

JINDAL PIPES LIMITED

JINDAL
D.P. JINDAL GROUP

A Legacy of 50 years, Engineering the future!



MAHARASHTRA SEAMLESS LIMITED
ISO9001:2015



ISO9001:2015

24" ERW PIPE MILL



GROUP PROFILE

The D.P. Jindal Group's culture of exceeding expectations and skillful success has cemented its position as India's top manufacturer of seamless and ERW steel pipes and tubes, including Maharashtra Seamless Ltd. in Nagothane, Maharashtra.

Forging ahead since its inception, the D.P. Jindal Group has achieved an impressive annual turnover of Rs 8863 crore despite national and international competition. With a progressive outlook, the Group has diversified into renewable energy generation, including wind and solar power, actively promoting environmental sustainability.

Constantly innovating, this company explores and redefines steel pipe and tube grades and applications for diverse sectors like Oil & Gas, power, and infrastructure. Their product range encompasses ERW pipes (black and galvanized) and seamless pipes (hot finished, cold drawn, and pilgered).

A prominent player in the industry with over 50 years of expertise, JINDAL STAR, formerly Jindal Ghaziabad, is recognized as one of India's oldest, most respected, and largest manufacturers of ERW (black and galvanized) steel pipes and tubes, offering sizes from 15mm NB to 610mm NB. JINDAL STAR stands out due to its unique offerings and significant market presence.





Jindal Star is a brand of D.P. Jindal Group.

Manufacturing Units

Strategically located manufacturing plants across India include Ghaziabad (U.P.), Raigad (Maharashtra), Jharsuguda (Odisha), Bellary (Karnataka), and Hyderabad (Telangana).

Installed Capacity

10 MMT/PA per annum, size 1/2" to 24" (wall thickness upto 12.7mm).

Branch Offices

Delhi, Punjab, Baroda, Kolkata, Mumbai, Chennai, Hyderabad, Bangalore.

Specifications

ERW pipes are being manufactured EN, BIS, BS, API, ASTM, DIN, IBR Specification and conform to various national and international standards.

Quality Assurance

Jindal Star has accreditation of API QI System and facilities are ISO9001:2015 certified

Awards

Jindal Star has been awarded as the most trusted brand of India in year 2015 & 2016 and the rated as amongst the top 100 brands in India.

