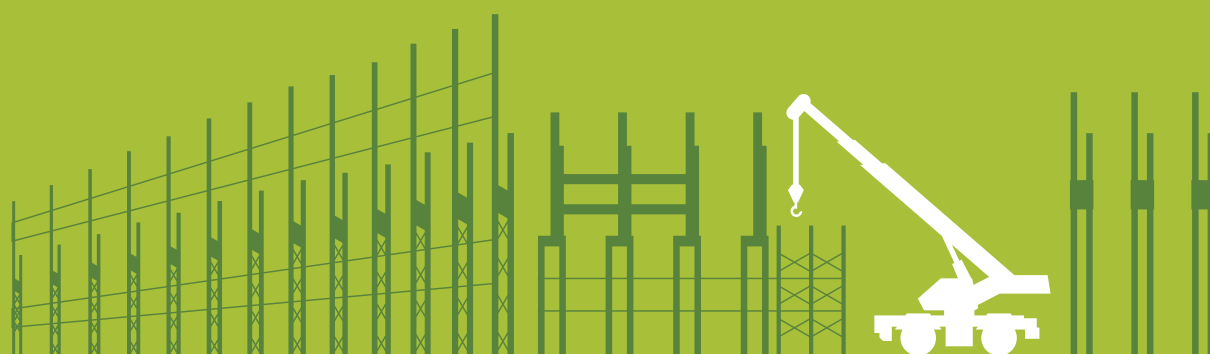




INTERPIPE

EXPERT PIPE SOLUTIONS FOR INDUSTRIAL APPLICATION

SEAMLESS PIPES,
WELDED PIPES AND HOLLOW SECTIONS



CONTENT

Interpipe at a glance

Seamless pipes

ASTM A 106/A 106M; A 53/A 53 M; ASTM A 333/A 333 M	5
DIN EN 10255	8
EN 10210-1, 2; EN 10297-1; DIN 1629; EN 10225	10
EN 10216-1; EN 10216-2; EN 10216-3	12

Line pipes

API 5L/ISO 3183	14
GOST 8731-74/8732-78	16

Welded pipes

ASTM A 53/A53 M	18
DIN EN 10255; EN 10225	19
EN 10217-1	20
EN 10217-2; EN 10217-3	20
EN 10219-1, 2	22
EN 10224	22
GOST 10705-80	23
GOST 20295-85	23

Square and rectangular pipes (hollow sections)

EN 10219-1, 2	24
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Polyethylene coated pipes

DIN 30670	25
EN ISO 21809	26
EN 10288	27

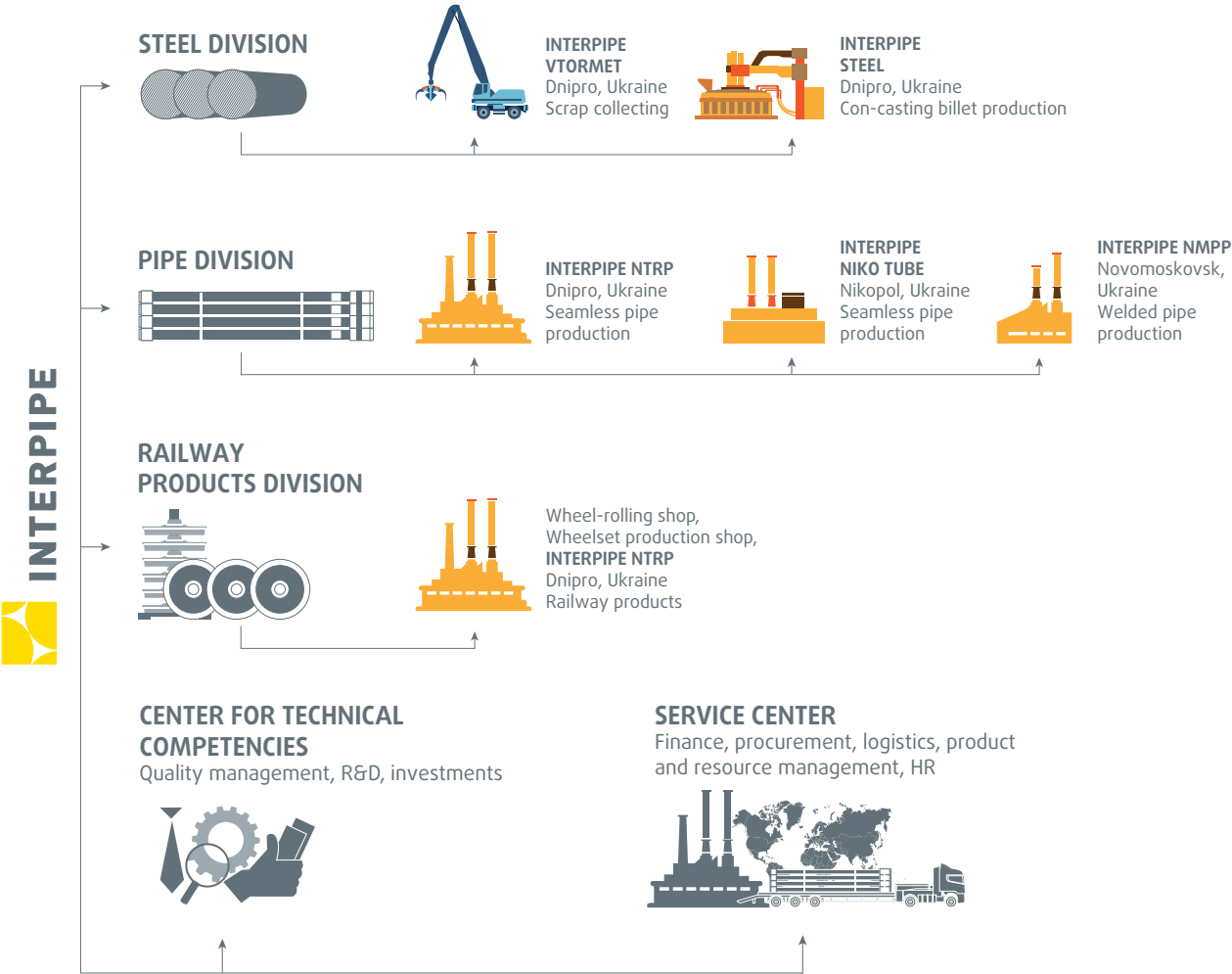
INTERPIPE AT A GLANCE

Interpipe is a global steel pipe producer for all major applications – oil&gas exploration and transportation, power generation, mechanical and structural use.

The company’s products are supplied to 80 countries all over the world through a chain of commercial offices located in Ukraine, Russia, Kazakhstan, Europe, the USA and the Middle East.

Interpipe structure includes production facilities located in Dnipro region, one of the major industrial centers of Ukraine. The company continues to invest heavily in the development and modernization of its mills.

Interpipe includes 3 operating divisions – Steel, Pipe and Railway Products. The company controls product quality at every stage: from manufacturing of raw materials to delivery of final products to customers.



