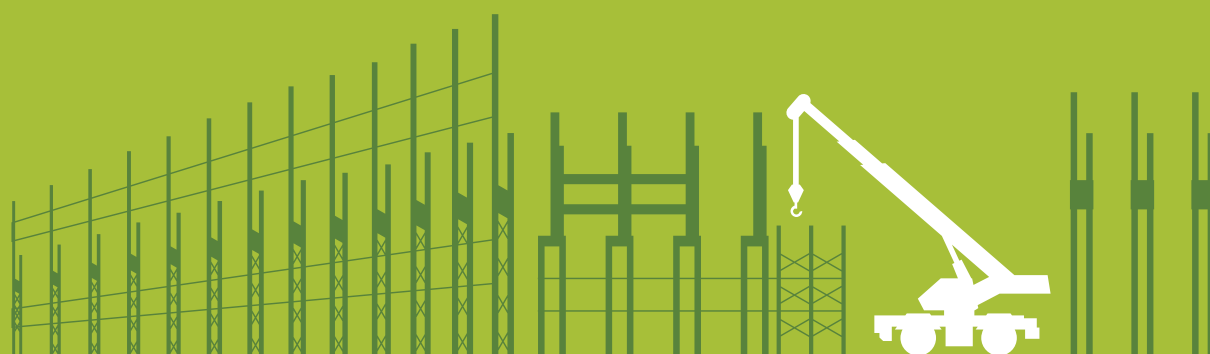




INTERPIPE

EXPERT PIPE SOLUTIONS FOR INDUSTRIAL APPLICATION

SEAMLESS PIPES,
WELDED PIPES AND HOLLOW SECTIONS



CONTENT

Interpipe at a glance

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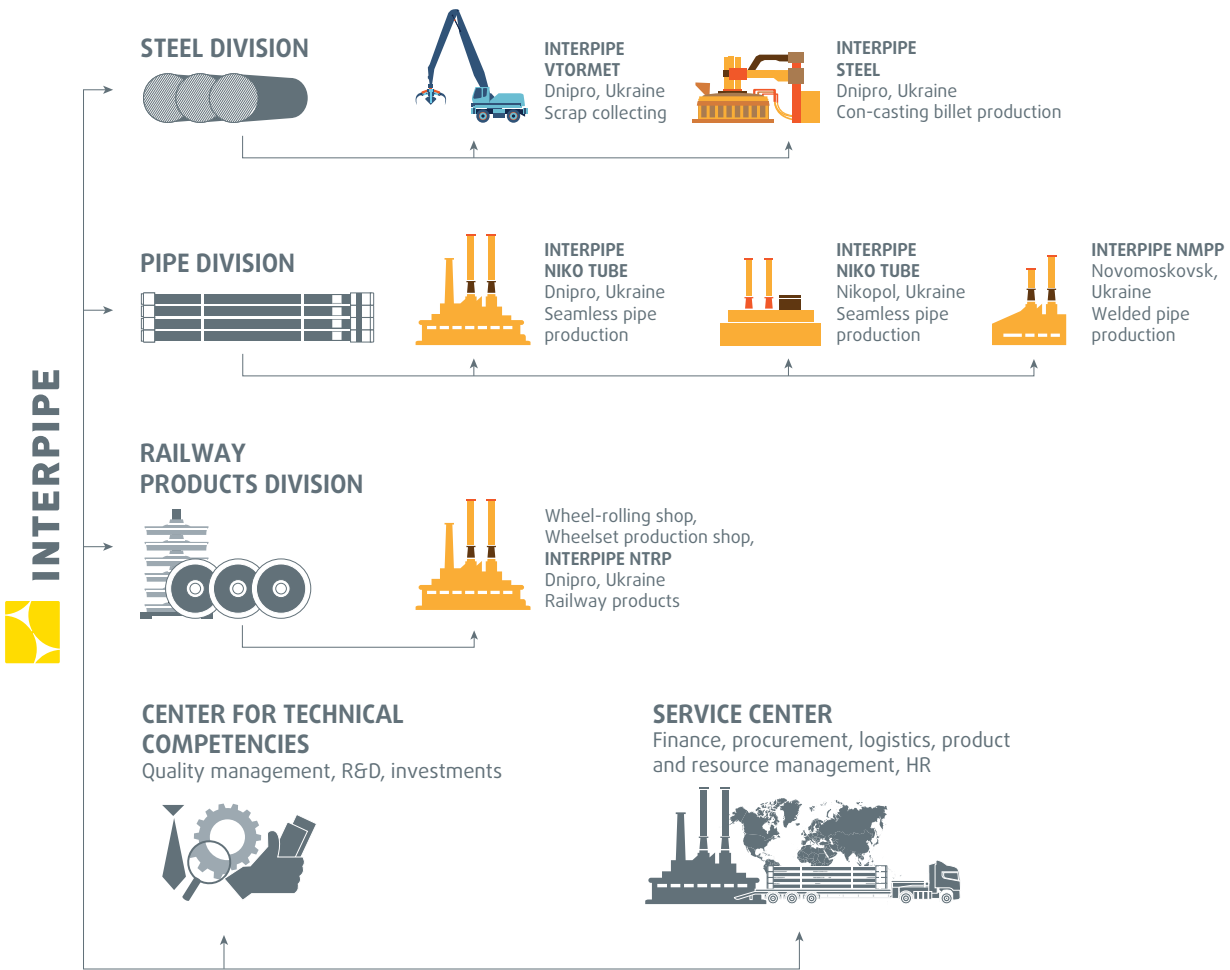
INTERPIPE AT A GLANCE

