

# Technical Specification of Pipes conforming to BS EN 10255

| Specified OD (mm) | Designation of Thread | H Heavy Series        |       |                |                                              |                     |                       | Medium Heavy Series |                |                                              |                     |                       |       | Light Series   |                                              |                     |                       |       |                | L1 Series                                    |                     |                       |       |                |                                              | L2 Series           |      |      |           |                     |      |
|-------------------|-----------------------|-----------------------|-------|----------------|----------------------------------------------|---------------------|-----------------------|---------------------|----------------|----------------------------------------------|---------------------|-----------------------|-------|----------------|----------------------------------------------|---------------------|-----------------------|-------|----------------|----------------------------------------------|---------------------|-----------------------|-------|----------------|----------------------------------------------|---------------------|------|------|-----------|---------------------|------|
|                   |                       | Outside Diameter (mm) |       | Thickness (mm) | Mass per unit length of bare pipe (kg./Mtr.) |                     | Outside Diameter (mm) |                     | Thickness (mm) | Mass per unit length of bare pipe (kg./Mtr.) |                     | Outside Diameter (mm) |       | Thickness (mm) | Mass per unit length of bare pipe (kg./Mtr.) |                     | Outside Diameter (mm) |       | Thickness (mm) | Mass per unit length of bare pipe (kg./Mtr.) |                     | Outside Diameter (mm) |       | Thickness (mm) | Mass per unit length of bare pipe (kg./Mtr.) |                     |      |      |           |                     |      |
|                   |                       |                       |       |                |                                              |                     |                       |                     |                |                                              |                     |                       |       |                |                                              |                     |                       |       |                |                                              |                     |                       |       |                |                                              |                     |      |      |           |                     |      |
|                   |                       | Max.                  | Min.  |                | Plain End                                    | Threaded & socketed | Max.                  | Min.                |                | Plain End                                    | Threaded & socketed | Max.                  | Min.  |                | Plain End                                    | Threaded & socketed | Max.                  | Min.  |                | Plain End                                    | Threaded & socketed | Max.                  | Min.  |                | Plain End                                    | Threaded & socketed | Max. | Min. | Plain End | Threaded & socketed | Max. |
| 21.3              | ½                     | 21.8                  | 21.0  | 3.2            | 1.44                                         | 1.45                | 21.8                  | 21.0                | 2.6            | 1.21                                         | 1.22                | 21.7                  | 21.0  | 2.3            | 1.08                                         | 1.09                | 21.7                  | 21.0  | 2.3            | 1.08                                         | 1.09                | 21.4                  | 21.0  | 2.0            | 0.947                                        | 0.956               |      |      |           |                     |      |
| 26.9              |                       | 27.3                  | 26.5  | 3.2            | 1.87                                         | 1.88                | 27.3                  | 26.5                | 2.6            | 1.56                                         | 1.57                | 27.1                  | 26.4  | 2.3            | 1.40                                         | 1.41                | 27.1                  | 26.4  | 2.3            | 1.39                                         | 1.40                | 26.9                  | 26.4  | 2.3            | 1.38                                         | 1.39                |      |      |           |                     |      |
| 33.7              | 1                     | 34.2                  | 33.3  | 4.0            | 2.93                                         | 2.95                | 34.2                  | 33.3                | 3.2            | 2.41                                         | 2.43                | 34.0                  | 33.3  | 2.9            | 2.20                                         | 2.22                | 34.0                  | 33.2  | 2.9            | 2.20                                         | 2.22                | 33.8                  | 33.2  | 2.6            | 1.98                                         | 2.00                |      |      |           |                     |      |
| 42.4              | 1                     | 42.9                  | 42.0  | 4.0            | 3.79                                         | 3.82                | 42.9                  | 42.0                | 3.2            | 3.10                                         | 3.13                | 42.7                  | 41.9  | 2.9            | 2.82                                         | 2.85                | 42.7                  | 41.9  | 2.9            | 2.82                                         | 2.85                | 42.5                  | 41.9  | 2.6            | 2.54                                         | 2.57                |      |      |           |                     |      |