SELLING TO CUSTOMERS GLOBALLY – KEY MARKETS

	North American Interpipe		Interpipe Middle East		Interpipe Kazakhstan		Interpipe Ukraine
	Interpipe Europe SA		Interpipe M		Interpipe Central Trade		



QUALITY-FOCUSED OPERATIONS

Interpipe considers quality control as a key part of the activities to manufacture products, exceeding customer needs. Quality control is implemented at all stages of production process – starting from continuous casting at the in-house mini mill and up to nondestructive testing of pipe body and pipe ends and shipping to customers.

Our commitment to quality is confirmed by:

- Pipe products certification in compliance with major international standards API 5CT, API 5L, EN (DIN), ASTM, JIS, GOST, DNV, Lloyd Register, UDT, Dir 97/23/EC, AD 2000 Merkblatt and customer specifications
- Quality management system as per ISO 9001 and API Q1
- Implementation of a continuous improvement system at the company mills
- Effectively operating customer reclamation system



ONGOING INVESTMENT PROGRAM

Interpipe regularly invests in development of its production capacities, improvement of the output quality, and expansion of its product range. Interpipe focused on providing the high quality product at short delivery time for each client. Interpipe has been conducting extensive improvement program, which included launch of in-house steel melting complex Interpipe Steel, installation of various new NDE systems, finishing lines and hydro testing equipment on the mills, improvement of heat treatment technologies.

SEAMLESS PIPES

ASTM A 106/A 106 M, ASTM A 53/A 53 M, ASTM A 333/A 333 M

Application: for producing structures, as well as for steam, water, gas and air pipelines for operations at low temperatures, and also in general machine-building and tool-making.

Steel grade: ASTM A 106 – A, B, C; ASTM A 53 – A, B; ASTM A 333 – Gr6

Pipe dimensions and weight according to ANSI/ASME B 36.10 M

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
½*	0.84	21.3	0.109	2.77	0.85	1.27	STD	40
			0.147	3.73	1.09	1.62	XS	80
¾*	1.05	26.7	0.113	2.87	1.13	1.69	STD	40
			0.154	3.91	1.48	2.20	XS	80
1	1.315	33.4	0.109	2.77	1.41	2.09	2.09	10
			0.114	2.90	1.46	2.18		30
			0.133	3.38	1.68	2.50	STD	40
			0.179	4.55	2.17	3.23	XS	80
1¼	1.660	42.2	0.109	2.77	1.81	2.69		10
			0.117	2.97	1.93	2.87		30
			0.140	3.56	2.27	3.39	STD	40
1½	1.900	48.3	0.191	4.85	3.00	4.47	XS	80
			0.109	2.77	2.09	3.11		10
			0.125	3.18	2.37	3.53		30
2	2.375	60.3	0.145	3.68	2.72	4.05	STD	40
			0.200	5.08	3.63	5.41	XS	80
			0.109	2.77	2.64	3.93		10
			0.125	3.18	3.01	4.48		30
			0.141	3.58	3.36	5.01		
2½	2.875	73.0	0.154	3.91	3.66	5.44	STD	40
			0.172	4.37	4.05	6.03		
			0.188	4.78	4.39	6.54		
			0.218	5.54	5.03	7.48	XS	80
			0.250	6.35	5.68	8.45		
			0.120	3.05	3.53	5.26		10
			0.156	3.96	4.53	6.74		
			0.172	4.37	4.97	7.40		
3	3.500	88.9	0.188	4.78	5.40	8.04		30
			0.203	5.16	5.80	8.63	STD	40
			0.216	5.49	6.13	9.14		
			0.250	6.35	7.01	10.44		
			0.276	7.01	7.67	11.41	XS	80
			0.375	9.52	10.02	14.9		160
			0.141	3.58	5.06	7.53		
			0.156	3.96	5.58	8.29		
			0.172	4.37	6.11	9.11		
3½	4.000	101.6	0.188	4.78	6.66	9.92		30
			0.216	5.49	7.58	11.29	STD	40
			0.250	6.35	8.69	12.93		
			0.281	7.14	9.67	14.40		
			0.300	7.62	10.26	15.27	XS	80
			0.438	11.13	14.34	21.35		160
			0.600	15.24	16.60	27.68	XXS	
			0.156	3.96	6.41	9.53		
0.172	4.37	7.03	10.48					
0.188	4.78	7.66	11.41		30			
0.226	5.74	9.12	13.57	STD	40			
0.250	6.35	10.02	14.92					
0.281	7.14	11.17	16.63					
0.318	8.08	12.52	18.63	XS	80			

■ – Upon agreement
* – For ASTM A 106, ASTM A 53

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
4	4.500	114.3	0.156	3.96	7.24	10.78		
			0.172	4.37	7.95	11.85		
			0.188	4.78	8.67	12.91		30
			0.203	5.16	9.32	13.89		
			0.219	5.56	10.02	14.91		
			0.237	6.02	10.80	16.07	STD	40
			0.250	6.35	11.36	16.91		
			0.281	7.14	12.67	18.87		
			0.312	7.92	13.97	20.78		
			0.337	8.56	15.00	22.32	XS	80
			0.438	11.13	19.02	28.37		120
			0.531	13.49	22.53	33.54		160
5	5.563	141.3	0.674	17.19	27.59	41.03	XXS	
			0.258	6.55	14.63	21.76	STD	40
			0.375	9.52	20.79	30.85	XS	80
			0.500	12.7	27.06	40.28		120
			0.626	15.88	32.99	49.10		160
6	6.625	168.3	0.750	19.05	38.59	57.43	XXS	
			0.172	4.37	11.87	17.67		
			0.188	4.78	12.94	19.28		
			0.203	5.16	13.94	20.76		
			0.219	5.56	15.00	22.31		
			0.250	6.35	17.04	25.36		
			0.280	7.11	18.99	28.26	STD	40
			0.312	7.92	21.06	31.32		
			0.344	8.74	23.10	34.39		
			0.375	9.52	25.05	37.28		
			0.432	10.97	28.60	42.56	XS	80
			0.500	12.70	32.74	48.73		
			0.562	14.27	36.43	54.20		120
			0.719	18.26	45.39	67.56		160
8	8.625	219.1	0.750	19.05	47.10	70.12		
			0.864	21.95	53.21	79.22	XXS	
			0.875	22.23	53.78	80.08		
			0.250	6.35	22.38	33.31		20
			0.277	7.04	24.72	36.31		30
			0.312	7.92	27.73	41.24		
			0.322	8.18	28.58	42.55	STD	40
			0.344	8.74	30.45	45.34		
			0.375	9.52	33.07	49.20		
			0.406	10.31	35.67	53.08		60
			0.438	11.13	38.33	57.08		
			0.500	12.70	43.43	64.64	XS	80
			0.562	14.27	48.44	72.08		
			0.594	15.09	51.00	75.92		100
0.719	18.26	60.77	90.44		120			
0.812	20.62	67.82	100.92		140			
0.875	22.22	72.49	107.88	XXS				
0.906	23.02	74.76	111.27		160			
1.000	25.40	81.51	121.33					
10	10.750	273.0	0.250	6.35	28.06	41.76		20
			0.279	7.09	31.23	46.49		
			0.307	7.80	34.27	51.01		30
			0.344	8.74	38.27	56.96		
			0.365	9.27	40.52	60.29	STD	40
			0.438	11.13	48.28	71.87		

