

BS EN 10255:2004+A1:2007

Technical Data of Pipes Conforming to BS EN 10255:2004+A1:2007 for Non-alloy steel tubes suitable for welding and threading.

Class	Nominal Size		Outside Diameter		Wall Thickness (mm)	Weight of Pipe Plain End (kg/m)	Test Pressure	Pieces per Bundle
	NPS	OD	min.	max.			bar	
Type - L	4"	114.3	113.0	113.9	3.6	9.83	50	14
	5"	139.7	138.5	140.8	4.5	15.00	50	10
	6"	165.1	163.9	166.5	4.5	17.80	50	10
Type - L1	4"	114.3	113.0	114.9	4.0	10.80	50	14
Type - L2	4"	114.3	113.0	113.9	3.6	9.75	50	14
Medium	4"	114.3	113.1	115.0	4.5	12.20	50	14
	5"	139.7	138.5	140.8	5.0	16.60	50	10
	6"	165.1	163.9	166.5	5.0	19.80	50	7
Heavy	4"	114.3	113.1	115.0	5.4	14.50	50	10
	5"	139.7	138.5	140.8	5.4	17.90	50	7
	6"	165.1	163.9	166.5	5.4	21.30	50	7

Tolerances:

- 1. Outside Diameter** : As per the above table
- 2. Thickness** : $\pm 10\%$ for M and H series & Type L
: -8% with the plus tolerance limited by the mass tolerance, for Types L1 and L2.
- 3. Weight** : $\pm 7.5\%$ 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. Straightness** : Straightness shall not exceed $0.002 L$.

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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 -0.030% & P -0.035%

7. Mechanical Properties :

Tensile Strength	: 320 to 520 N/mm ² ,
Yield Strength	: 195 N/mm ² (minimum)
% Elongation	: 20% minimum

8. Flattening Test : For above NPS 2" - Welded tubes shall be flattened with the weld placed alternately at 0° or 90° to the direction of the force. For Weld Test - Flatten up to 75% of original dia of the tube. 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. 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 : Galvanizing coating as per EN 10240 A.1 / EN ISO 1461 / customer requirement.

11. Marking : Stenciling as per standard & customer requirement.

12. Packing : Hexagonal Type

13. Colour Coding :

For Type L	-- Green
For Type L1	-- White
For Type L2	-- Brown
For Medium	-- Blue
For Heavy	-- Red