INTERPIPE

EXPERT PIPE SOLUTIONS FOR INDUSTRIAL APPLICATION

SEAMLESS PIPES, WELDED PIPES AND HOLLOW SECTIONS

CONTENT

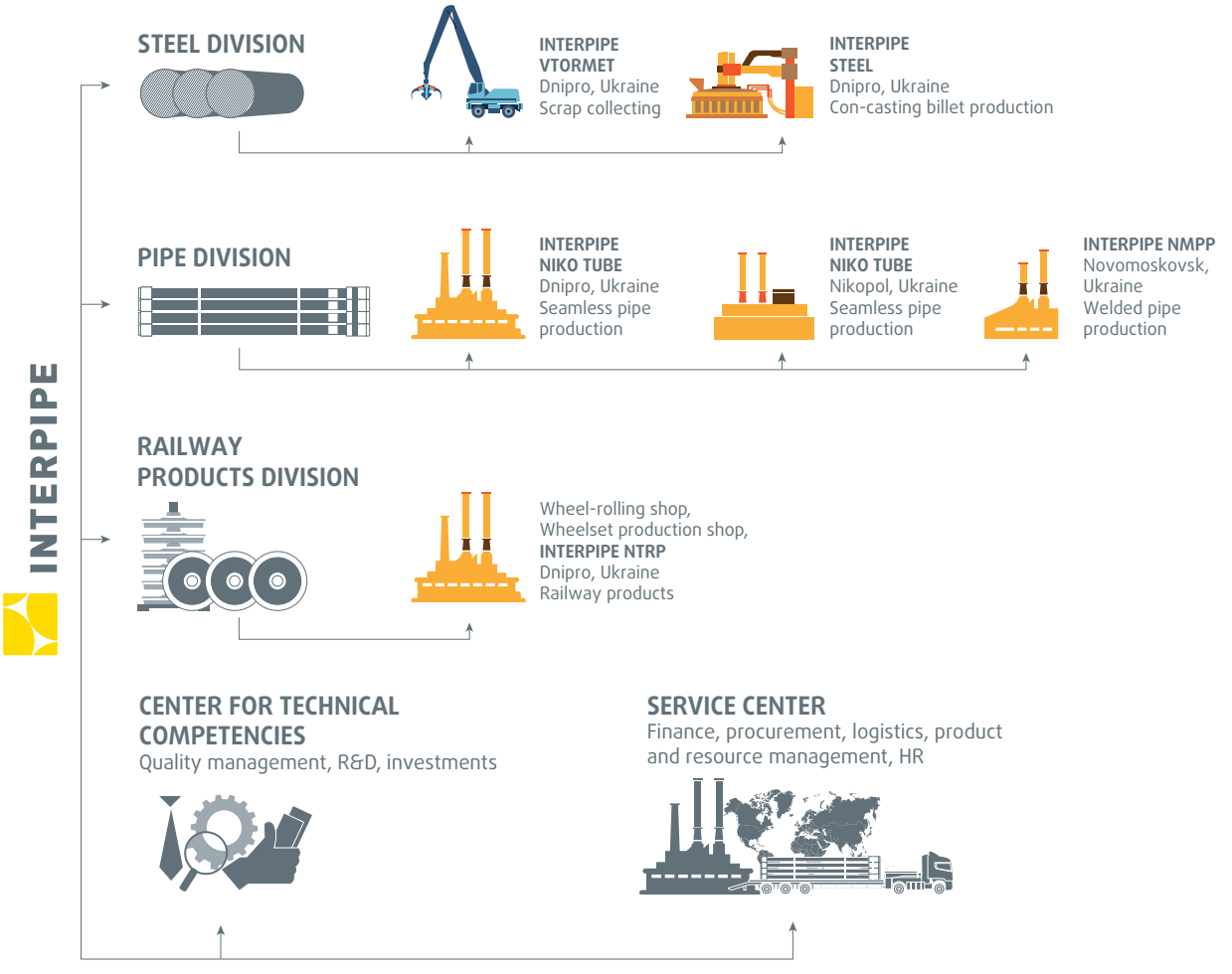
INTERPIPE AT A GLANCE

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, 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

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, Loyd 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 dismeter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
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
			0,177	4,50	2,16	3,21		
			0.179	4.55	2.17	3.23	XS	80
			0,221	5,60	2,58	3,84		
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
			0.191	4.85	3.00	4.47	XS	80
			0,197	5,00	3,08	4,59		
			0,221	5,60	3,40	5,05		
			0,248	6,30	3,75	5,58		
1½	1.900	48.3	0.109	2.77	2.09	3.11		10
			0.125	3.18	2.37	3.53		30
			0.145	3.68	2.72	4.05	STD	40
			0.200	5.08	3.63	5.41	XS	80
			0,221	5,60	3,96	5,90		
			0,248	6,30	4,38	6,53		
			0,280	7,10	4,84	7,21		
			0,315	8,00	5,34	7,95		
			0,394	10,00	6,35	9,45		
2	2.375	60.3	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		
			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		
			0,280	7,10	6,26	9,32		
			0,315	8,00	6,93	10,32		
			0,394	10,00	8,33	12,40		
			0,433	11,00	8,98	13,37		
			0,472	12,00	9,60	14,29		
			0,559	14,20	10,85	16,14		
2½	2.875	73.0	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		
			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
			0,315	8,00	8,61	12,82		
			0.375	9.52	10.02	14.9		160
			0,394	10,00	10,44	15,54		
			0,433	11,00	11,3	16,82		
			0,472	12,00	12,13	18,05		
			0,559	14,20	13,84	20,59		
			0,591	15,00	14,42	21,46		
			0,630	16,00	15,11	22,49		

