2.76	3.65