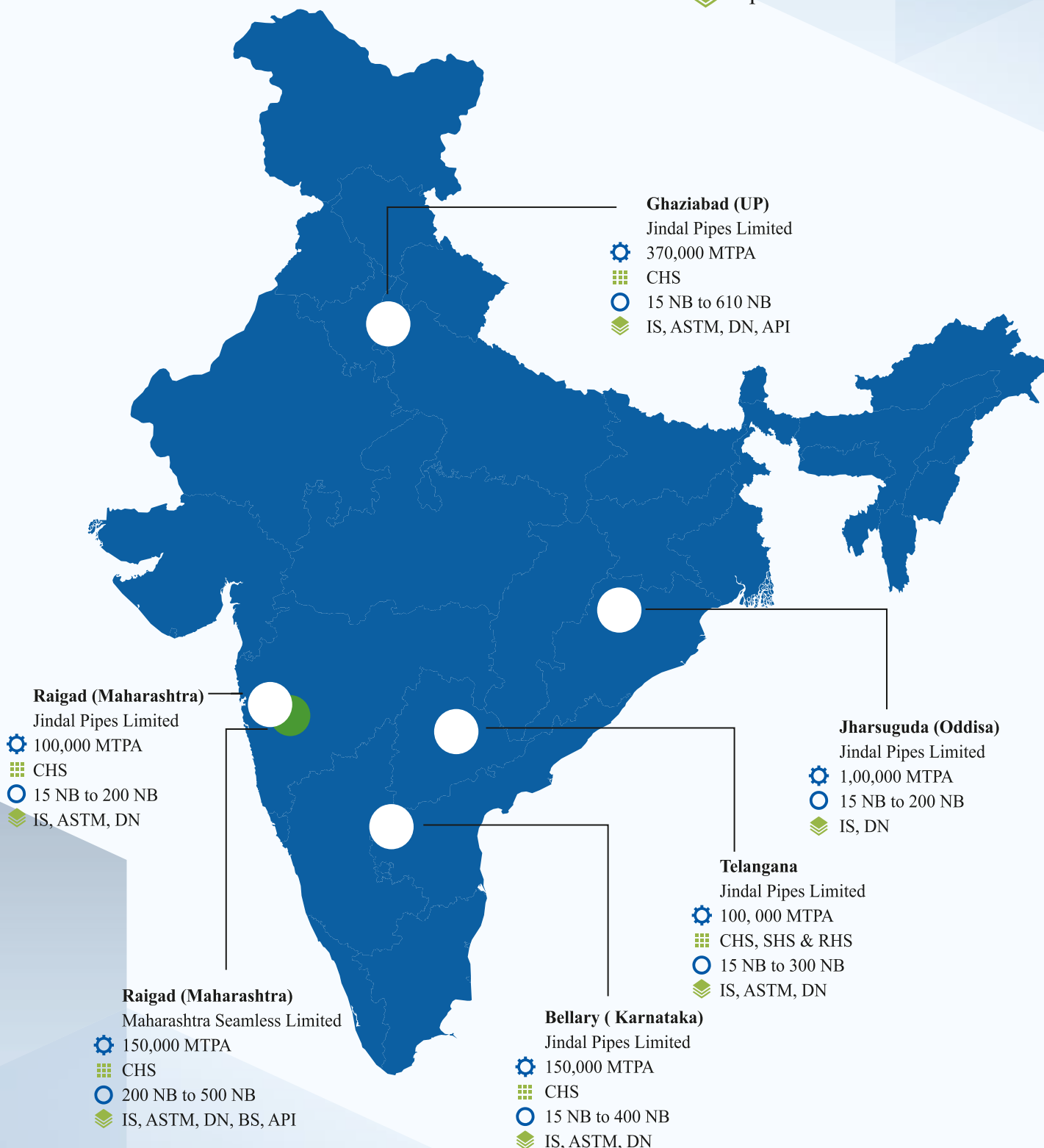
Pipe Corrosion Protection Systems

The Group's Raigad coating plant, in Maharashtra, offers pipe corrosion protection with 3LPE, 3LPP, and FBE coatings for both black and galvanized pipes, in addition to its galvanizing facilities.



MANUFACTURING UNITS

-  Manufacturing Capacity
-  Type of Section
-  Size Range Specion
-  Specification



ABOUT JINDAL PIPES LIMITED

HAZIABAD UNIT (Jindal Nagar)

Jindal Pipes Limited, a pioneering leader in the pipe industry, is renowned for manufacturing India's top-quality ERW, black and galvanized steel pipes, along with powder and epoxy coatings.

Established in 1970, Jindal Pipes Limited has significantly advanced pipe manufacturing through innovation, achieving a 3,70,000 MTPA capacity with skilled workforce and advanced technology. It offers a wide product range from 15 NB to 610 NB and 2.00 mm to 12.70 mm wall thicknesses, providing a market advantage. Its sister company, Maharashtra Seamless Limited, supplies ERW and Seamless Pipes up to 500 NB.

Jindal Pipe prioritizes quality through strict raw material management, manufacturing, distribution, and delivery, evidenced by ISO 9001:2015, API, and BIS certifications, reflecting its "No Compromise on Quality" policy.

QUALITY CREDENTIALS

Jindal Pipe's Total Quality approach, emphasizing strict control from raw materials to customer delivery, has earned it ISO 9001:2015, API, and BIS certifications, reflecting its "No compromises on Quality" commitment.

Jindal Pipes Limited is API QI System and ISO 9001 certified, and its products are approved by international inspection authorities like Lloyds, DNV, BVQI, TUV NORD, EIL, PDIL, SGS, NTPC, PGCIL, BHEL, TUV SUD, QSS, and more.

Jindal Pipes Limited has an in-house lab for testing and inspections during manufacturing process.

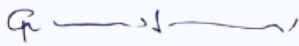


QUALITY POLICY

- Consistent with the Group purpose, we are committed to create value for all our stakeholders by continually improving the effectiveness of Quality System and Processes through innovation, involving all our employees
- We shall constantly strive to improve the quality of the life of the communities it serves through excellence in all facets of its activities.

OUR OBJECTIVES SHALL BE TO:

- (A) Produce and deliver products as per customer expectations, confirming to National / International standard.
- (B) Enhance the knowledge and skills of the Employees for effective implementation of Quality Management System.



RAGHAV JINDAL
(MANAGING DIRECTOR)

Inspection Agencies

TPL	IR CLASS	RITES	TUV NORD
INTERTEK	EIL	QUEST	LRIS
DGS & D	PDIL	DNV GL	HMPL
ICS	SGS	TUV SUD	
NTPC	BVQI	ABS	



ACCREDITATION




Certificate of Authority to use the Official API Monogram
License Number: 5L-0135 ORIGINAL

The American Petroleum Institute hereby grants to
JINDAL PIPES LIMITED
35th Km, Delhi-Hapur Road
Jindal Nagar
Hapur, Uttar Pradesh
India

the right to use the Official API Monogram® on manufactured products under the conditions in the official publications of the American Petroleum Institute entitled API Spec Q1® and **API-5L** and in accordance with the provisions of the License Agreement.

In all cases where the Official API Monogram is applied, the API Monogram shall be used in conjunction with this certificate number: **5L-0135**

The American Petroleum Institute reserves the right to revoke this authorization to use the Official API Monogram for any reason satisfactory to the Board of Directors of the American Petroleum Institute.