— Upon agreement

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule		
	in	mm	in	mm	lb/ft	kg/m				
			0.500	12.70	54.79	81.52	XS	60		
			0.594	15.09	64.49	95.97		80		
			0.719	18.26	77.10	114.70		100		
			0.844	21.44	89.38	133.00	XXS	120		
			1.000	25.40	104.23	155.09		140		
			1.125	28.58	115.75	172.27		160		
			1.250	31.75	126.54	188.90				
12	12.750	323.8	0.281	7.14	37.46	55.76				
			0.312	7.92	41.48	61.70				
			0.330	8.38	43.81	65.19			30	
			0.344	8.74	45.69	67.91	STD			
			0.375	9.53	49.61	73.86				
			0.406	10.31	53.57	79.71			40	
			0.438	11.13	57.65	85.82	XS			
			0.500	12.70	65.48	97.44				
			0.562	14.27	73.22	108.93			60	
			0.625	15.88	81.01	120.59				
			0.688	17.48	88.71	132.05				
			0.750	19.05	95.21	143.17				
			0.812	20.62	103.63	154.17				
			0.844	21.44	107.42	159.87				
			0.875	22.23	111.08	165.33				
			0.983	23.83	118.44	176.29	XXS	120		
			1.000	25.40	125.61	186.92				
1.062	26.97	132.69	197.43							
1.125	28.58	139.81	208.08		140					
1.250	31.75	153.67	228.68							
1.312	33.32	160.42	238.69			160				
14	14.000	355.6	0.312	7.92	45.61	67.9		20		
			0.344	8.74	50.17	74.76				
			0.375	9.53	54.57	81.33		STD	30	
			0.406	10.31	59.00	87.79				
			0.438	11.13	63.44	94.55				
			0.469	11.91	67.84	100.95				
			0.500	12.7	72.16	107.40				
			0.562	14.27	80.73	120.12				
			0.594	15.09	85.05	126.71			60	
			0.625	15.88	89.36	133.04				
			0.688	17.48	97.91	144.76				
			0.750	19.05	106.13	158.10			80	
			0.875	22.23	122.17	182.76				
			0.938	23.83	194.96	130.85				
			1.094	27.79	224.65	150.79			100	
			1.250	31.75	253.56	170.21		120		
			1.406	35.71	281.70	189.11				
			2.000	50.8	381.83	256.32			140	
			2.125	53.97	401.50	269.50				
2.200	55.88	413.01	277.25							
2.500	63.5	457.40	307.05							
16	16	406.4	0.344	8.8	57.57	85.71				
			0.375	9.53	62.64	93.27			STD	30
			0.406	10.31	67.68	100.71				
			0.438	11.13	72.86	108.49				
			0.469	11.91	77.87	115.87				
			0.500	12.7	82.85	123.31			XS	40
			0.562	14.27	92.75	138				
0.625	15.88	102.72	152.94							

— Upon agreement

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
16	16	406.4	0.656	16.66	107.76	160.13		60
			0.688	17.48	112.62	167.66		
			0.750	19.05	122.27	181.98		
			0.812	20.62	131.84	196.18		80
			0.844	21.44	136.74	203.54		
			0.875	22.23	141.48	210.61		
			0.938	23.83	151.03	224.83		
			1.000	25.4	160.35	238.66		100
			1.031	26.19	164.98	245.57		
			1.062	26.97	169.59	252.37		
			1.125	28.58	178.89	266.3		
			1.188	30.18	188.11	280.01		120
			1.219	30.96	192.61	286.66		
			1.250	31.75	197.1	293.35		140
1.438	36.53	223.85	333.21					

DIN EN 10255 UNALLOYED STEEL TUBES SUITABLE FOR WELDING AND THREADING

Application: for transportation fluids and general purpose

Dimensions and weight for Hot rolled

Nominal size, mm	Outside diameter, mm		H (heavy-weight)		M (medium-weight)		Steel grades
	max.	min.	Wall thickness, mm	Weight per length unit, kg/m	Wall thickness, mm	Weight per length unit, kg/m	
33.7	34.2	33.3	4.0	2.9	3.2	2.41	S 195 T
42.4	42.9	42.0	4.0	3.79	3.2	3.1	
48.3	48.8	47.9	4.0	4.37	3.2	3.56	
60.3	60.8	59.7	4.5	6.19	3.6	5.03	
76.1	76.6	75.3	4.5	7.93	3.6	6.42	
88.9	89.5	88.0	5.0	10.3	4.0	8.36	
114.3	115.0	113.1	5.4	14.5	4.5	12.2	
139.7	140.8	138.5	5.4	17.9	5.0	16.66	
165.1	166.5	163.9	5.4	21.3	5.0	19.88	

— Upon agreement

Dimensions and weight for Hot rolled – Type L and L1

Nominal size, mm	Outside diameter, mm		Type L		Type L1		Steel grades
	max.	min.	Wall thickness, mm	Weight per length unit, kg/m	Wall thickness, mm	Weight per length unit, kg/m	
42.4	42.7	41.9	2.9	2.82	2.9	2.82	
48.3	48.6	47.8	2.9	3.25	2.9	3.24	
60.3	60.7	59.6	3.2	4.51	3.2	4.49	
76.1	76.3	75.2	-	-	3.2	5.73	
88.9	89.4	87.9	-	-	3.6	7.55	
114.3	114.9	113	-	-	4.0	10.8	
139.7	140.8	138.5	4.5	15.0	-	-	
165.1	166.5	163.9	4.5	17.8	-	-	

— Upon agreement



EN 10210-1, 2; EN 10297-1; EN 10225

Application: commercial pipes for instrumentation, construction, pipeworks and other general engineering purposes

Dimensions

D/s, mm																													
	2.6	2.9	3.2	3.6	4	4.5	5	5.6	6	6.3	7.1	8	8.8	9	9.5	10	11	12	12.5	13	13.5	14	14.2	15	15.5	16	16.5	17	
31.8																													
33.4																													
33.7																													
35																													
38																													
42.2																													
42.4																													
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343																													
355.6																													
368																													
377																													
381																													
394																													
406.4																													
419																													
426																													

■ – Can produce
 ■ – By agreement
 ■ – For production of these dimensions we have to prepare rolling tools. While placing the orders you have to clarify terms for preparing of needed equipment. Min order - 200tn per OD

Dimensions

D/s, mm	Wall thickness, mm																					Steel grades							
	17.5	18	19	20	22	22.2	24	25	26	27	28	30	32	35	36	38	40	42	45	50	55	60	65	70	75	EN 10210	EN 10297	EN 10225	
31.8																													
33.4																													
33.7																													
35																													
38																													
42.2																													
42.4																													
44.5																													
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394																													
406.4																													
419																													
426																													