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

 North American Interpipe	 Interpipe Middle East	 Interpipe Ukraine
 Interpipe Europe SA	 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		
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		
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		
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		
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 diameter		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

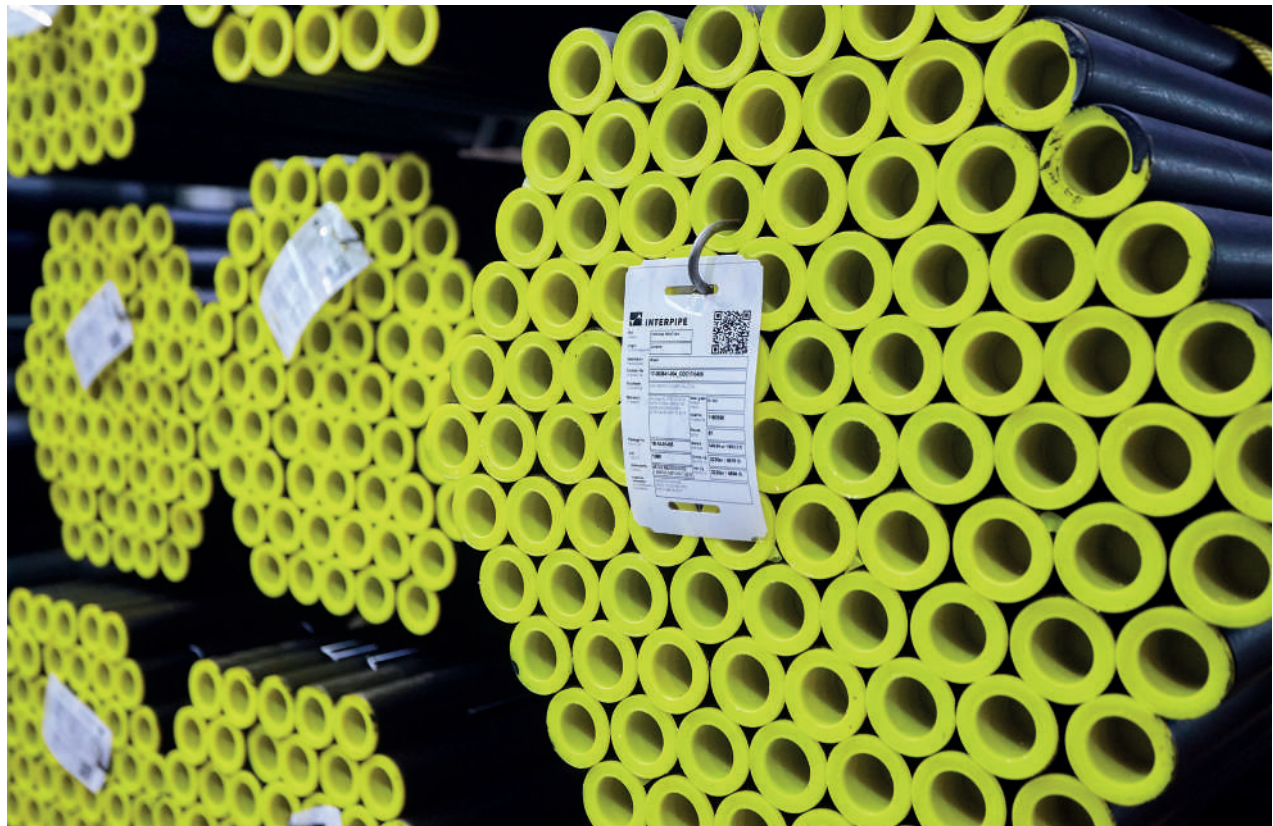
Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
8	8.625	219.1	0.250	6.35	22.38	33.31		20
			0.277	7.04	24.72	36.31		30
			0.312	7.92	27.73	41.24		
			0.322	8.18	28.58	42.55	STD	40
			0.344	8.74	30.45	45.34		
			0.375	9.52	33.07	49.20		
			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	60
			0.562	14.27	73.22	108.93		
			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 diameter		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
			16	16	406.4	2.000	50.80	381.83
2.125	53.97	401.50				269.50		
2.200	55.88	413.01				277.25		
2.500	63.50	457.40				307.05		
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																													
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406.4																													
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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	
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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	
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32.0																														
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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																										
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406.4																										
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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 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