The scope of this license includes the following: Manufacturer of Line Pipe Plain End at PSL 1 - Type of Pipe: HFW / Delivery Condition: M / Max. Grade: X70, / Delivery Condition: N / Max. Grade: X70 and / Delivery Condition: R / Max. Grade: X70; Manufacturer of Line Pipe Threaded and Coupled - Type of Pipe: HFW / Delivery Condition: M / Max. Grade: B, / Delivery Condition: N / Max. Grade: B and / Delivery Condition: R / Max. Grade: B

QMS Exclusions: Design and Development; Servicing; Customer Property

Effective Date: JULY 16, 2023
Expiration Date: JULY 16, 2026

Anchal Liddar
 Senior Vice President of Global Industry Services

To verify the authenticity of this license, go to www.api.org/compositelist.



JINDAL PIPES LIMITED

22ND MILE STONE, DELHI - HAPUR ROAD, JINDAL NAGAR,
 PO - JINDAL NAGAR – 201 015, DISTRICT - HAPUR, UTTAR PRADESH, INDIA.

Bureau Veritas Certification Holding SAS – UK Branch certifies that the Management System of the above organisation has been audited and found to be in accordance with the requirements of the Management System Standard detailed below.

Standard

ISO 9001:2015

Scope of certification

MANUFACTURE , SALES AND MARKETING OF M.S. ERW BLACK AND GALVANISED; PLAIN, BEVEL AND SCREWED AND SOCKETED END PIPES AND TUBES OF SIZE 15MM TO 610 MM FOR WATER, AIR, SEWAGE, OIL AND GAS LINES, BOILER & SUPER HEATER, HEAT EXCHANGER, CONDENSER, AIR HEATER, STRUCTURE AND GENERAL ENGINEERING APPLICATIONS.

Original cycle start date: **22 September 1995**
 Expiry date of previous cycle: **02 March 2023**
 Recertification Audit date: **20 December 2022**
 Recertification cycle start date: **27 March 2025**

Subject to the continued satisfactory operation of the organisation's Management System, this certificate is valid until: **02 March 2026**

Certificate No. **IND.23.4053/QM/U** Version: 2 Issue date: **27 March 2025**

J. Manian

Signed on behalf of BVCH SAS UK Branch
Dr. JN MANIAN
 Director – CERTIFICATION, South Asia
 Commodities, Industry & Facilities Division

For certificate authenticity, click here
<https://certcheck.ukas.com>

ISO 9001 | IN042537

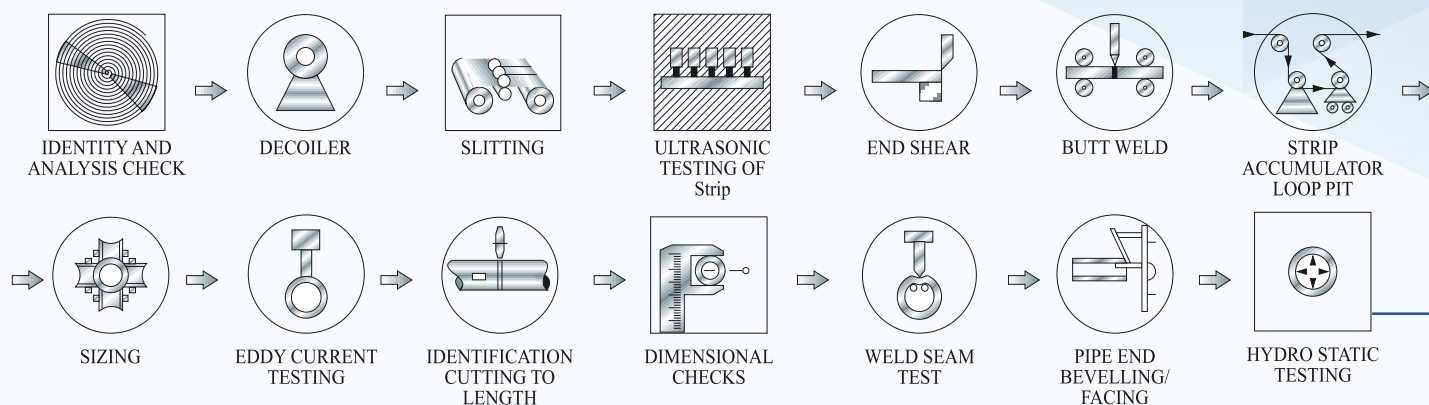


Certification body address: 5th Floor, 100 Lower Thames Street, London, EC3R 6DL, United Kingdom.

Local office: Bureau Veritas (India) Private Limited (Certification Business)
 72 Business Park, Marol Industrial Area, MIDC Cross Road "C",
 Andheri (East), Mumbai – 400 093, India.