EN 10216-1; EN 10216-2; EN 10216-3 STEEL TUBES DESIGNATED FOR PRESSURE PURPOSES

Dimensions

D/s, mm																													
	2.6	2.9	3.2	3.6	4	4.5	5	5.4	5.6	6	6.3	7.1	8	8.8	9	9.5	10	11	12	12.5	13	13.5	14	14.2	15	15.5	16	16.5	17
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32.0																													
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■ – Can produce
 ■ – By agreement
 ■ – For production of these dimensions we have to prepare rolling tools. While placing the orders you have to clarify terms for preparing of needed equipment. Min order - 200tn per OD

Dimensions

D/s, mm	Wall thickness, mm																								Steel grades		
	17.5	18	19	20	22	22.2	24	25	26	27	28	30	32	35	36	38	40	42	45	50	55	60	65	70			
31.8																										P235TR1-P355N, P460N, 16Mo3, 10CrMo5-5, 13CrMo4-5	
32.0																											
33.4																											
33.7																											
35																											
38																											
42.2																											
42.4																											
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330																											
343																											
355.6																											
368																											
377																											
381																											
394																											
406.4																											
419																											
426																											

LINE PIPES

SPECIFICATION FOR LINE PIPES – API 5L/ISO 3183

Application: gas, water and oil transportation
 Welded highest steel grade X70/Service Annex H
 Seamless highest steel grade X80/Service Annex H, J

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Wheight class	Schedule	Pipe type	
	in	mm	in	mm	lb/ft	kg/m			Seamless	Welded
½	0.840	21.3	0.109	2.77	0.85	1.27	STD	40	*	
			0.147	3.73	1.09	1.62	XS	80	*	
¾	1.050	26.7	0.113	2.87	1.13	1.69	STD	40	*	
			0.154	3.91	1.48	2.20	XS	80	*	
1	1.315	33.4	0.109	2.77	1.41	2.09		10	*	
			0.114	2.90	1.46	2.18		30	*	
			0.133	3.38	1.68	2.50	STD	40	*	
			0.179	4.55	2.17	3.24	XS	80	*	
1¼	1.660	42.2	0.109	2.77	1.81	2.69		10	*	
			0.117	2.97	1.93	2.87		30	*	
			0.140	3.56	2.27	3.39	STD	40	*	
1½	1.900	48.3	0.191	4.85	3.00	4.47	XS	80	*	
			0.109	2.77	2.09	3.11		10	*	
			0.125	3.18	2.37	3.53		30	*	
2	2.375	60.3	0.145	3.68	2.72	4.05	STD	40	*	
			0.200	5.08	3.63	5.41	XS	80	*	
			0.109	2.77	2.64	3.93		10	*	
			0.125	3.18	3.01	4.48		30	*	
2½	2.875	73.0	0.141	3.58	3.36	5.01		*		
			0.154	3.91	3.66	5.44	STD	40	*	
			0.172	4.37	4.05	6.03		*		
			0.188	4.78	4.39	6.54		*		
			0.218	5.54	5.03	7.48	XS	80	*	
			0.250	6.35	5.68	8.45		*		
			0.120	3.05	3.53	5.26		10	*	
			0.156	3.96	4.53	6.74		*		
3	3.500	88.9	0.172	4.37	4.97	7.40		*		
			0.188	4.78	5.40	8.04		30	*	
			0.203	5.16	5.80	8.63	STD	40	*	
			0.216	5.49	6.13	9.14		*		
			0.250	6.35	7.01	10.44		*		
			0.276	7.01	7.67	11.41	XS	80	*	
			0.375	9.52	10.02	14.9		160	*	
			0.141	3.58	5.06	7.53		*		
			0.156	3.96	5.58	8.30		*		
3½	4.000	101.6	0.172	4.37	6.12	9.11		*		
			0.188	4.78	6.66	9.92		30	*	
			0.216	5.49	7.58	11.29	STD	40	*	
			0.250	6.35	8.69	12.93		*		
			0.281	7.14	9.67	14.40		*		
			0.300	7.62	10.26	15.27	XS	80	*	
			0.438	11.13	14.34	21.35		160	*	
			0.600	15.24	16.60	27.68	XXS		*	
			0.156	3.96	6.41	9.54		*		
			0.172	4.37	7.04	10.48		*		
4	4.500	114.3	0.188	4.78	7.66	11.41		30	*	
			0.226	5.74	9.12	13.57	STD	40	*	
			0.250	6.35	10.02	14.92		*		
			0.281	7.14	11.17	16.63		*		
			0.318	8.08	12.52	18.64	XS	80	*	
			0.156	3.96	7.24	10.78		*		
5	5.563	141.3	0.172	4.37	7.96	11.85		*		
			0.188	4.78	8.67	12.91		30	*	
			0.203	5.16	9.32	13.89		*		
			0.219	5.56	10.02	14.91		*		
			0.237	6.02	10.80	16.08	STD	40	*	
			0.250	6.35	11.36	16.91		*		
			0.281	7.14	12.67	18.87		*		
			0.337	8.56	14.98	22.32	XS	80	*	
			0.438	11.13	19.00	28.32		120	*	
5	5.563	141.3	0.258	6.55	14.63	21.92	STD	40	*	
			0.281	7.14	15.87	23.50		*		
			0.312	7.92	17.51	25.99		*		
			0.344	8.74	19.19	28.45		*		
			0.375	9.53	20.80	30.88	XS	80	*	
			0.500	12.70	27.06	40.28		120	*	