— Upon agreement
* — For ASTM A 106, ASTM A 53

Pipe dimensions and weight

Nominal size	Outside dismeter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
3	3.500	88.9	0.141	3.58	5.06	7.53		
			0.156	3.96	5.58	8.29		
			0.172	4.37	6.11	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	
3½	4.000	101.6	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
			0,438	11,13	16,68	24,83		
			0,531	13,49	19,70	29,31		
			0,674	17,12	23,97	35,67		
			0,750	19,05	26,06	38,78		
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
			0.674	17.19	27.59	41.03	XXS	
			0,750	19,05	30,07	44,75		
5	5.563	141.3	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
			0.750	19.05	38.59	57.43	XXS	
6	6.625	168.3	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
			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		

— Upon agreement

Pipe dimensions and weight

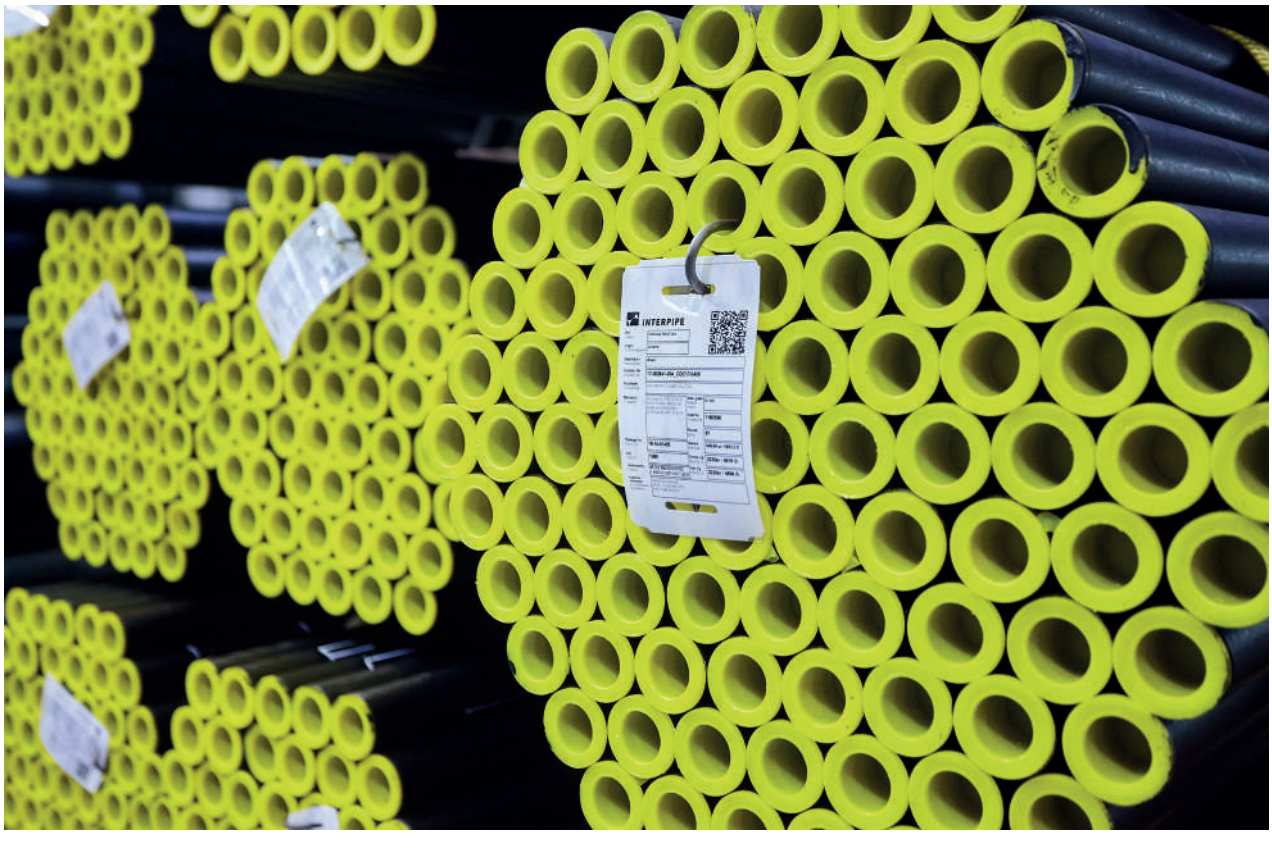
Nominal size	Outside dismeter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
8	8.625	219.1	0.250	6.35	22.38	33.31		20
			0.277	7.04	24.72	36.31		30
			0.312	7.92	27.73	41.24		
			0.322	8.18	28.58	42.55	STD	40
			0.344	8.74	30.45	45.34		
			0.375	9.52	33.07	49.20		
			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		
			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		120
			1.000	25.40	104.23	155.09	XXS	140
			1.125	28.58	115.75	172.27		160
			1.250	31.75	126.54	188.90		
			1,312	33,32	132,58	197,3		
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		
			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	95.21	143.17		
			0.812	20.62	103.63	154.17		
			0.844	21.44	107.42	159.87		100
			0.875	22.23	111.08	165.33		
			0.983	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

— Upon agreement

Pipe dimensions and weight

Nominal size	Outside dismeter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
14	14.000	355.6	0.312	7.92	45.61	67.90		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		40
			0.469	11.91	67.84	100.95		
			0.500	12.70	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		100
			1.094	27.79	224.65	150.79		120
			1.250	31.75	253.56	170.21		140
			1.406	35.71	281.70	189.11		160
			2.000	50.80	381.83	256.32		
			2.125	53.97	401.50	269.50		
			2.200	55.88	413.01	277.25		
			2.500	63.50	457.40	307.05		
16	16	406.4	0.344	8.80	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	12.70	82.85	123.31	XS	40
			0.562	14.27	92.75	138.00		
			0.625	15.88	102.72	152.94		

