

# AS 1074

Technical Data of Pipes Conforming to AS 1074 for Steel tubes and tubulars for ordinary service

Class	Nominal Size		Outside Diameter		Wall Thickness (mm)	Weight of Pipe Plain End (kg/m)	Test Pressure	Piece Per Bundle
	NPS	DN	min.	max.			bar	
L	4"	100	113.0	113.9	3.6	9.75	50	14
M	4"	100	113.3	114.9	4.5	12.20	50	14
	5"	125	138.7	140.6	5.0	16.60	50	10
	6"	150	164.1	166.1	5.0	19.70	50	7
H	4"	100	113.3	114.9	5.4	14.50	50	10
	5"	125	138.7	140.6	5.4	17.90	50	10
	6"	150	164.1	166.1	5.4	21.30	50	7

## Tolerances:



**1. Outside Diameter** : As per the above table

## 2. Thickness:

Light	Medium	Heavy
-8%	-10%	-10%
+unlimited	+unlimited	+unlimited

**3. Weight** : +10%/-8% ( Single tube)

**4. Straightness** : 0.2% of the length.

**5. Ends** : Cut cleanly and nominally square with the axis of the tube and free from excessive burrs.

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**6. Chemical Composition (max %) :** S-0.045% , P-0.045% & CE-0.40%

**7. Mechanical Properties** : Tensile Strength : 320 to 460 N/mm<sup>2</sup>,  
: Yield Strength : 195 N/mm<sup>2</sup> (minimum)  
: % Elongation : 20% minimum

**8. Flattening Test (90°)** : For weld Test - Flatten up to 75% of original OD of tube. No cracks in the weld.  
For Material-Flatten up to 60% of original OD of tube. No cracks in the metal other than in the weld.

**9. Leak Tightness test:**

a) : Online NDT (Eddy Current) OR

b) : Hydro testing at pressure as per above table and holding time min. 5 second.



**10. Surface Protection** : Black & Galvanizing coating as per standard / customer requirement.

**11. Packing** : Hexagonal Type

**12. Colour Coding** : For Light -- Brown  
For Medium -- Blue  
For Heavy -- Red