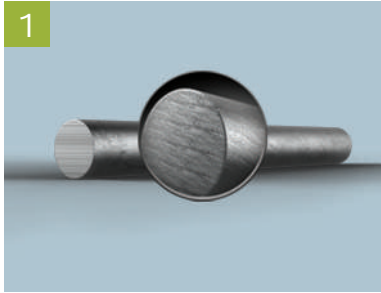
Dimensions and weight for Hot rolled – Type L and L1

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	
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	-	-	

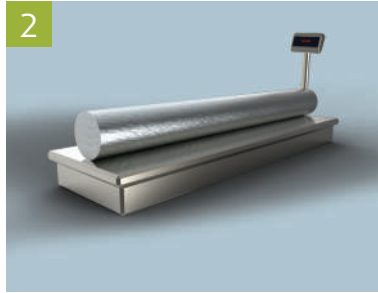
— Upon agreement



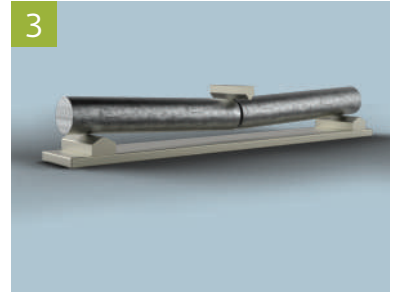
MANUFACTURING OF SEAMLESS PIPES



1
Billet incoming inspection



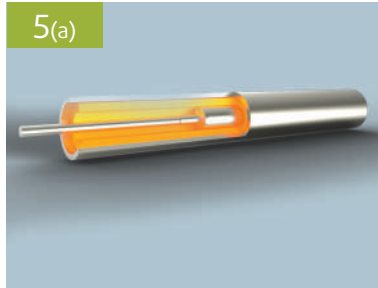
2
Billet weighing



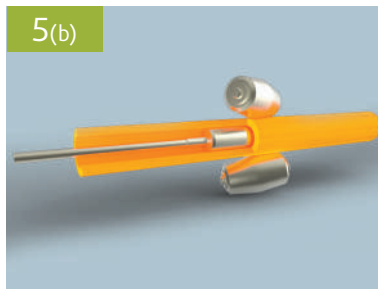
3
Billet cutting



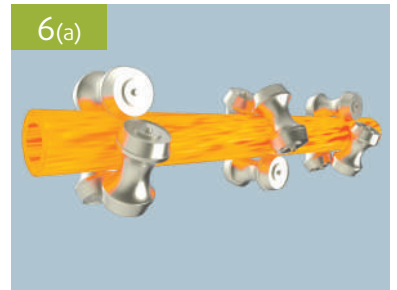
4
Heating of billet in rotary furnace



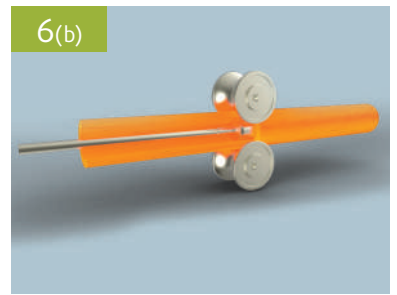
5(a)
Piercing of billet at piercing press



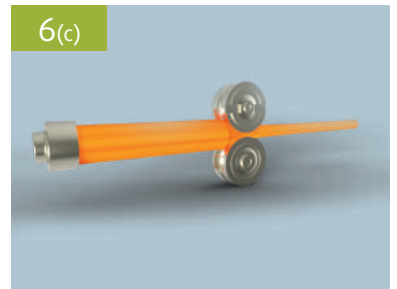
5(b)
Piercing of billet at cross-roll piercer