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Wheight class	Schedule	Pipe type				
	in	mm	in	mm	lb/ft	kg/m			Seamless	Welded			
6	6.625	168.3	0.280	7.11	18.99	28.26	STD	40	*	*			
			0.312	7.92	21.06	31.33			*	*			
			0.344	8.74	23.10	34.39			*	*			
			0.375	9.53	25.05	37.31			*	*			
			0.432	10.97	28.60	42.56	XS	80	*	*			
			0.500	12.70	32.74	48.73			*	*			
			0.562	14.27	36.43	54.21		120	*	*			
			0.625	15.88	40.09	59.69			*	*			
			0.719	18.26	45.39	67.57		160	*	*			
			0.750	19.05	47.10	70.12			*	*			
			0.864	21.95	53.21	79.22	XXS		*	*			
			0.875	22.23	53.78	80.08			*	*			
			8	8.625	219.1	0.188	4.78	16.98	25.26			*	*
						0.203	5.16	18.28	27.43		20	*	*
0.219	5.56	19.68				29.48		30	*	*			
0.250	6.35	22.38				33.57			*	*			
0.277	7.04	24.72				36.82		30	*	*			
0.312	7.92	27.73				41.25			*	*			
0.322	8.18	28.58				42.55	STD	40	*	*			
0.344	8.74	30.45				45.34			*	*			
0.375	9.53	33.07				49.25			*	*			
0.406	10.31	35.67				53.09		60	*	*			
0.438	11.13	38.33				57.08			*	*			
0.500	12.70	43.43				64.64	XS	80	*	*			
0.562	14.27	48.44				72.08			*	*			
0.594	15.09	51.00				75.92		100	*	*			
0.625	15.88	53.45				79.59			*	*			
0.719	18.26	60.77				90.44		120	*	*			
0.750	19.05	63.14				93.98			*	*			
0.812	20.62	67.82				100.93		140	*	*			
0.875	22.23	72.49				107.93	XXS		*	*			
0.906	23.01	74.69				111.27		160	*	*			
1.000	25.40	81.51	121.33			*	*						
10	10.750	273.0	0.203	5.16	22.89	34.35			*	*			
			0.219	5.56	24.65	36.94			*	*			
			0.250	6.35	28.06	41.76		20	*	*			
			0.279	7.09	31.23	46.49			*	*			
			0.307	7.80	34.27	51.01		30	*	*			
			0.344	8.74	38.27	56.96			*	*			
			0.365	9.27	40.52	60.29	STD	40	*	*			
			0.438	11.13	48.28	71.88			*	*			
			0.500	12.70	54.79	81.53	XS	60	*	*			
			0.562	14.27	61.21	91.05			*	*			
			0.594	15.09	64.49	95.98		80	*	*			
			0.625	15.88	67.65	100.69			*	*			
			0.719	18.26	77.10	114.71		100	*	*			
			0.812	20.62	86.26	128.62			*	*			
			0.844	21.44	89.38	133.01		120	*	*			
			0.875	22.23	92.37	137.48			*	*			
			0.938	23.83	98.39	146.43			*	*			
			1.000	25.40	104.23	155.10	XXS	140	*	*			
			1.125	28.58	115.75	172.27		160	*	*			
			1.250	31.75	126.94	188.90			*	*			
12	12.750	323.8	0.219	5.56	29.34	43.96		20	*	*			
			0.250	6.35	33.41	50.11			*	*			
			0.281	7.14	37.46	55.76			*	*			
			0.312	7.92	41.48	61.70			*	*			
			0.330	8.38	43.81	65.19		30	*	*			
			0.344	8.74	45.62	67.91			*	*			
			0.375	9.53	49.61	73.86	STD		*	*			
			0.406	10.31	53.57	79.71		40	*	*			
			0.438	11.13	57.65	85.82			*	*			
			0.500	12.70	65.48	97.44	XS		*	*			
			0.562	14.27	73.22	108.93		60	*	*			
			0.625	15.88	81.01	120.59			*	*			
			0.688	17.48	88.71	132.05		80	*	*			
			0.750	19.05	96.21	143.17			*	*			
			0.812	20.62	103.63	154.17			*	*			
			0.875	22.23	111.08	165.33			*	*			
			0.938	23.83	118.44	176.29			*	*			
			1.000	25.40	125.61	186.92	XXS	120	*	*			
			1.062	26.97	132.69	197.43			*	*			
			1.125	28.58	139.81	208.08		140	*	*			
1.250	31.75	153.67	228.68			*	*						
1.312	33.32	160.42	238.69		160	*	*						
14	14.000	355.6	0.219	5.56	32.26	48.33		10	*	*			
			0.250	6.35	36.75	55.11			*	*			
			0.281	7.14	41.21	61.02		20	*	*			
			0.312	7.92	45.65	67.74			*	*			
			0.344	8.74	50.22	74.42	STD	30	*	*			
			0.375	9.53	54.62	81.08			*	*			
			0.406	10.31	59.00	87.71		10	*	*			
16	16.000	406.4	0.250	6.35	42.09	63.13			*	*			
			0.281	7.14	47.22	69.91		20	*	*			
			0.312	7.92	52.32	77.63			*	*			
			0.344	8.74	57.57	85.32	STD	30	*	*			
			0.375	9.53	62.64	92.98			*	*			
			0.406	10.31	67.60	100.60		10	*	*			
20	20.000	508.0	0.438	11.10	72.70	108.20			*	*			
			0.250	6.35	52.78	79.16			*	*			
			0.281	7.14	59.23	87.70			*	*			
			0.312	7.92	65.66	97.43			*	*			
			0.344	8.74	72.28	107.12	STD	20	*	*			
			0.375	9.53	78.67	116.78			*	*			
0.406	10.31	85.04	126.41			*	*						
0.438	11.10	91.39	136.01			*	*						

GOST 8731-74/GOST 8732-78 HOT ROLLED SEAMLESS STEEL PIPES

Application: for constructing pipelines, producing car elements and mechanisms, structure details, columns, long-well beams, fundamental piles, anti-landslip bearings, in road building, etc.

Dimensions

Outside diameter, mm	Wall thickness, mm																												
	2.6	2.8	3.0	3.2	3.5	4.0	4.5	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0	9.5	10.0	11.0	12.0	13.0	14.0	15.0	16.0	17.0	18.0	19.0		
32.0																													
33.7																													
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203.0																													
219.0																													
245.0																													
273.0																													
299.0																													
325.0																													
351.0																													
356.0																													
377.0																													
406.0																													
426.0																													

Dimensions

Outside diameter, mm	Wall thickness, mm																								Steel grades
	20.0	22.0	24.0	25.0	26.0	28.0	30.0	32.0	34.0	35.0	36.0	38.0	40.0	42.0	45.0	48.0	50.0	56.0	60.0	63.0	70.0	75.0			
32.0																									
33.7																									
38.0																									
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73.0																									
76.0																									
83.0																									
89.0	■	■																							
95.0	■	■	■																						
102.0	■	■	■	■																					
108.0	■	■	■	■	■	■																			
114.0	■	■	■	■	■	■	■																		
121.0	■	■	■	■	■	■	■	■																	
127.0	■	■	■	■	■	■	■	■	■																
133.0	■	■	■	■	■	■	■	■	■	■															
140.0	■	■	■	■	■	■	■	■	■	■	■														
146.0	■	■	■	■	■	■	■	■	■	■	■	■													
152.0	■	■	■	■	■	■	■	■	■	■	■	■	■												
159.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■											
168.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■										
178.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■									
180.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■								
194.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■								
203.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■							
219.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■						
245.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■					
273.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■				
299.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■			
325.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■		
351.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	
356.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
377.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
406.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
426.0	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■

■ – Production upon agreement with the mill

WELDED PIPES

ASTM A 53/A 53 M

Application: for producing structures, as well as for steam, water, gas and air pipelines, and also in general machine-building and tool-making.

Steel grade — A, B.