— 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	■	■	■	■	■	■	■	■	■	■	■																	
40	■	■	■	■	■	■	■	■	■	■	■																	
42.2	■	■	■	■	■	■	■	■	■	■																		
42.4	■	■	■	■	■	■	■	■	■	■	■	■																
44.5	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■												
48.3	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■									
51	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■									
54		■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■									
57		■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■									
60.3		■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■					
63.5		■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■		
67		■	■	■	■	■	■	■	■	■	■																	
70		■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■		
73		■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■		
76.1		■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■		
82.5			■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
88.9			■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
95				■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
101.6				■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
108				■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
114.3				■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
121					■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
127					■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
133					■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
139.7					■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
141.3					■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
146						■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
152.4						■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
159						■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
165.1						■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
168.3						■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
171									■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
177.8									■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
191										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
193.7									■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
203										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
206																										■	■	■
210																										■	■	■
216										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
219.1									■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
229										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
241										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
244.5										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
254										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
257										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
267										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
273										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
279										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
292										■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
298.5											■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
305											■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
318											■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
323.9											■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
330											■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
340											■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
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																												
48.3																												
51																												
54																												
57																												
60.3																												
63.5																												
67																												
70																												
73																												
76.1																												
82.5																												
88.9																												
95																												
101.6																												
108																												
114.3																												
121																												
127																												
133																												
139.7																												
141.3																										S235JRH,		
146																										S275J0H,		
152.4																										S275J2H,		
159																										S355K2H,		
165.1																										S275NH,		S355G1,
168.3																										S275NLH,	E235-	S355G14,
171																										S355NH,	E470	S355G15
177.8																										S355NLH,		
191																										S420NH,		
193.7																										S420NLH,		
203																										S460NH,		
206																										S460NLH		
210																												
216																												
219.1																												
229																												
241																												
244.5																												
254																												
257																												
267																												
273																												
279																												
292																												
298.5																												
305																												
318																												
323.9																												
330																												
340																												
343																												
355.6																												
368																												
377																												
381																												
394																												
406.4																												
419																												
426																												

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

Dimensions

D/s, mm	Wall thickness, 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
31.8																													
32.0																													
33.4																													
33.7																													
35																													
38																													
40																													
42.2																													
42.4																													
44.5																													
48.3																													
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54																													
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60.3																													
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76.1																													
82.5																													
88.9																													
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114.3																													
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139.7																													
141.3																													
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152.4																													
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165.1																													
168.3																													
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177.8																													
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394																													
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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	
31.8																										
32.0																										
33.4																										
33.7																										
35																										
38																										
40																										
42.2																										
42.4																										
44.5																										
48.3																										
51																										
54																										
57																										
60.3																										
63.5																										
67																										
70																										
73																										
76.1																										
82.5																										
88.9																										
95																										
101.6																										
108																										
114.3																										
121																										
127																										
133																										
139.7																										
141.3																										
146																										
152.4																										
159																										
165.1																										
168.3																										
171																										
177.8																										
191																										
193.7																										
203																										
206																										
210																										
216																										
219.1																										
229																										
241																										
244.5																										
254																										
257																										
267																										
273																										
279																										
292																										
298.5																										
305																										
318																										
323.9																										
330																										
340																										
343																										
355.6																										
368																										
377																										
381																										
394																										
406.4																										
419																										
426																										

P235TR1-P355N, P460N, 16Mo3, 10CrMo5-5, 13CrMo4-5

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 diametr, 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

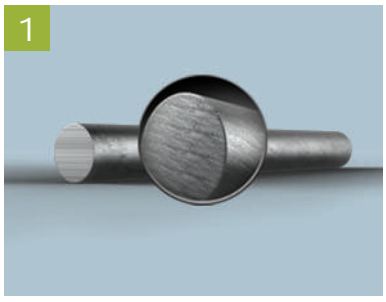
Dimensions and weight for Hot rolled – Type L and L1

Nominal size, mm	Outside diametr, 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	
33.7	34.0	33.2	2.9	2.2	2.9	2.2	S 195 T
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

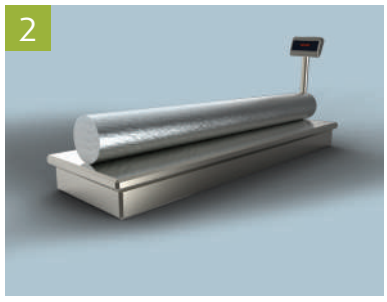
MANUFACTURING OF SEAMLESS PIPES

1



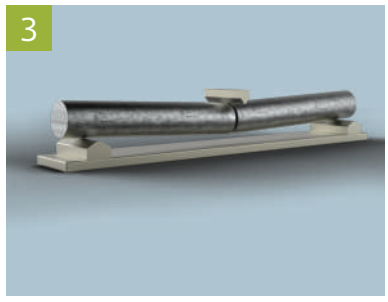
Billet incoming inspection

2



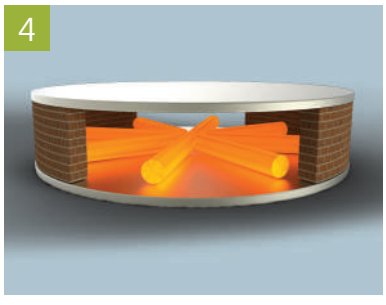
Billet weighing

3



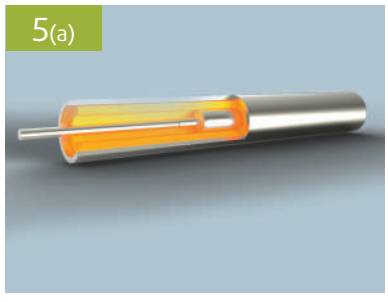
Billet cutting

4



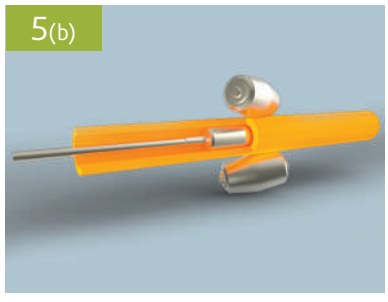
Heating of billet in rotary furnace

5(a)