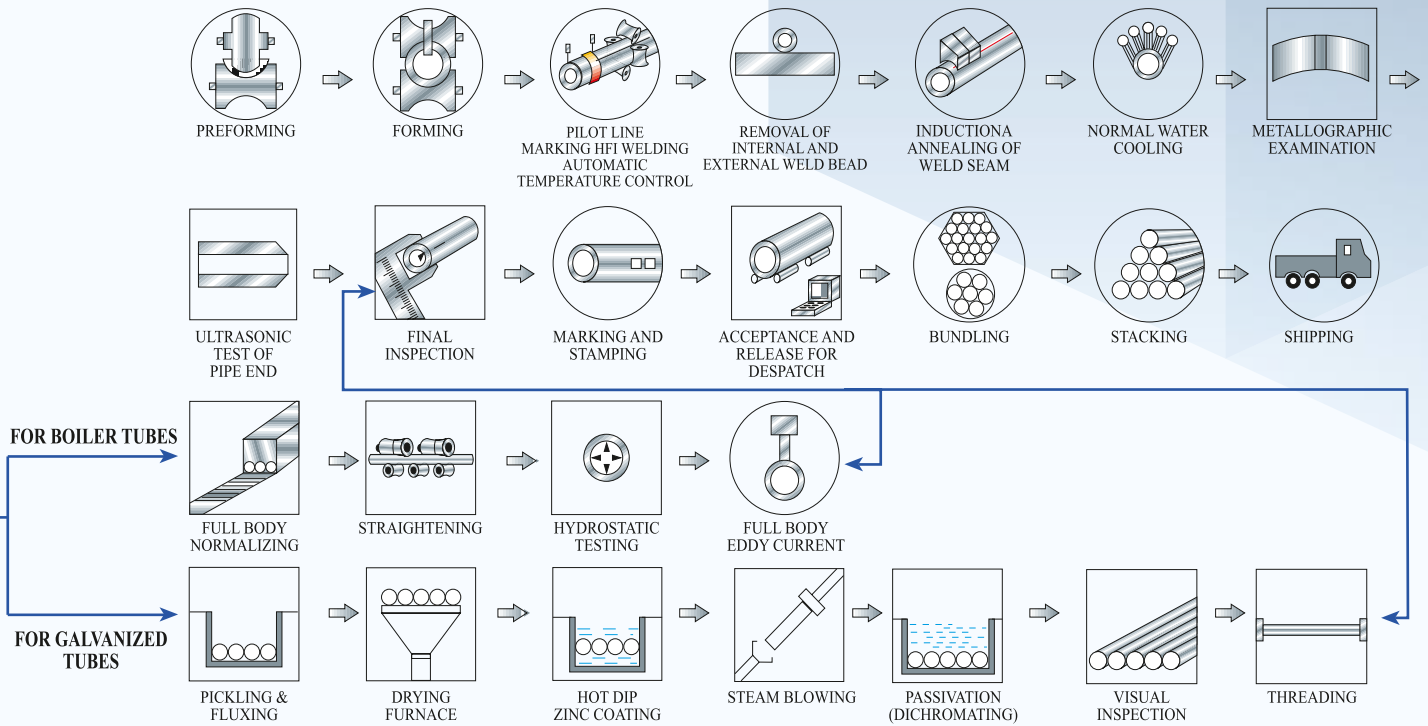
Further clarifications regarding the scope of this certificate and the applicability of the management system requirements may be obtained by consulting the organisation.
 To check this certificate validity please call + 91 22 6274 2000.

MANUFACTURING AND TESTING FLOW DIAGRAM OF HIGH FREQUENCY INDUCTION WELDED/ELECTRIC RESISTANCE WELDED BLACK AND GALVANIZED PIPES/TUBES



Application & Specifications

Oil & Gas Sector	API IS/ISO	:5L 46th edition :3183
Automotive Industry	BS IS	: 6323 (Pt-V) : 3601, 3074
Hydrocarbon & Process Industry	ASTM BS IS	: A-53 : 3603 : 6286
Boiler, Heat Exchanger Superheater, Air Heater & Condenser	ASTM BS IS	: A-178, A-214, : 3059 (P-I & P-II), 6323 (Pt-V) : 2416 (Pt-IV)
Mechanical, Structural & General Engineering	IS BS	: 1161, 3601, 9295 : 6323 (Pt-V)
Water, Gas & Sewage	IS BS DIN ISO	: 3589, 1239 (Pt-1) : 1387 : 2440, 2441 : 65
Water Well	IS	: 4270



CLIENTS



SUCCESSFUL PROJECTS

Jindal Star offers a wide range of black and galvanized ERW steel pipes and tubes (IS:3183, IS:9295, IS:4270, IS: 1239, IS:3589, IS: 1161, API 5L, ASTM) for plumbing, fire fighting, MEP, structural, and oil & gas applications, making them a top-selling brand. We customize products by steel grade, thickness, length, and finish, ensuring prompt delivery at competitive prices through strategically located units and branches.

We uniquely offer galvanizing up to 610 NB (increasing from 500 NB) and have supplied this to numerous prestigious high-altitude water projects.

Our strong nationwide distribution network includes distributors, dealers, and retailers.

Our prominent clients include ONGC, Oil India Ltd, IOCL, HPCL, BPCL, BHEL, NTPC, GAIL Gas Limited, Public Health Engineering Department, Irrigation Department, Hindalco, L&T, Bullet Train Project, Jal Jeevan Mission, and customers in the USA, Middle East, Far East, and other Asian regions.