Pipe dimensions and weight according to ANSI/ASME B 36.10 M

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
1/2	0.840	21.3	0.109	2.77	0.85	1.27		
3/4	1.050	26.7	0.113	2.87	1.13	1.69		
1	1.315	33.4	0.133	3.38	1.68	2.50	STD	40
1 ¼	1.660	42.2	0.140	3.56	2.27	3.39	STD	40
1 ½	1.900	48.3	0.125	3.18	2.37	3.54		30
			0.145	3.68	2.72	4.05	STD	40
2	2.375	60.3	0.141	3.58	3.36	5.01		
			0.156	3.91	3.66	5.44	STD	40
3	3.500	88.9	0.125	3.18	4.51	6.72		
3 ½	4.000	101.6	0.125	3.18	5.18	7.72		
4	4.500	114.3	0.125	3.18	5.85	8.71		
			0.156	3.96	7.24	10.78		
8	8.625	219.1	0.203	5.15	18.26	27.22		
			0.219	5.56	19.66	29.28		
			0.250	6.35	22.38	33.32		20
			0.277	7.04	24.70	36.81		30
			0.312	7.92	27.70	41.24		
			0.322	8.18	28.55	42.55	STD	40
			0.344	8.74	30.42	45.34		
			0.375	9.53	33.04	49.25		
10	10.750	273.0	0.203	5.16	22.87	34.09		
			0.219	5.56	24.63	36.68		
			0.250	6.35	28.04	41.77		20
			0.279	7.09	31.20	46.51		30
			0.307	7.8	34.24	51.03		
			0.344	8.74	38.23	56.98		
			0.365	9.27	40.52	60.29	STD	40
			0.406	10.31	45.34	66.61		
12	12.750	323.8	0.219	5.56	29.31	43.65		
			0.250	6.35	33.38	49.73		20
			0.281	7.14	37.42	55.77		
			0.312	7.92	41.45	61.71		
			0.330	8.38	43.77	65.2		30
			0.344	8.74	45.58	67.93		
			0.375	9.53	49.56	73.88	STD	40
			0.406	10.31	53.52	79.73		
14	14.000	355.6	0.219	5.56	32.23	47.99		
			0.250	6.35	36.71	54.69		10
			0.281	7.14	41.17	61.35		
			0.312	7.92	45.61	67.9		20
			0.344	8.74	50.17	74.76		
			0.375	9.53	54.57	81.33	STD	30
			0.406	10.31	59.00	87.79		
16	16	406.4	0.219	5.6	39.95	54.96		
			0.250	6.35	42.05	62.64		10
			0.281	7.14	47.17	70.3		
			0.312	7.92	52.27	77.83		20

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
16	16	406.4	0.344	8.74	57.52	85.71	STD	30
			0.375	9.53	62.64	93.27		
			0.406	10.31	67.68	100.71		
20	20	508	0.250	6.35	52.78	78.55	STD	20
			0.281	7.14	59.23	88.19		
			0.312	7.92	65.66	97.67		
			0.344	8.74	72.28	107.6		
			0.375	9.52	78.87	117.02		
			0.406	10.31	84.04	126.53		

DIN EN 10255 UNALLOYED STEEL TUBES SUITABLE FOR WELDING AND THREADING

Application: for transportation fluids and general purpose

Nominal size, mm	H (heavy-weight)				M (medium-weight)		Type L1				Type L2				Steel grades
	Outside diameter, mm		Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	Outside diameter, mm		Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	Outside diameter, mm		Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	
	max.	min.					max.	min.			max.	min.			
21.3	-	-	-	-	2.6	1.21	21.7	21	2.3	1.08	21.4	21.0	2.0	0.947	S195T
26.9	21.8	21.0	3.2	1.44	2.6	1.56	27.1	26.4	2.3	1.4	26.9	26.4	2.3	1.38	
33.7	-	-	-	-	3.2	2.41	34.0	33.2	2.9	2.2	33.8	33.2	2.6	1.98	
42.4	42.9	42.0	4.0	3.79	3.2	3.1	42.7	41.9	2.9	2.82	42.5	41.9	2.6	2.54	
48.3	48.8	47.9	4.0	4.37	3.2	3.56	48.6	47.8	2.9	3.25	48.4	47.8	2.9	3.23	
60.3	-	-	-	-	3.6	5.03	60.7	59.6	3.2	4.51	60.2	59.6	2.9	4.08	
76.1	-	-	-	-	3.6	6.42	76	75.2	3.2	5.75	76.0	75.2	3.2	5.71	
88.9	-	-	-	-	4.0	8.36	88.7	87.9	3.6	7.55	88.7	87.9	3.2	6.72	
114.3	-	-	-	-	4.5	12.2	114.9	113.0	4.0	10.8	113.9	113	4.0	3.6	

EN 10225 STEEL WELDED TUBES FOR STATION-KEEPING OFFSHORE FACILITIES CONSTRUCTION

Tube dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm									Steel grades
	4.50	5.0	5.6	6.3	7.1	8.0	8.8	10.0	11.0	
219.1	23.82	26.4	29.5	33.1	37.1	41.6	45.64	51.57		S355G1+N S355G13+N Group 1.2
273.0		33.0	36.9	41.4	46.6	52.3	57.3	64.86		
323.9			44.0	49.3	55.5	62.3	68.4	77.4		
355.6			48.3	54.3	61.0	68.6	75.3	85.2		
406.4				62.2	69.9	78.6	86.3	97.8		
508.0				77.9	87.7	98.6	108.0	123.0	134.8	

EN 10217-1 UNALLOYED STEEL TUBES WITH SPECIFIED ROOM TEMPERATURE PROPERTIES

Application: for using under pressing load
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm																	Steel grades		
	1.5	1.8	2.0	2.3	2.6	2.9	3.2	3.6	4.0	4.5	5.0	5.6	6.3	7.1	8.0	8.8	10.0		11.0	
17.2	0.58	0.68	0.75	0.85																
21.3	0.73	0.87	0.95	1.08	1.20	1.32														
26.9		1.11	1.23	1.40	1.56	1.72	1.87													
32.0		1.34	1.48	1.69	1.89	2.08	2.27	2.52	2.76											
33.7		1.42	1.56	1.78	1.99	2.20	2.41	2.67	2.93											
42.4		1.80	1.99	2.28	2.55	2.83	3.09	3.45	3.79											
48.3		2.06	2.28	2.61	2.93	3.25	3.56	3.97	4.37											
51.0		2.18	2.42	2.76	3.10	3.44	3.77	4.21	4.64											
57.0		2.45	2.71	3.10	3.49	3.87	4.25	4.74	5.23											
60.3			2.88	3.30	3.70	4.11	4.51	5.03	5.55											
76.1			3.66	4.19	4.71	5.24	5.75	6.44	7.11	7,95										
88.9			4.29	4.91	5.53	6.15	6.76	7.57	8.38	9,37										
101.6			4.91	5.63	6.35	7.06	7.77	8.70	9.63	10,78										
108.0			5.23	6.00	6.76	7.52	8.27	9.27	10.30	11,49										
114.3			5.54	6.35	7.16	7.97	8.77	9.80	10.90	12.20										
219.1										23.80	26.40	29.50	33.10	37.10	41.60	45.64	51.57			
273.0											33.00	36.90	41.40	46.60	52.30	57.30	64.86			
323.9												44.00	49.30	55.50	62.30	68.40	77.40			
355.6												48.30	54.30	61.00	68.60	75.30	85.20			
406.4												55	62.20	69.90	78.60	86.30	97.80			
508.0												35	77.00	87.70	98.60	108.00	123.00	134.82		