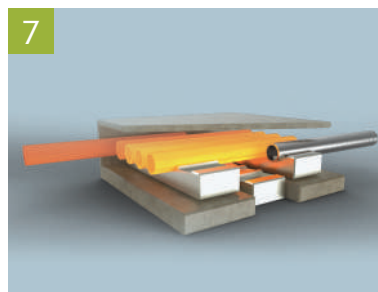
6(a)
Shell rolling at continuous rolling mill



6(b)
Shell rolling at plug mill



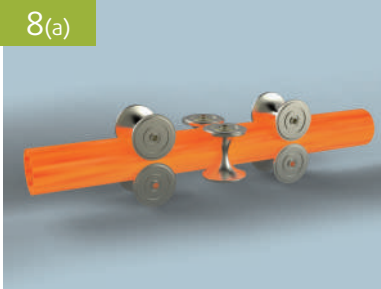
6(c)
Shell rolling at pilger mill



7
Heating of pipes

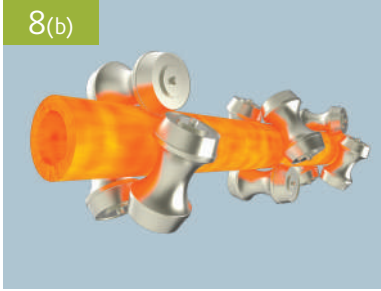
MANUFACTURING OF SEAMLESS PIPES

8(a)



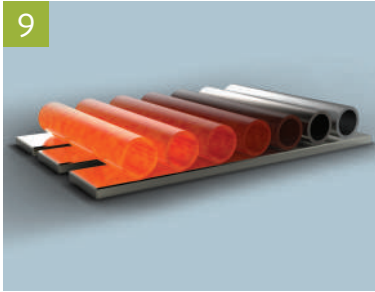
Sizing

8(b)