Bullet Train



Kochi Metro

NCT of Delhi



IIT Hyderabad

DLF - Camalias

Lucknow Metro



Bengaluru Metro

Hyderabad Metro

Bengaluru Airport



City Gas Distribution

Chennai Nashro Tunnel

Supreme Court of India



BLACK & GALVANIZED ERW STEEL TUBES CONFORMING TO IS:1239 (PT-1) Equivalent to BS:1387

SERIES					LIGHT	MEDIUM						HEAVY					
NOMINAL BORE		O.D.	OUTSIDE DIA.		W.T.	WEIGHT		OUTSIDE DIA.		W.T.	WEIGHT		OUTSIDE DIA.		W.T.	WEIGHT	
INCH	mm	mm	MIN. (MM)	MAX. (mm)	mm	P/E Kg/m	S/S Kg/m	MIN. (MM)	MAX. (mm)	mm	P/E Kg/m	S/S Kg/m	MIN. (MM)	MAX. (mm)	mm	P/E Kg/m	S/S Kg/m
1/2	15	21.3	21.0	21.4	2.0	0.947	0.956	21.0	21.8	2.6	1.21	1.22	21.0	21.8	3.2	1.44	1.45
3/4	20	26.9	26.4	26.9	2.3	1.38	1.39	26.5	27.3	2.6	1.56	1.57	26.5	27.3	3.2	1.87	1.88
1	25	33.7	33.2	33.8	2.6	1.98	2.00	33.3	34.2	3.2	2.41	2.43	33.3	34.2	4.0	2.93	2.95
1 1/4	32	42.4	41.9	42.5	2.6	2.54	2.57	42.0	42.9	3.2	3.10	3.13	42.0	42.9	4.0	3.79	3.82
1 1/2	40	48.3	47.8	48.4	2.9	3.23	3.27	47.9	48.8	3.2	3.56	3.60	47.9	48.8	4.0	4.37	4.41
2	50	60.3	59.6	60.2	2.9	4.08	4.15	59.7	60.8	3.6	5.03	5.10	59.7	60.8	4.5	6.19	6.26
2 1/2	65	76.1	75.2	76.0	3.2	5.71	5.83	75.3	76.6	3.6	6.42	6.54	75.3	76.6	4.5	7.93	8.05
3	80	88.9	87.9	88.7	3.2	6.72	6.89	88.0	89.5	4.0	8.36	8.53	88.0	89.5	4.8	9.90	10.10
4	90	101.6	-	-	3.6	8.70	-	-	-	4.0	9.63	-	-	-	4.8	11.5	-
4	100	114.3	113.0	113.9	3.6	9.75	10.00	113.1	115.0	4.5	12.20	12.50	113.1	115.0	5.4	14.50	14.80
5	125	139.7	-	-	4.5	15.00	-	138.5	140.8	4.8	15.90	16.40	138.5	140.8	5.4	17.90	18.40
6	150	165.1	-	-	4.5	17.80	-	163.9	166.5	4.8	18.90	19.50	163.9	166.5	5.4	21.30	21.90

NOTE:

- (I) IS:1239&BS:1387 cover sizes upto 100 mm NB all series and 125 & 150 mm NB medium & heavy series, plain end and screwed & socketed ends.
- (II) Hydro test Pressure-5 MPa

BIS Amendment Thickness Changed for IS 1161 Amendment No. 2- August-2023 (5th Revision)