— Production upon agreement with the mill

P195TR1/TR2 -
P265TR1/TR2

EN 10217-2/EN 10217-3 UNALLOYED STEEL TUBES WITH SPECIFIED ROOM TEMPERATURE PROPERTIES

Application: for using under pressing load
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm									Steel grades	
	4.5	5.0	5.6	6.3	7.1	8.0	8.8	10.0	11.0	EN 10217-2	EN 10217-3
219.1	23.80	26.4	29.5	33.1	37.1	41.6					
273.0		33.0	36.9	41.4	46.6	52.3	57.3	64.86			
323.9			44.0	49.3	55.5	62.3	68.4	77.4			
355.6			48.3	54.3	61.0	68.6	75.3	85.2			
406.4			35.3	62.2	69.9	78.6	86.3	97.8			
508.0				77.9	87.7	98.6	108.0	123.0	134.8		

— Production upon agreement with the mill

P195GH,
P235GH,
P265GH

P355N



EN 10219-1, 2 WELDED STRUCTURAL ROUND PIPES FOR METAL STRUCTURES

Application: on-ground and underground construction, bridge and crane building
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm														Steel grades	
	2	2.5	3	4	4.5	5	5.6	6	6.3	7.1	8	9.5	10	11		
21.3	0.95	1.08														S235JRH
26.9	1.23	1.40	1.56													
33.7	1.56	1.78	1.99													
42.4	1.99	2.28	2.55	2.83												
48.3	2.28	2.61	2.93	3.25												
60.3	2.88	3.56	3.70	4.11												
76.1	3.66	4.19	4.71	5.24												
88.9	4.29	4.91	5.53	6.15												
101.6			6.35	7.06												
114.3			7.16	7.97												
219.1					23.80	26.40	29.50	31.53	33.10	37.10	41.60					S235JRH - S355J2H
273						33.00	36.90	39.51	41.40	46.60	52.30	61.73	64.86			
323.9							44.00	47.04	49.30	55.50	62.30	73.66	77.41			
355.6							48.30	51.73	54.30	61.00	68.60	81.09	85.23			
406.4								59.25	62.20	69.90	78.60	92.99	97.76	107.30		
508									77.90	87.70	98.60	116.79	122.81	134.82		

— Production upon agreement with the mill

EN 10224 UNALLOYED STEEL PIPES AND FITINGS FOR PIPELINES

Application: for water transportation (including drinking water)
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm																Steel grades
	2.0	2.3	2.6	2.9	3.2	3.6	4.0	4.5	5.0	5.6	6.3	7.1	8.0	8.8	10.0	11.0	
21.3	0.95	1.08	1.20														L235
26.9	1.23	1.40	1.56	1.72	1.87												
33.7	1.56	1.78	1.99	2.20	2.41												
42.4	1.99	2.27	2.55	2.82	3.09	3.09	3.79										
48.3	2.28	2.61	2.93	3.25	3.56	3.56	4.37										
60.3	2.88	3.29	3.76	4.11	4.51	4.51	5.55										
76.1	3.66	4.19	4.71	5.24	5.75	5.75	7.11	7.95									
88.9	4.29	4.91	5.53	6.15	6.76	6.76	8.38	9.37									
101.6					7.77	7.77	9.63	10.78									
114.3					8.77	8.77	10.88	12.19									
219.1								23.80	26.40	29.50	33.10	37.10	41.60	45.64	51.56		L235 L275 L355
273									33.00	36.90	41.40	46.60	52.30	57.36	64.86		
323.9										44.00	49.30	55.50	62.30	68.38	77.41		
355.6										48.30	54.30	61.00	68.60	75.26	85.23		
406.4											62.20	69.90	78.60	86.29	97.76		
508											77.90	87.70	98.60	108.34	122.81	134.82	

— Production upon agreement with the mill

GOST 10705-80

ERW LONGITUDINALLY WELDED STEEL TUBES

Application: for pipelines and different purpose structure
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm																				Steel grades					
	1.5	2.0	2.2	2.5	2.8	3.0	3.2	3.5	3.8	4.0	4.5	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0		9.5	10.0	11.0		
21.3		0.95																							08кп, 08пс, Ст1кп, Ст1пс, Ст2сп, Ст2пс, Ст3сп, Ст3пс, 10, 10пс, 20, 20пс	
27		1.23	1.35	1.51																						
32		1.48	1.62	1.82	2.02	2.15																				
33		1.53	1.67	1.88	2.09	2.22																				
40	1.42	1.87	2.05	2.31	2.57	2.74																				
42		1.97	2.16	2.44	2.71	2.89																				
45		2.12	2.32	2.62	2.91	3.11																				
48		2.27	2.48	2.81	3.12	3.33	3.54	3.84																		
51	1.83	2.42	2.65	2.99	3.33	3.55	3.77	4.10																		
57		2.71	2.97	3.36	3.74	4.00	4.25	4.62																		
60				3.55	3.95	4.22	4.48	4.88	5.27																	
76				4.53	5.05	5.40	5.75	6.26	6.26	7.10																
89						6.36	6.77	7.38	7.98	8.38																
102						7.32	7.80	8.50	9.20	9.67	10.82															
108						7.77	8.27	9.02	9.76	10.26	11.49															
114						8.21	8.74	9.54	10.33	10.85	12.15															
152											16.37	18.13	19.87	21.60	23.32	25.03										
159											17.14	18.99	20.82	22.64	24.44	26.24										
219											23.8	26.39	28.96	31.52	34.06	36.60	39.12	41.63								
273											33.05	36.28	39.51	42.72	45.92	49.11	52.28	55.44	58.60							
325												43.34	47.20	51.06	54.90	58.73	62.54	66.35	70.14	73.92	77.68					
355.6												47.49	51.73	55.95	60.18	64.38	68.58	72.75	76.93	81.08	85.23					
406.4													59.25	64.10	68.95	73.77	78.60	83.40	88.20	92.98	97.76	107.3				
426													62.15	67.25	72.33	77.41	82.47	87.52	92.55	97.58	102.59	112.58				
530																	90.29	96.64	102.99	109.32	115.64	121.94	128.24	140.79		

GOST 20295-85

STEEL WELDED TUBES FOR GAS AND OIL MAIN PIPELINES

Application: for construction of gas and oil main pipelines, oil-products pipelines, process and field pipelines
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm														Steel grades											
	4.5	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0	9.5	10.0	11.0	12.0		13.0	14.0	14.9								
152	16.4	18.1	19.9	21.6	23.3	25.0																			K34 (10, 10пс) K38 (Ст3сп, Ст3пс) K42 (20, 20пс) K50, K52, K55, K60 (17Г1С-У, 09Г2С, 09Г2Ф, 13ХФА, 13Г1С-У, 10Г2ФБЮ)	
159	17.14	18.99	20.82	22.64	24.44	26.24																				
219	23.8	26.39	28.96	31.52	34.06	36.60	39.12	41.63																		
273		33.05	36.28	39.51	42.72	45.92	49.11	52.28	55.44	58.60																
325			43.34	47.20	51.06	54.90	58.73	62.54	66.35	70.14	73.92	77.68														
426				62.15	67.25	72.33	77.41	82.47	87.52	92.55	97.58	102.59	112.58													
530						90.29	96.64	102.99	109.32	115.64	121.94	128.24	140.79													

SQUARE AND RECTANGULAR PIPES (HOLLOW SECTIONS)