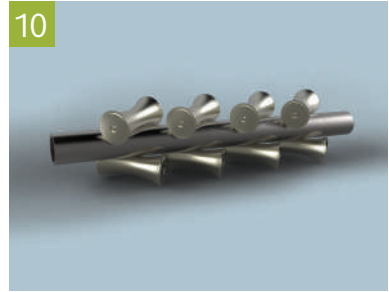
Stretch reducing

9



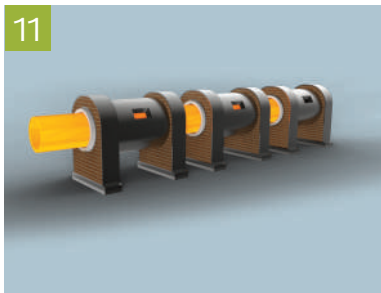
Pipes cooling

10



Straightening of pipes

11



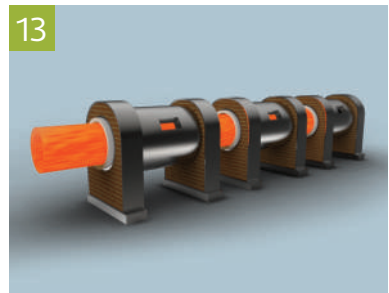
Heating of pipes for quenching

12



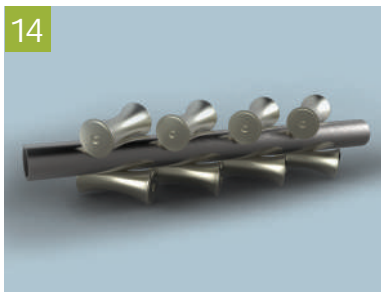
Quenching

13



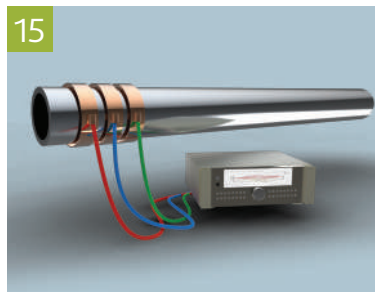
Tempering

14



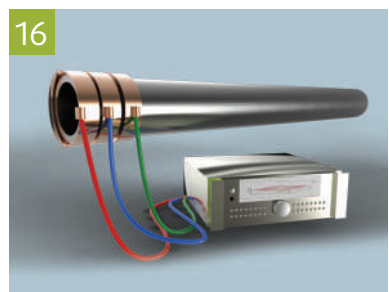
Warm straightening

15



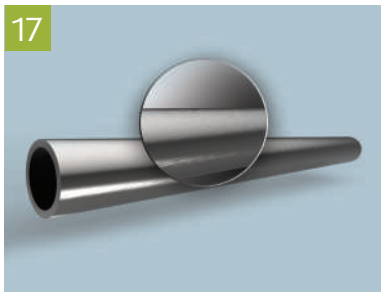
Nondestructive control of pipe body

16



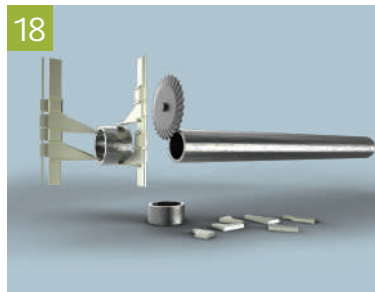
NDT of pipe ends

17



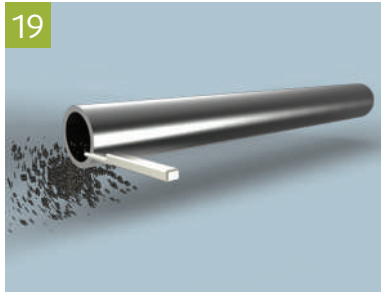
Visual inspection

18

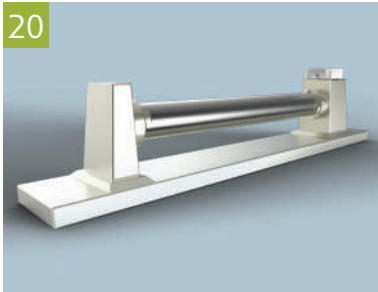


Sampling for mechanical tests and chemical composition analysis

FINISHING OF PLAIN END PIPES



19 Beveling



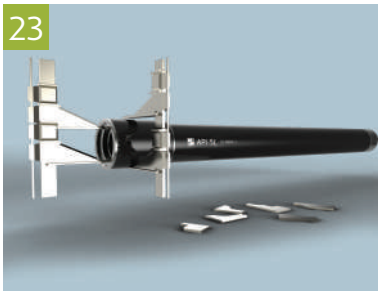
20 Hydraulic pressure test



21 Painting of pipes



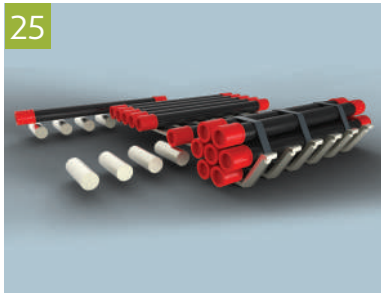
22 Marking



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	*	
			0.600	15.24	16.60	27.68	XXS	*		
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	*		
3½	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	40	-	-			
			0.406	10.31	53.57	79.71	-	-	-	-			
			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																													
38.0																													
42.0																													
42.4																													
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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 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																										
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		
10	10.750	273.0	0.322	8.18	28.55	42.55	STD	40
			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		
12	12.750	323.8	0.344	8.74	38.23	56.98		
			0.365	9.27	40.52	60.29	STD	40
			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		30
			0.330	8.38	43.77	65.2		
14	14.000	355.6	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		
			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		20
16	16	406.4	0.312	7.92	45.61	67.9		
			0.344	8.74	50.17	74.76		30
			0.375	9.53	54.57	81.33	STD	40
			0.250	6.35	42.05	62.64		10
			0.281	7.14	47.17	70.3		20
20	20	508	0.312	7.92	52.27	77.83		
			0.344	8.74	57.52	85.71		30
			0.375	9.53	62.64	93.27	STD	40
			0.438	11,13	72,91	108,50		
			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		
20	20	508	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		
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 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													
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 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				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 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																						
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							

08кп, 08пс,
Ст1кп, Ст1пс,
Ст2сп, Ст2пс,
Ст3сп, Ст3пс,
10, 10пс, 20,
20пс

Ст3сп, Ст3пс,
10, 10пс, 20,
20пс

К50, К52,
К55, К60
(17Г1С-У,
09Г2С, 09Г3СФ,
13ХФА,
13Г1С-У,
10Г2ФБЮ)

GOST 20295-85

STEEL WELDED TUBES FOR GAS AND OIL MAIN PIPELINES

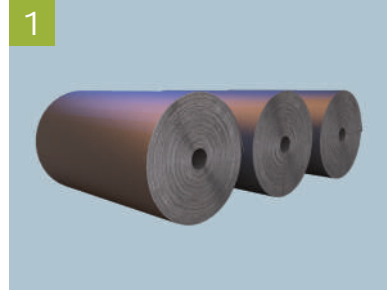
Application: for construction of gas and oil main pipelines, oil-products pipelines,
process and field pipelines
Pipe dimensions and weight