NB	OD	Thk	Mass	NB	OD	Thk	Mass	NB	OD	Thk	Mass	NB	OD	Thk	Mass	NB	OD	Thk	Mass	NB	OD	Thk	Mass
mm	mm	mm	kg/m	mm	mm	mm	kg/m	mm	mm	mm	kg/m	mm	mm	mm	kg/m	mm	mm	mm	kg/m	mm	mm	mm	kg/m
(1)	(2)	(3)	(4)	(1)	(2)	(3)	(4)	(1)	(2)	(3)	(4)	(1)	(2)	(3)	(4)	(1)	(2)	(3)	(4)	(1)	(2)	(3)	(4)
15	21.3	2	0.95	65	76.1	2	3.65	100	114.3	4	10.88	135	152.4	6.3	22.70	170	177.8	12.5	50.96	225	244.5	12.5	71.52
15	21.3	2.5	1.16	65	76.1	2.5	4.54	100	114.3	5	13.48	135	152.4	8	28.49	175	193.7	4	18.71	250	273	5	33.05
15	21.3	3	1.35	65	76.1	3	5.41	100	114.3	6	16.03	135	152.4	10	35.12	175	193.7	5	23.27	250	273	6	39.51
20	26.9	2	1.23	65	76.1	4	7.11	100	114.3	6.3	16.78	150	165.1	3	11.99	175	193.7	6	27.77	250	273	6.3	41.44
20	26.9	2.5	1.50	65	76.1	5	8.77	100	114.3	8	20.97	150	165.1	4	15.89	175	193.7	6.3	29.12	250	273	8	52.28
20	26.9	3	1.77	65	76.1	6	10.37	110	127	2.9	8.88	150	165.1	5	19.74	175	193.7	8	36.64	250	273	10	64.86
25	33.7	2	1.56	65	76.1	6.3	10.84	110	127	3.2	9.77	150	165.1	6	23.54	175	193.7	10	45.3	250	273	12	77.24
25	33.7	2.5	1.92	80	88.9	2	4.29	110	127	3.6	10.96	150	165.1	6.3	24.67	175	193.7	12	53.77	300	323.9	6	47.04
25	33.7	3	2.27	80	88.9	2.5	5.33	110	127	4	12.13	150	165.1	8	30.99	175	193.7	12.5	55.86	300	323.9	6.3	49.34
32	42.4	2	1.99	80	88.9	3	6.36	110	127	5	15.04	150	168.3	3	12.23	200	219.1	4	21.22	300	323.9	8	62.32
32	42.4	2.5	2.46	80	88.9	4	8.38	110	127	6	17.90	150	168.3	4	16.21	200	219.1	5	26.40	300	323.9	10	77.41
32	42.4	3	2.91	80	88.9	5	10.35	110	127	6.3	18.75	150	168.3	5	20.14	200	219.1	6	31.53	300	323.9	12	92.30
32	42.4	4	3.79	80	88.9	6	12.27	125	139.7	3	10.11	150	168.3	6	24.02	200	219.1	6.3	33.06	300	323.9	12.5	95.99
40	48.3	2	2.28	80	88.9	6.3	12.83	125	139.7	4	13.39	150	168.3	6.3	25.17	200	219.1	8	41.65	350	355.6	5	43.23
40	48.3	2.5	2.82	90	101.6	2	4.91	125	139.7	5	16.61	150	168.3	8	31.63	200	219.1	10	51.57	350	355.6	6	51.73
40	48.3	3	3.35	90	101.6	2.5	6.11	125	139.7	6	19.78	150	168.3	10	39.04	200	219.1	12	61.29	350	355.6	6.3	54.27
40	48.3	4	4.37	90	101.6	3	7.29	125	139.7	6.3	20.73	170	177.8	4	17.14	200	219.1	12.5	63.69	350	355.6	8	68.58
40	48.3	5	5.34	90	101.6	4	9.63	125	139.7	8	25.98	170	177.8	5	21.31	225	244.5	5	29.53	350	355.6	10	85.23
50	60.3	2	2.88	90	101.6	5	11.91	125	139.7	10	31.99	170	177.8	6	25.42	225	244.5	6	35.29	350	355.6	12	101.68
50	60.3	2.5	3.56	90	101.6	6	14.15	135	152.4	3	11.05	170	177.8	6.3	26.65	225	244.5	6.3	37.01	350	355.6	12.5	105.77
50	60.3	3	4.24	90	101.6	6.3	14.81	135	152.4	4	14.64	170	177.8	8	33.50	225	244.5	8	46.66	350	355.6	16	134
50	60.3	4	5.55	100	114.3	2.5	6.89	135	152.4	5	18.18	170	177.8	10	41.38	225	244.5	10	57.83	350	355.6	20	165.53
50	60.3	5	6.82	100	114.3	3	8.23	135	152.4	6	21.66	170	177.8	12	49.07	225	244.5	12	68.81				

ERW PIPES FOR WATER & SEWAGE CONFORMING TO IS:3589 & WATER WELL CASING CONFORMING TO IS:4270

SIZE		CONVENTIONAL MASS PER UNIT LENGTH (Kg/m)																				
NB	OD	WALL THICKNESS (mm)																				
mm	mm	3.20	3.60	4.00	4.30	4.65	4.85	5.00	5.20	5.40	5.60	6.00	6.35	6.40	7.00	7.10	8.00	9.50	10.00	12.00	12.50	12.70
100	114.30	-	-	-	-	-	-	13.48	-	14.50	-	16.02	-	-	-	-	-	-	-	-	-	-
125	141.30	-	-	-	-	-	-	16.81	-	18.10	-	20.02	-	-	-	-	-	-	-	-	-	-
150	168.30	13.03	14.62	16.21	17.39	18.77	19.55	20.13	20.91	21.69	-	24.01	25.36	25.55	27.84	28.22	-	-	-	-	-	-
175	193.70	-	16.88	18.71	20.08	21.68	22.59	23.27	24.17	25.07	-	27.77	39.34	29.56	32.23	32.67	36.63	-	-	-	-	-
200	219.10	-	19.13	21.22	22.78	24.59	25.62	26.40	27.43	28.46	29.48	31.53	33.31	33.57	36.61	37.12	41.65	49.10	51.56	-	-	-
250	273.10	-	23.93	26.54	28.50	30.78	32.08	33.06	34.35	35.65	36.94	39.52	41.77	42.09	45.93	46.57	52.30	61.75	64.88	-	-	-
300	323.90	-	-	31.55	33.89	36.61	38.16	39.32	40.87	42.41	43.96	47.04	49.73	50.11	54.70	55.47	62.32	73.65	77.41	-	-	-
350	355.60	-	-	34.68	37.25	40.24	41.95	43.23	44.93	46.63	48.33	51.73	54.69	55.11	60.18	61.02	68.57	81.08	85.22	-	-	-
400	406.4	-	-	-	-	-	-	49.49	51.45	-	-	59.24	62.64	-	-	69.91	78.60	92.98	97.75	116.71	121.42	123.30
450	457	-	-	-	-	-	-	55.73	57.94	-	-	66.73	70.57	-	-	78.77	88.58	104.84	110.23	131.68	137.02	139.15
500	508	-	-	-	-	-	-	62.02	64.48	-	-	-	78.55	-	-	87.70	98.64	116.78	122.81	146.78	152.74	155.12
600	610	-	-	-	-	-	-	-	-	-	-	-	94.53	-	-	105.56	118.76	140.68	147.96	176.96	184.18	187.06