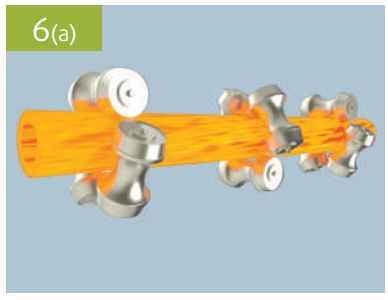
Piercing of billet at piercing press

5(b)



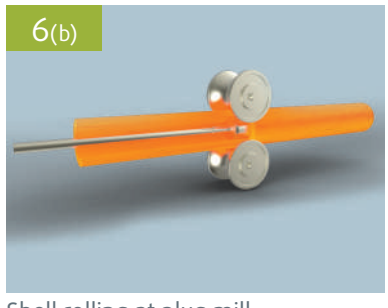
Piercing of billet at cross-roll piercer

6(a)



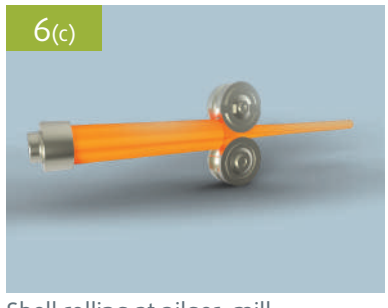
Shell rolling at continuous rolling mill

6(b)



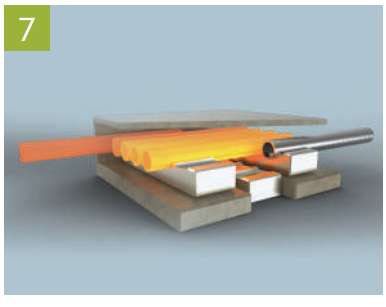
Shell rolling at plug mill

6(c)



Shell rolling at pilger mill

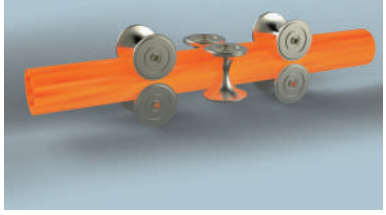
7



Heating of pipes

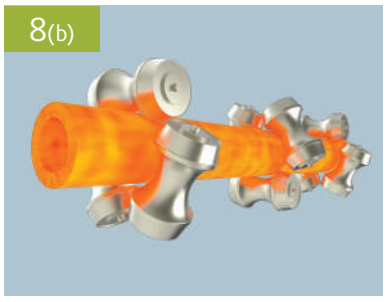
MANUFACTURING OF SEAMLESS PIPES

8(a)



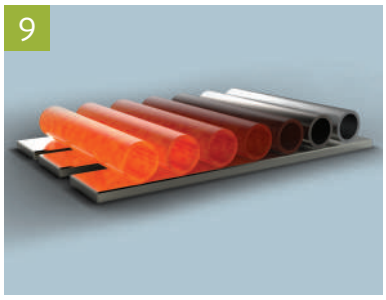
Sizing

8(b)