Outside 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												
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					

К34
(10, 10пс)
К38
(Ст3сп, Ст3пс)
К42
(20, 20пс)

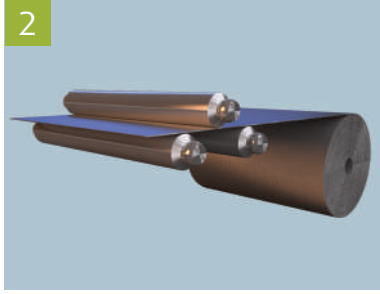
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WELDED PIPES PRODUCTION



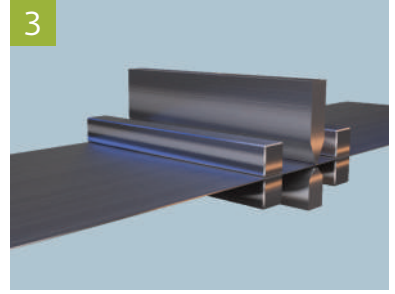
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Coil storage



2

Uncoiling



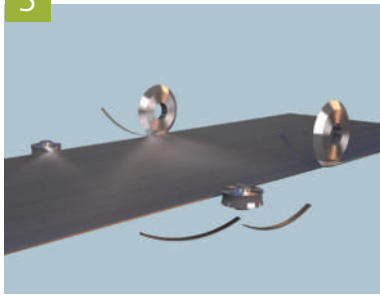
3

Coil ends cutting&welding



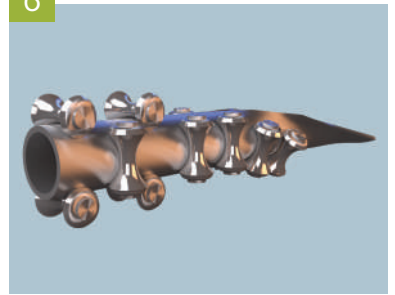
4

Accumulating



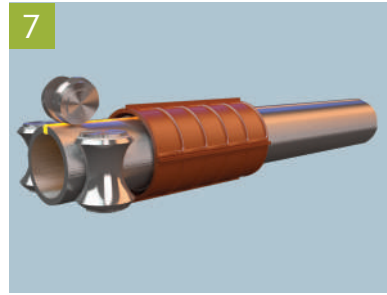
5

Edge trimming and edge milling



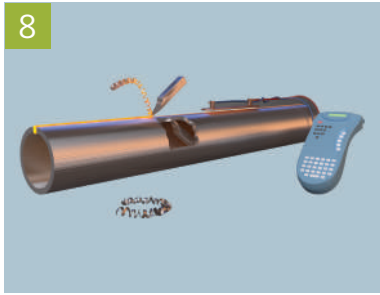
6

Forming



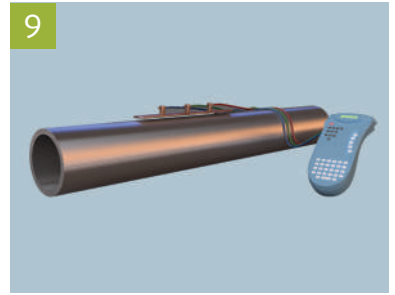
7

ERW/HFI welding



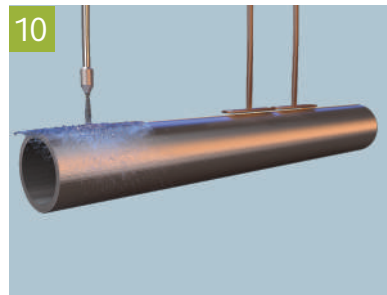
8

OD/ID scarfing



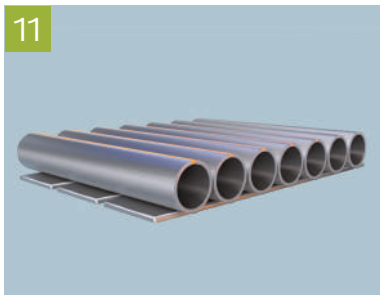
9

On line seam UST



10

Seam annealing



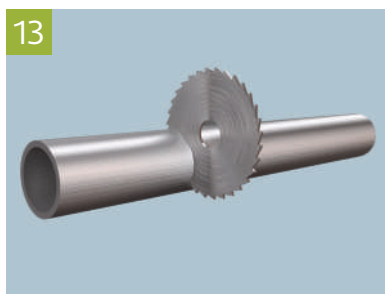
11

Cooling



12

Sizing



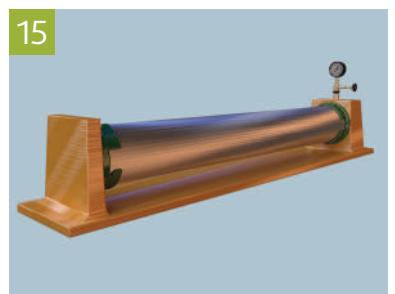
13

Cut to length



14

Ends beveling