- NOTE: (I) IS:4270 covers Pipe size 100 mm to 350 mm NB & IS:3589 covers Pipe size 168.30 mm O.D. to 610 mm OD.
 (II) IS 4270 covers wall thickness upto 10 mm.
 (III) IS 3589 covers wall thickness upto 12.70 mm.
 (IV) Also uptill 24inch chart will be added with all the thickness.
 (V) Other thickness may be supplied as per agreement.
 (VI) Max. Hydro Test Pressure IS:3589-5 MPa, IS:4270-7 MPa.

ERW LINE PIPES CONFORMING TO API 5L, IS/ ISO:3183 & ASTM A 53

Dimensions. Weights and Test Pressures for Sizes 8" through 24" (SI Units)

Size	Specified Outside Diameter	Specified Wall Thickness	Plain-end Weight per Unit Length	Calculated Inside Diameter	Minimum Test Pressure (kPa x 100)									
					Grade A25	Grade A	Grade B	Grade X-42	Grade X-46	Grade X-52	Grade X-56	Grade X-60	Grade X-65	Grade X-70
	D (mm)	t (mm)	Wps (Kg/m)	d (mm)										
3 1/2"	88.9	3.2	6.76	82.5	69	91	106	125	138	156	168	179	194	205
	88.9	3.6	7.57	81.7	69	102	119	141	156	175	190	201	205	205
	88.9	4.0	8.37	80.9	69	113	132	157	173	194	205	205	205	205
	88.9	4.4	9.17	80.1	69	125	146	172	190	205	205	205	205	205
	88.9	4.8	9.95	79.3	69	136	159	188	205	205	205	205	205	205
	88.9	5.5	11.31	77.9	69	156	170	205	205	205	205	205	205	205
4"	101.6	3.2	7.76	95.2	-	79	93	110	121	136	147	157	170	183
	101.6	3.6	8.70	94.4	55	89	104	123	136	153	166	177	191	205
	101.6	4.0	9.63	93.6	-	99	116	137	151	170	184	196	205	205
	101.6	4.4	10.55	92.8	69	109	127	151	166	187	202	205	205	205
	101.6	4.8	11.46	92	83	119	139	164	181	204	205	205	205	205
	101.6	5.7	13.48	90.2	83	141	165	195	205	205	205	205	205	205
	101.6	6.4	15.02	88.8	-	159	185	205	205	205	205	205	205	205
4 1/2"	114.3	3.2	8.77	107.9	55	71	82	97	108	121	131	139	151	163
	114.3	3.6	9.83	107.1	-	79	93	110	121	136	147	157	170	183
	114.3	4.0	10.88	106.3	69	88	103	122	134	151	164	174	189	204
	114.3	4.4	11.92	105.5	-	97	113	134	148	166	180	192	205	205
	114.3	4.8	12.96	104.7	83	106	124	146	161	181	197	205	205	205
	114.3	5.2	13.99	103.9	-	115	134	158	175	197	205	205	205	205
	114.3	5.6	15.01	103.1	83	123	144	170	188	205	205	205	205	205
	114.3	6.0	16.02	102.3	83	132	154	183	202	205	205	205	205	205
	114.3	6.4	17.03	101.5	-	141	165	195	205	205	205	205	205	205
5 9/16"	141.3	3.2	10.90	134.9	46	57	67	79	87	98	106	113	122	132
	141.3	4.0	13.54	133.3	58	71	83	99	109	122	132	141	153	165
	141.3	4.8	16.16	131.7	70	86	100	118	130	147	159	169	183	196
	141.3	5.6	18.74	130.1	18	100	117	138	152	171	186	197	205	205
	141.3	6.6	21.92	128.1	83	118	137	163	179	202	205	205	205	205
6 5/8"	168.3	3.2	13.03	161.9	-	48	56	83	91	103	111	118	128	138
	168.3	3.6	14.62	161.1	-	54	63	93	103	116	125	133	144	156
	168.3	4.0	16.21	160.3	-	60	70	103	114	128	139	148	160	173
	168.3	4.4	17.78	159.5	-	66	77	114	125	141	153	163	176	190
	168.3	4.8	19.35	158.7	-	72	84	124	137	154	167	178	193	205
	168.3	5.2	20.91	157.9	-	78	91	134	148	167	181	192	205	205
	168.3	5.6	22.47	157.1	-	84	98	145	160	180	195	205	205	205
	168.3	6.4	25.55	155.5	-	96	112	165	183	205	205	205	205	205
	168.3	7.1	28.22	154.1	-	106	124	184	202	205	205	205	205	205
8 5/8"	219.1	4.0	21.22	211.1	-	46	54	79	88	99	107	114	123	133
	219.1	4.8	25.37	209.5	-	55	64	95	105	118	128	136	148	159
	219.1	5.2	27.43	208.7	-	60	70	103	114	128	139	148	160	173