Stretch reducing

9

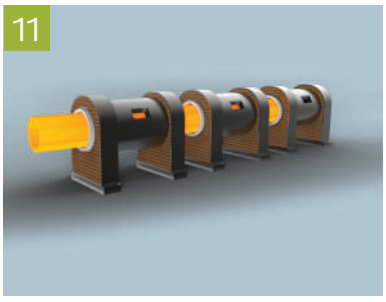


Pipes cooling

10

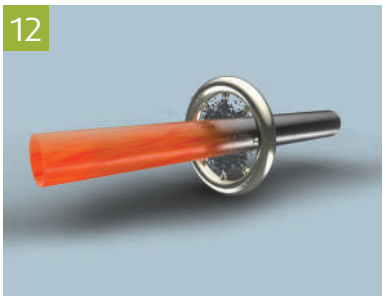
Straightening of pipes

11



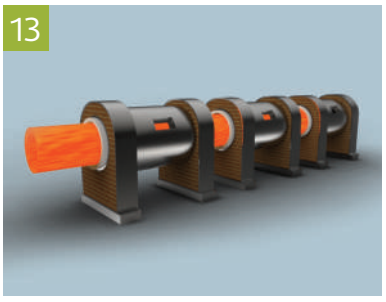
Heating of pipes for quenching

12



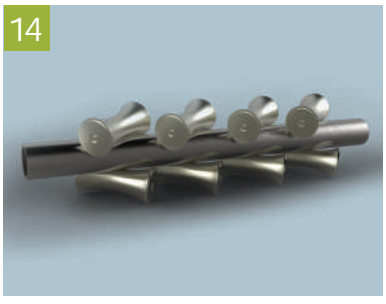
Quenching

13



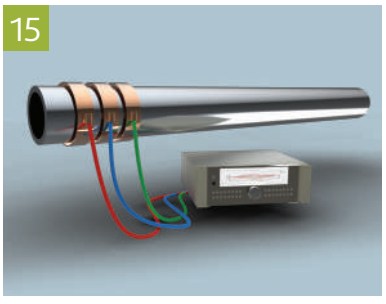
Tempering

14



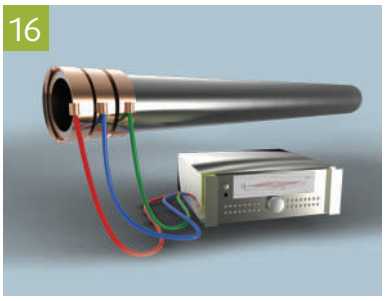
Warm straightening

15



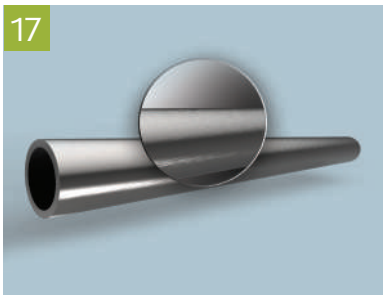
Nondestructive control of pipe body

16



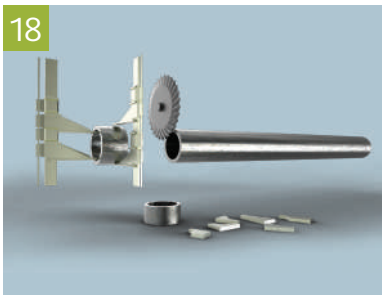
NDT of pipe ends

17



Visual inspection

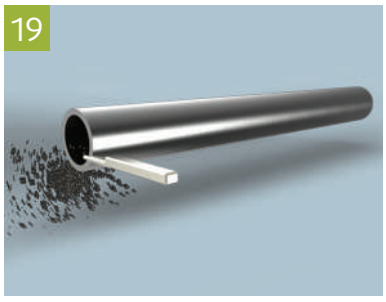
18



Sampling for mechanical tests and chemical composition analysis

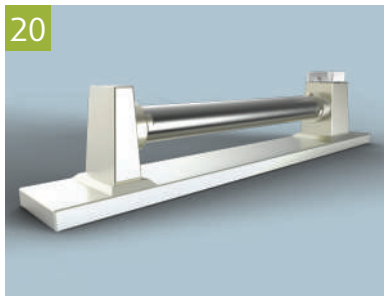
FINISHING OF PLAIN END PIPES

19



Beveling

20



Hydraulic pressure test

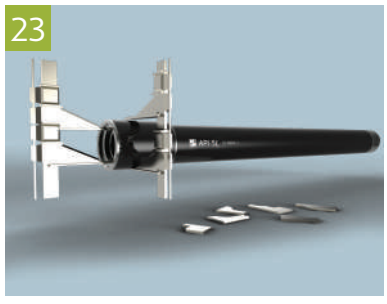
21

Painting of pipes

22

Marking

23

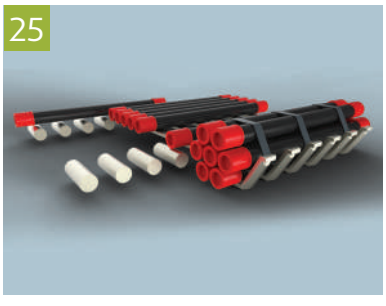


Final inspection

24

Bevel protection

25



Bundling

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
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	·	
			0.191	4.85	3.00	4.47	XS	80	·	
1½	1.900	48.3	0.109	2.77	2.09	3.11		10	·	
			0.125	3.18	2.37	3.53		30	·	
			0.145	3.68	2.72	4.05	STD	40	·	
			0.200	5.08	3.63	5.41	XS	80	·	
2	2.375	60.3	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			·	
			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			·	
2½	2.875	73.0	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			·	
			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	14.90		160	·	
3	3.500	88.9	0.141	3.58	5.06	7.53			·	
			0.156	3.96	5.58	8.30			·	
			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		·	
3 ½	4.000	101.6	0.156	3.96	6.41	9.54			·	
			0.172	4.37	7.04	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	18.64	XS	80	·	
4	4.500	114.3	0.156	3.96	7.24	10.78			·	
			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	·	·
			0,406	10,31	44,88	66,79			+	
			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		·
			0.438	11.10	72.70	108.20				·
20	20.000	508.0	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 diametr, 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																											
38. 0																											
42.0																											
42.4																											
45.0																											
48.3																											
50.0																											
51.0																											
57.0																											
60.0																											
60.3																											
63.5																											
70.0																											
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																											

Dimensions

Outside diametr, 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																							10, 20, 35, 45, 50, 09G2S (09Г2С), 10G2 (10Г2), 20H (20Х), 40H (40Х), 15HM (15ХМ), 30HMA (30ХМА), 15H (15Х), 15HA (15ХА), 35H (35Х), 20HM (20ХМ), 20G (20Г), 30G2 (30Г2), 35G2 (35Г2), 10HSND (10ХСНД), 15GS (15ГС), 10G2B (10Г2Б), 38HA (38ХА), 45H (45Х), 18HG (18ХГ), 33HS (33ХС), 30HM (30ХМ), 15HF (15ХФ), 35HM (35ХМ), 40HFA (40ХФА), 40HN (40ХН), 45HN (45ХН), 12HN2 (12ХН2), 12HN3A (12ХН3А), 20HN3A (20ХН3А), 20H2N4A (20Х2Н4А), 30HN3A (30ХН3А), 30HGSA (30ХГСА), 30HGSN2A (30ХГСН2А), 40HN2MA (40ХН2МА), 38H2N2MA (38Х2Н2МА), 18H2N4MA (18Х2Н4МА), 38H2MUA (38Х2МЮА)
33.7																							
38. 0																							
42.0																							
42.4																							
45.0																							
48.3																							
50.0																							
51.0																							
57.0																							
60.0																							
60.3																							
63.5																							
70.0																							
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.