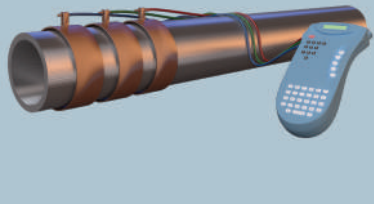


15

Hydrotesting

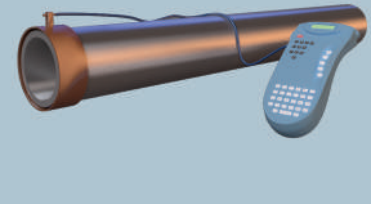
WELDED PIPES PRODUCTION

16



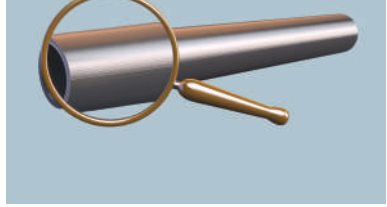
Final ultrasonic inspection

17



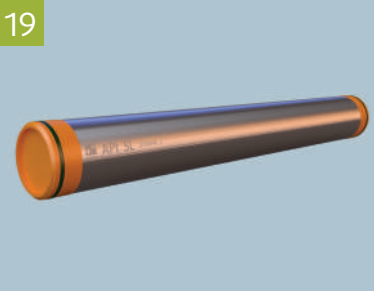
Wet MPI on pipe ends

18



Final visual inspection

19



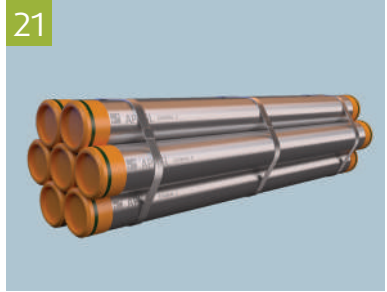
WMS bevel protect

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							
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	

S235JRH-
S275J0H

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;

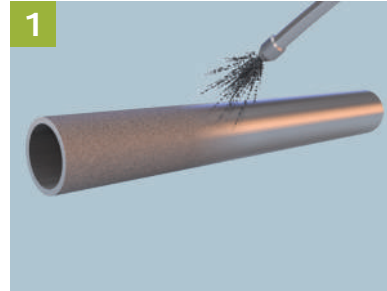
Type 2 – at service temperatures up to plus 30 °C;

Acceptance testing of pipes with coating:

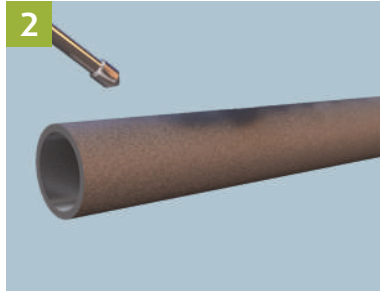
- external appearance of coating check;
- length measuring of bare ends;
- taper angle measuring coating to the pipe's body;
- dielectric coating integrity testing;
- thickness of coating testing;
- strength test of coating with the impact up to (20 ± 5) °C;
- peel force control at temperatures of plus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



