

# BS 1387

Technical Data of Pipes Conforming to BS 1387 for plain end steel tubes

Class	Nominal Size		Outside Diameter		Wall Thickness (mm)	Weight of Tube Plain End (kg/m)	Test Pressure	Pieces 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	12.2	50	14
	5"	125	138.7	140.6	5.0	16.6	50	10
	6"	150	164.1	166.1	5.0	19.7	50	7
H	4"	100	113.3	114.9	5.4	14.5	50	10
	5"	125	138.7	140.6	5.4	17.9	50	10
	6"	150	164.1	166.1	5.4	21.3	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 %) :** C-0.20%, Mn-1.20%, S-0.045% & P-0.045%

**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