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
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
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		
			0.307	7.8	34.24	51.03		30
			0.344	8.74	38.23	56.98		
			0.365	9.27	40.52	60.29	STD	40
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	
			0.406	10.31	53.52	79.73		40
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
16	16	406.4	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
			0.344	8.74	57.52	85.71		
			0.375	9.53	62.64	93.27	STD	30
			0,438	11,13	72,91	108,50		
20	20	508	0.250	6.35	52.78	78.55		10
			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	STD	20
			0.406	10.31	84.04	126.53		
			0,438	11,13	91,64	136,38		

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 diametr, 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 diametr, mm		Wall thickness, mm	Weight per length unit, kg/m(plain ends green pipe)	Outside diametr, mm		Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	
	max.	min.					max.	min.			max.	min.			
17,2			2		2,3				2				1,8		S195T
21.3	-	-	-	-	2.6	1.21	21.7	21	2.3	1.08	21.4	21.0	2.0	0.947	
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	3,6	3.6	

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															P195TR1/TR2 - P265TR1/TR2
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

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				P195GH, P235GH, P265GH	P355N
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

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 diametr, 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												
38	1,78	2,19	2,59												
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	7,95										
88.9	4.29	4.91	5.53	6.15	9,37										
101.6			6.35	7.06	10,78										
114.3			7.16	7.97	12,19										
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	

EN 10224
UNALLOYED STEEL PIPES AND FITINGS FOR PIPELINES

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

Outside diametr, 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				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	

GOST 10705-80
ERW LONGITUDINALLY WELDED STEEL TUBES

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

Outside diametr, 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					Ст3сп, Ст3пс, 10, 10пс, 20, 20пс
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

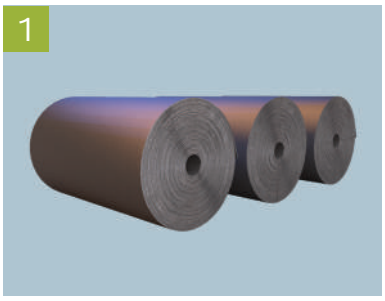
K50, K52, K55, K60 (17Г1С-У, 09Г2С, 09ГСФ, 13ХФА, 13Г1С-У, 10Г2ФБЮ)

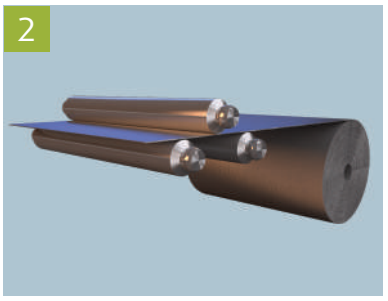
GOST 20295-85
STEEL WELDED TUBES FOR GAS AND OIL MAIN PIPELINES

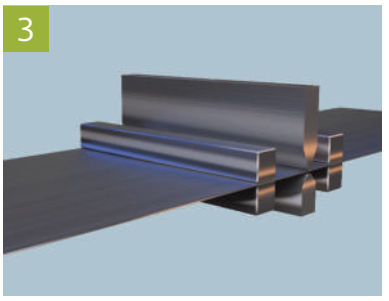
Application: for construction of gas and oil main pipelines, oil-products pipelines, process and field pipelines
Pipe dimensions and weight

Outside diametr, 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												К34 (10, 10пс) К38 (Ст3сп, Ст3пс) К42 (20, 20пс) К50, К52, К55, К60 (17Г1С-У, 09Г2С, 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					