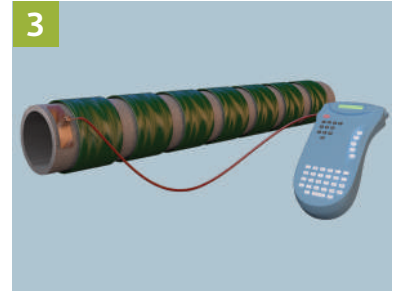
3-LAYER POLYETHYLENE/POLYPROPYLENE COATING FUSION BONDED EPOXY COATING



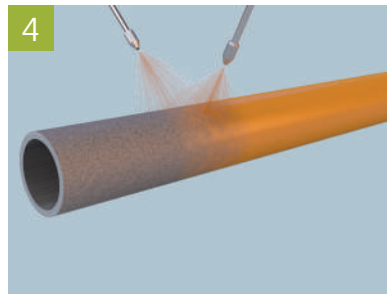
1 Shot blasting



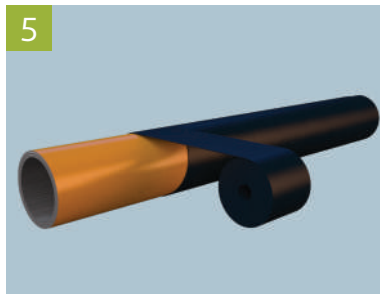
2 Dust removal



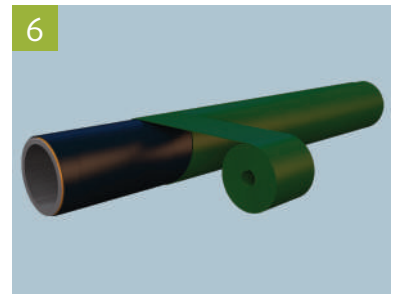
3 Induction heating



4 Epoxy powder application



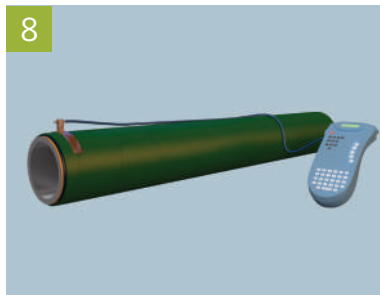
5 Adhesive application



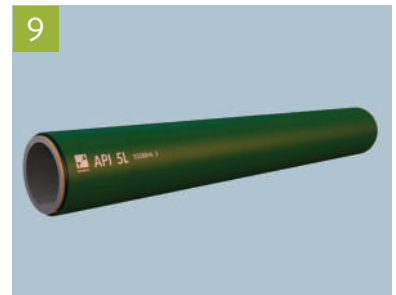
6 Polyethylen application



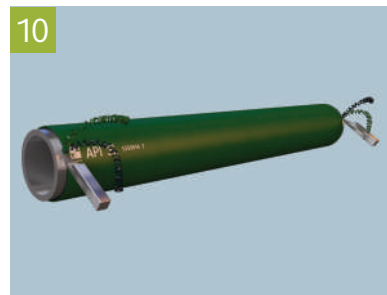
7 Pipe cooling



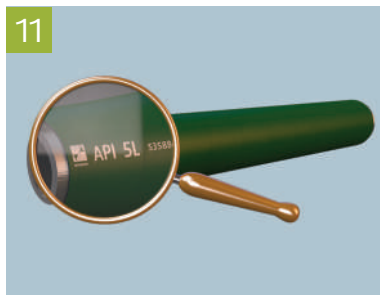
8 On-line holiday test



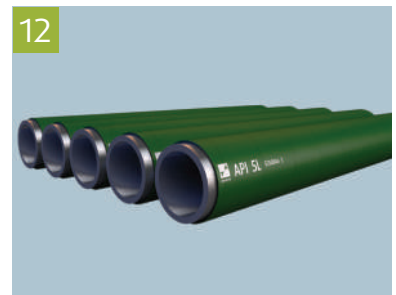
9 Pipe marking



10 Pipe ends processing



11 Final visual inspection marking ends protect



12 Storing

Interpipe Europe

Via San Salvatore 13 - P.O. Box 745
CH-6902 Paradiso - Lugano, Switzerland
Tel.: **+41 91 261 39 00**
Fax: **+41 91 261 39 01**
E-mail: **info@eu.interpipe.biz**

Interpipe Central Trade

Corneliusstrasse 34,
60325 Frankfurt-am-Main, Germany
Tel.: **+49 695 050 25 850**

Interpipe Middle East

Office N°: LB191008, P.O. Box 262810,
Jebel Ali, Dubai - UAE
Tel.: **+971 4 812 5500**
Fax: **+971 4 885 7412**
E-mail: **info@ae.interpipe.biz**

North American Interpipe

1800 West Loop South, Suite 1350,
Houston, Texas, 77027 - USA
Tel.: **+1 713 333 0333**
Fax: **+1 713 333 0330**
E-mail: **info@us.interpipe.biz**

Interpipe Ukraine

1A, Piszhevskogo street
49000 Dnepropetrovsk, Ukraine
Tel.: **+380 56 736 60 06**
Fax: **+380 562 389 482, 389 580**
E-mail: **info@ua.interpipe.biz**
www.interpipe.biz