EN 10219-1, 2 WELDED STRUCTURAL HOLLOW SECTIONS

Application: on-ground and underground construction, bridge and crane building
Pipe dimensions and weight

Dimensions, mm		Weight per length unit, kg/m, wall thickness, mm										Steel grades
A	B	1.5	1.8	2.0	2.2	2.5	2.8	3.0	3.2	3.5	4.0	
17	17		0.82	0.89	0.96	1.05						
20	20	0.84	0.98	1.08	1.16	1.29						
25	25	1.08	1.27	1.39	1.51	1.68		1.95				
25	28		1.35	1.49	1.61	1.80		2.09				
30	20	1.08	1.27	1.39	1.51	1.68		1.95				
30	25			1.55	1.68	1.88		2.19				
30	30	1.31	1.55	1.70	1.85	2.07		2.42				
35	20			1.55	1.68	1.88	2.07	2.19				
35	30			1.86	2.03	2.27	2.50	2.66				
35	35		1.83	2.02	2.20	2.46	2.72	2.89				
40	20	1.31	1.55	1.70	1.85	2.07	2.29	2.42				
40	25	1.43	1.69	1.86	2.03	2.27	2.50	2.66				
40	28		1.78	1.95	2.13	2.39	2.64	2.80				
40	30		1.83	2.02	2.20	2.47	2.72	2.89				
40	40	1.78	2.12	2.33	2.55	2.85	3.16	3.36	3.56	3.85	4.31	
45	20			1.86	2.03	2.27	2.50	2.66				
45	45		2.40	2.65	2.89	3.25	3.60	3.83	4.06	4.39	4.93	
50	25	1.67	1.97	2.17	2.37	2.66	2.94	3.13	3.31	3.57	3.99	
50	28		2.06	2.27	2.48	2.78	3.08	3.27	3.46	3.74	4.18	
50	30		2.12	2.32	2.55	2.86	3.16	3.36	3.56	3.85	4.31	
50	40		2.40	2.65	2.89	3.25	3.60	3.83	4.06	4.39	4.93	
50	45		2.54	2.80	3.06	3.45	3.82	4.07	4.31	4.67	5.25	
50	50		2.68	2.96	3.24	3.64	4.04	4.31	4.56	4.94	5.56	
60	28		2.34	2.58	2.82	3.17	3.52	3.74				
60	30		2.40	2.65	2.89	3.25	3.60	3.83	4.06	4.39	4.93	
60	35			2.80	3.06	3.45	3.82	4.07	4.31	4.67	5.25	
60	40			2.96	3.24	3.64	4.04	4.30	4.56	4.94	5.56	
60	60			3.59	3.93	4.43	4.92	5.25	5.57	6.04	6.82	
70	50			3.59	3.93	4.43	4.92	5.25	5.57	6.04	6.82	
70	70			4.22	4.62	5.21	5.80	6.19	6.57	7.14	8.07	
80	40			3.59	3.93	4.43	4.92	5.25	5.57	6.04	6.82	
80	60			4.22	4.62	5.21	5.80	6.19	6.57	7.14	8.07	
80	80			4.84	5.31	6.00	6.68	7.13	7.58	8.24	9.33	
90	50			4.22	4.62	5.21	5.80	6.19	6.57	7.14	8.07	
90	90			5.47	6.00	6.78	7.56	8.07	8.58	9.43	10.59	
100	40			4.22	4.62	5.21	5.80	6.19	6.57	7.14	8.07	
100	50			4.53	4.96	5.61	6.24	6.66	7.08	7.69	8.70	
100	60			4.84	5.31	6.00	6.68	7.13	7.58	8.24	9.33	
100	80			5.47	6.00	6.78	7.56	8.18	8.71	9.50	10.81	

S235JRH-
S275J0H

POLYETHYLENE COATED PIPES

DIN 30670

POLYETHYLENE COATING ON STEEL PIPES AND FITTINGS EXTERNAL

Coating execution:

N – normal execution (at temperatures of up to 50 °C);
S – special execution (at temperatures of up to 70 °C).

Coating thickness:

Pipe nominal outside diameter, mm	Coating thickness, at least, mm	
	Normal thickness (n)	Reinforced thickness (v)
From 100 to 250 inclusive	2.0	2.7
From 250 to 500 inclusive	2.2	2.9
From 500 to 530 inclusive	2.5	3.2

Pipe length: 10-13 m

Coating requirements:

Coating characteristics	Norm	
	Execution type	
	Normal	Special
Dielectric continuity, kV, no less than	Lack of electric current in 25 kV	
Impact strength of (23±2) °C, J but no less, for the tubes in diameter: - 200 mm and over - up to 200 mm	5 4.25	5 4.25
Adherence of coating to steel l/cm, no less than temperature: - (20±5) °C - (50±5) °C	35 15	35 25



EN ISO 21809

EXTERNAL THREE-LAYER POLYETHYLENE AND POLYPROPYLENE COATING

Coating thickness:

Weight of 1 meter of pipe Pm/m (kg/m)	Total coating thickness, at least, mm					
	Class B1	Class B2	Class B3	Class C1	Class C2	Class C3
Pm ≤ 15	1.3	1.8	2.3	1.3	1.7	2.1
15 < Pm ≤ 50	1.5	2.1	2.7	1.5	1.9	2.4
50 < Pm ≤ 130	1.8	2.5	3.1	1.8	2.3	2.8

Coating type:

Coating classes:

Class B – used for application at pipeline service temperatures from minus 20 °C to plus 60 °C.

Class C – used for application at pipeline service temperatures from minus 40 °C to plus 80 °C.

Acceptance testing of pipes with coating:

- external appearance of coating check;
- length measuring of bare ends;
- taper angle measuring coating to the pipe's body;
- dielectric coating integrity testing;
- thickness of coating testing;
- strength test of coating with the impact up to (23±3) °C;

Peel force control:

Class B – at temperatures of plus 23 °C and plus 60 °C;

Class C – at temperatures of plus 23 °C and plus 80 °C;

- cathodic disbondment test;
- hot water coating test.



EN 10288

EXTERNAL TWO-LAYER POLYETHYLENE COATING

Coating thickness:

Composition of the coating	Tube nominal outside diameter, mm	Coating thickness class, mm, at least		
		1	2	3
Two-layer polyethylene coating	Up to 114.3 inclusive	1.5	1.8	2.5
	From 114 to 273 inclusive	1.8	2.0	2.7
	From 273 to 508 inclusive	2.0	2.2	2.9
	From 508 to 762 inclusive	2.2	2.5	3.2

Coating type:

Type 1 – at service temperatures up to plus 60 °C;
Type 2 – at service temperatures up to plus 30 °C;

Acceptance testing of pipes with coating:

- external appearance of coating check;
- length measuring of bare ends;
- taper angle measuring coating to the pipe's body;
- dielectric coating integrity testing;
- thickness of coating testing;
- strength test of coating with the impact up to (20 ± 5) °C;
- peel force control at temperatures of plus (23 ± 2) °C and plus (60 ± 2) °C.



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