WELDED PIPES PRODUCTION

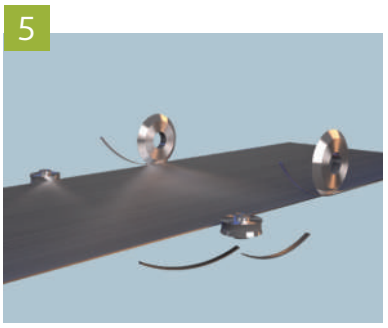
1

Coil storage

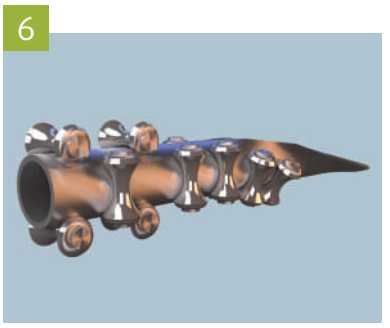
2

Uncoiling

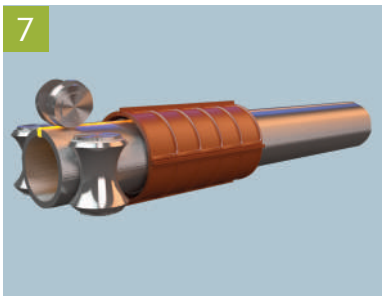
3

Coil ends cutting&welding

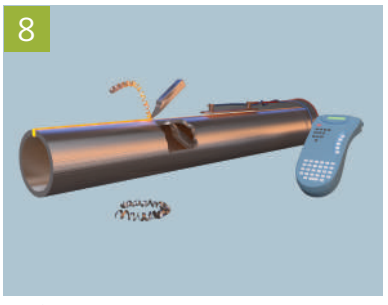
4

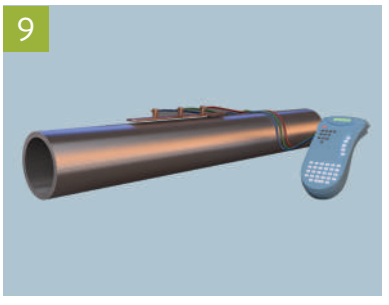
Accumulating

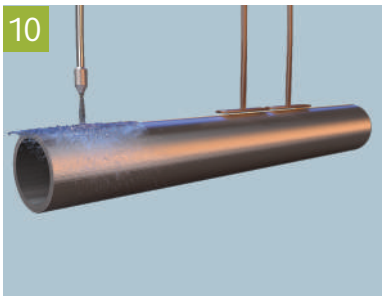
5

Edge trimming and edge milling

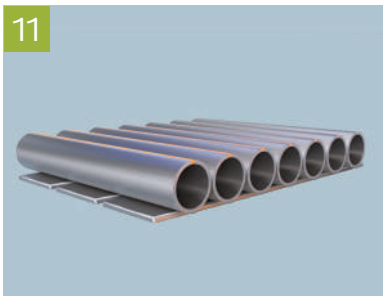
6

Forming

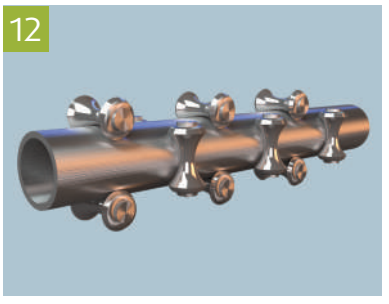
7

ERW/HFI welding

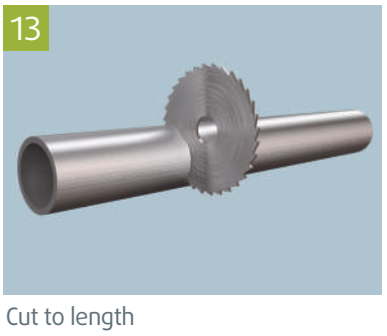
8

OD/ID scarfing

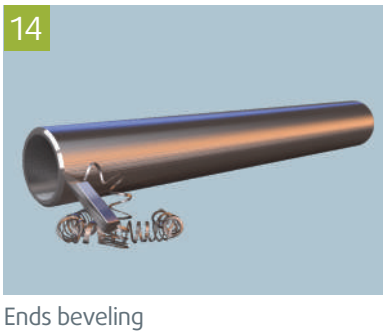
9

On line seam UST

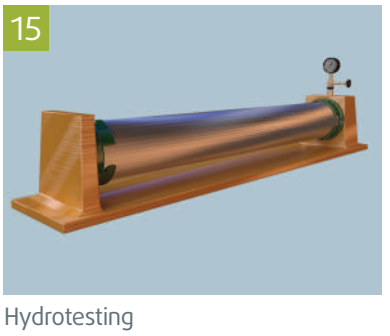
10

Seam annealing

11

Cooling

12

Sizing

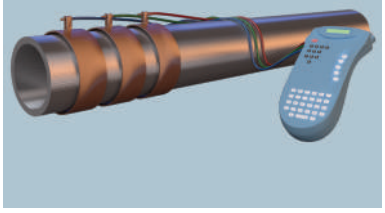
13

Cut to length

14

Ends beveling

15

Hydrotesting

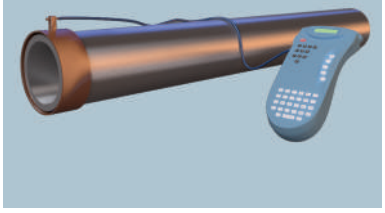
WELDED PIPES PRODUCTION

16



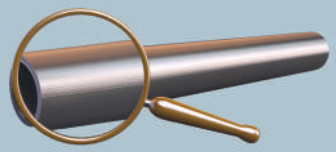
Final ultrasonic inspection

17



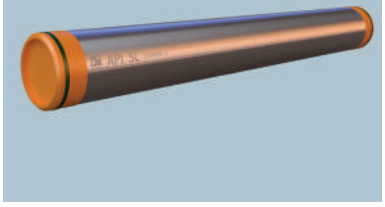
Wet MPI on pipe ends

18



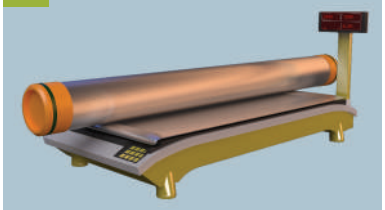
Final visual inspection

19



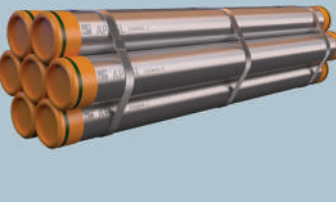
WMS bevel protect

20



Weighing

21



Pipes storing

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	4.5	
17	17		0.82	0.89	0.96	1.05							S235JRH-S275J0H
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	2,49				
40	25	1.43	1.69	1.86	2.03	2.27	2.50	2.66	2,74				
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	1,77	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	20			2,31	2,51	2,82	3,11	3,3					
60	25			2,46	2,69	3,01	3,33	3,54					
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		2,66	2.96	3.24	3.64	4.04	4.30	4.56	4.94	5.56		
60	60		3,22	3.59	3.93	4.43	4.92	5.25	5.57	6.04	6.82	7,43	
70	50			3.59	3.93	4.43	4.92	5.25	5.57	6.04	6.82	7,43	
70	70			4.22	4.62	5.21	5.80	6.19	6.57	7.14	8.07	8,85	
80	40			3.59	3.93	4.43	4.92	5.25	5.57	6.04	6.82	7,43	
80	60			4.22	4.62	5.21	5.80	6.19	6.57	7.14	8.07	8,85	
80	80		4,35	4.84	5.31	6.00	6.68	7.13	7.58	8.24	9.33	10,26	
90	50			4.22	4.62	5.21	5.80	6.19	6.57	7.14	8.07	8,85	
90	90			5.47	6.00	6.78	7.56	8.07	8.58	9.43	10.59	11,67	
100	40			4.22	4.62	5.21	5.80	6.19	6.57	7.14	8.07	8,85	
100	50			4.53	4.96	5.61	6.24	6.66	7.08	7.69	8.70	9,56	
100	60			4.84	5.31	6.00	6.68	7.13	7.58	8.24	9.33	10,26	
100	80			5.47	6.00	6.78	7.56	8.18	8.71	9.50	10.81	11,67	