| 48.3              | 1½                    | 48.8                  | 47.9  | 4.0            | 4.37                                         | 4.41                | 48.8                  | 47.9                | 3.2            | 3.56                                         | 3.60                | 48.6                  | 47.8  | 2.9            | 3.25                                         | 3.29                | 48.6                  | 47.8  | 2.9            | 3.24                                         | 3.28                | 48.4                  | 47.8  | 2.9            | 3.23                                         | 3.27                |      |      |           |                     |      |
| 60.3              | 2                     | 60.8                  | 59.7  | 4.5            | 6.19                                         | 6.26                | 60.8                  | 59.7                | 3.6            | 5.03                                         | 5.10                | 60.7                  | 59.6  | 3.2            | 4.51                                         | 4.58                | 60.7                  | 59.6  | 3.2            | 4.49                                         | 4.56                | 60.2                  | 59.6  | 2.9            | 4.08                                         | 4.15                |      |      |           |                     |      |
| 76.1              | 2 ½                   | 76.6                  | 75.3  | 4.5            | 7.93                                         | 8.05                | 76.6                  | 75.3                | 3.6            | 6.42                                         | 6.54                | 76.0                  | 75.2  | 3.2            | 5.75                                         | 5.87                | 76.3                  | 75.2  | 3.2            | 5.73                                         | 5.85                | 76.0                  | 75.2  | 3.2            | 5.71                                         | 5.83                |      |      |           |                     |      |
| 88.9              | 3                     | 89.5                  | 88.0  | 5.0            | 10.3                                         | 10.5                | 89.5                  | 88.0                | 4.0            | 8.36                                         | 8.53                | 88.7                  | 87.9  | 3.2            | 6.76                                         | 6.93                | 89.4                  | 87.9  | 3.6            | 7.55                                         | 7.72                | 88.7                  | 87.9  | 3.2            | 6.72                                         | 6.89                |      |      |           |                     |      |
| 101.6             | 3 ½                   | -                     | -     | -              | -                                            | -                   | -                     | -                   | -              | -                                            | -                   | 101.2                 | 100.3 | 3.6            | 8.70                                         | 8.88                | -                     | -     | -              | -                                            | -                   | -                     | -     | -              | -                                            | -                   |      |      |           |                     |      |
| 114.3             | 4                     | 115.0                 | 113.1 | 5.4            | 14.5                                         | 14.8                | 115.0                 | 113.1               | 4.5            | 12.2                                         | 12.5                | 113.9                 | 113.0 | 3.6            | 9.83                                         | 10.1                | 114.9                 | 113.0 | 4.0            | 10.8                                         | 11.1                | 113.9                 | 113.0 | 3.6            | 9.75                                         | 10.0                |      |      |           |                     |      |
| 139.7             | 5                     | 140.8                 | 138.5 | 5.4            | 17.9                                         | 18.4                | 140.8                 | 138.5               | 5.0            | 16.6                                         | 17.1                | 140.8                 | 138.5 | 4.5            | 15.0                                         | 15.5                | -                     | -     | -              | -                                            | -                   | -                     | -     | -              | -                                            | -                   |      |      |           |                     |      |
| 165.1             | 6                     | 166.5                 | 163.9 | 5.4            | 21.3                                         | 21.9                | 166.5                 | 163.9               | 5.0            | 19.8                                         | 20.4                | 166.5                 | 163.9 | 4.5            | 17.8                                         | 18.4                | -                     | -     | -              | -                                            | -                   | -                     | -     | -              | -                                            | -                   |      |      |           |                     |      |

## Tolerances

OD :- As per above table

Thickness: -

± 10% (For H, M & L Series)

± 8% (For L1 & L2 Series)

Weight:

± 7.5% (For H, M & L Series)

-8%,+10% (For L1 & L2 Series)

## Chemical Properties (Max%)

Carbon : 0.20%

Manganese : 1.40%

Phosphorus : 0.035%

Sulphur : 0.030%

## Mechanical Properties

Yield Stress : 195 N/mm (Min.)

Tensile Strength : 320 to 520 N/mm

%Elongation : 20 % (Min.)

### Bend Test:-

For tubes upto & including 60.3 mm OD

Bending Angle : 90

Bending radius : 3 D

### Flattening Test:-

For tubes above 60.3 mm OD

1.Flatten upto 75% of OD for weld test weld

at 12 of 3 O'clock.

2.Flatten upto 60% of OD for raw material test

## Galvanizing Test

1. Zinc coating : 55 µ (min.)

2. Adhesion test (upto 60.3 mm OD)