POLYETHYLENE COATED PIPES

DIN 30670
POLYETHYLENE COATING ON STEEL PIPES AND FITTINGS EXTERNAL

Coating execution:

N – normal execution (at temperatures of from -20°C up to +60°C)
S – special execution (at temperatures of from -40°C up to +80°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: 10-12 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/mm	no less than 5	no less than 7
Adherence of coating to steel H/cm, no less than temperature: 23°C 50°C	 100 20	 150 30

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
130 < Pm ≤ 200	2,2	2,8	3,5	2,2	2,5	3,2

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	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 530 inclusive	2.2	2.5	3.2

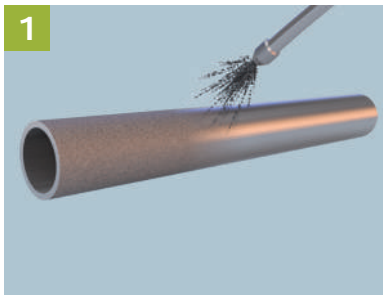
Coating type:

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

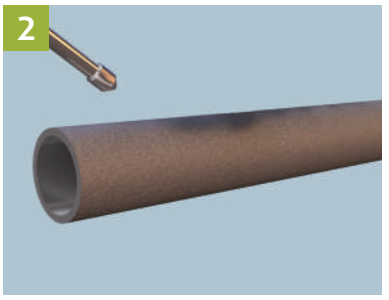
Acceptance testing of pipes with coating:

- 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.

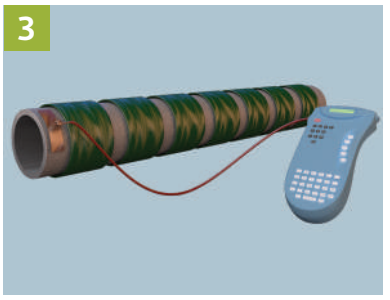
3-LAYER POLYETHYLENE/POLYPROPHYLENE COATING FUSION BONDED EPOXY COATING



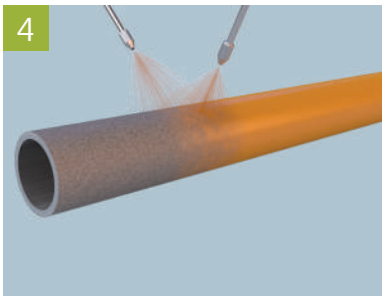
Shot blasting



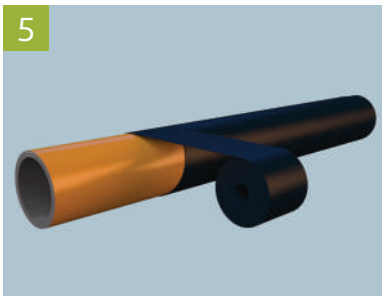
Dust removal



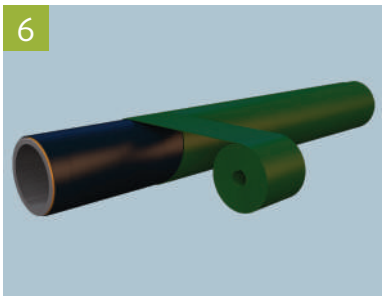
Induction heating



Epoxy powder application

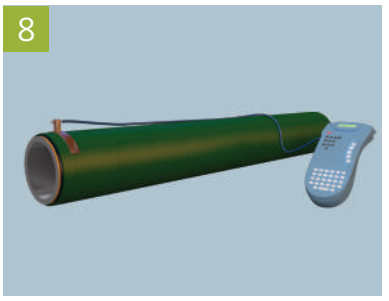


Adhesive application

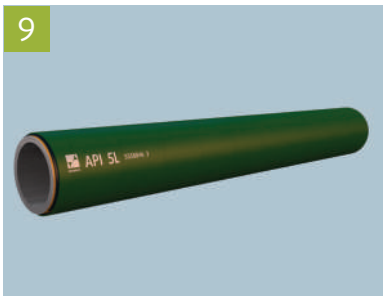


Polyethylen application

Pipe cooling

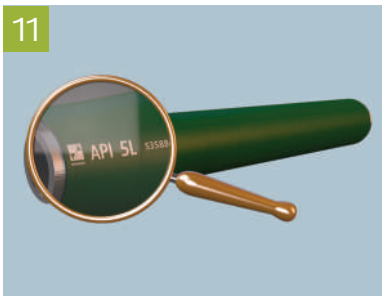


On-line holiday test

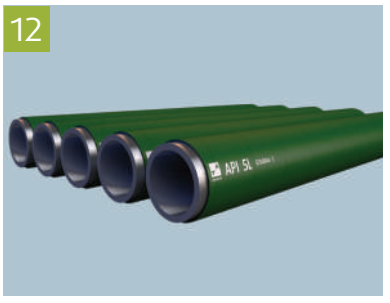


Pipe marking

Pipe ends processing



Final visual inspection
marking ends protect



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