ERW LINE PIPES CONFORMING TO API 5L, IS/ ISO:3183 & ASTM A 53 16", 18", 20", 24"

Dimensions. Weights and Test Pressures for Sizes 8" through 24" (SI Units)

Size	Specified Outside Diameter	Specified Wall Thickness	Plain-end Weight per Unit Length	Calculated Inside Diameter	Minimum Test Pressure (kPa x 100)									
					Grade A25	Grade A	Grade B	Grade X-42	Grade X-46	Grade X-52	Grade X-56	Grade X-60	Grade X-65	Grade X-70
	D (mm)	t (mm)	Wps (Kg/m)	d (mm)										
8 5/8"	219.1	5.6	29.48	207.9	-	64	75	111	123	138	150	159	173	186
	219.1	6.4	33.57	206.3	-	74	86	127	140	158	171	182	197	205
	219.1	7.0	36.61	205.1	-	81	94	139	153	173	187	199	205	205
	219.1	7.9	41.14	203.3	-	91	106	157	173	195	205	205	205	205
	219.1	8.2	42.65	202.7	-	94	110	163	180	202	205	205	205	205
	219.1	8.7	45.14	201.7	-	100	117	173	191	205	205	205	205	205
	219.1	9.5	49.10	200.1	-	109	127	189	205	205	205	205	205	205
10 3/4"	273.1	4.0	26.54	265.1	-	37	43	72	80	90	97	103	112	121
	273.1	4.8	31.76	263.5	-	44	52	87	96	108	117	124	134	145
	273.1	5.2	34.35	262.7	-	48	56	94	104	117	126	134	146	157
	273.1	5.6	36.94	261.9	-	52	60	101	112	125	136	145	157	169
	273.1	6.4	42.09	260.3	-	59	69	116	127	143	155	165	179	193
	273.1	7.1	46.57	258.9	-	66	76	128	141	159	172	183	199	205
	273.1	7.8	51.03	257.5	-	72	84	141	155	175	189	202	205	205
	273.1	8.7	56.72	255.7	-	80	94	157	173	195	205	205	205	205
	273.1	9.3	60.50	254.5	-	86	100	168	185	205	205	205	205	205
12 3/4"	323.9	4.4	34.67	315.1	-	34	40	67	74	83	90	96	104	112
	323.9	4.8	37.77	314.3	-	37	44	73	81	91	98	105	113	122
	323.9	5.2	40.87	313.5	-	40	47	79	87	98	106	113	123	132
	323.9	5.6	43.96	312.7	-	44	51	85	94	106	115	122	132	143
	323.9	6.4	50.11	311.1	-	50	58	97	107	121	131	139	151	163
	323.9	7.1	55.47	309.7	-	55	64	108	119	134	145	155	168	181
	323.9	7.9	61.56	308.1	-	61	72	120	133	149	162	172	187	201
	323.9	8.4	65.35	307.1	-	65	76	128	141	159	172	183	198	205
	323.9	8.7	67.62	306.5	-	68	79	132	146	164	178	189	205	205
	323.9	9.5	73.65	304.9	-	74	86	145	160	179	194	205	205	205
14"	355.6	4.8	41.52	346.0	-	34	40	67	73	83	89	95	103	111
	355.6	5.2	44.93	345.2	-	37	43	72	80	89	97	103	112	121
	355.6	5.3	45.78	345.0	-	38	44	74	81	91	99	105	114	123
	355.6	5.6	48.33	344.4	-	40	46	78	86	96	104	111	121	130
	355.6	6.4	55.11	342.8	-	45	53	89	98	110	119	127	138	148
	355.6	7.1	61.02	341.4	-	50	59	98	109	122	132	141	153	165
	355.6	7.9	67.74	339.8	-	56	65	110	121	136	147	156	170	183
	355.6	8.7	74.42	338.2	-	62	72	121	133	150	162	173	187	202
	355.6	9.5	81.08	336.6	-	67	79	132	145	163	177	188	204	205
16"	406.4	5.00	49.49	396.4	37	44	51	61	67	75	82	87	94	101
	406.4	5.20	51.45	396	38	46	53	63	70	78	85	90	98	105
	406.4	6.00	59.24	394.4	44	53	61	73	80	90	98	104	113	122
	406.4	6.35	62.64	393.7	46	56	65	77	85	96	104	110	120	129

ERW LINE PIPES CONFORMING TO API 5L, IS/ ISO:3183 & ASTM A 53 16", 18", 20", 24"

Dimensions. Weights and Test Pressures for Sizes 8" through 24" (SI Units)

Size	Specified Outside Diameter	Specified Wall Thickness	Plain-end Weight per Unit Length	Calculated Inside Diameter	Minimum Test Pressure (kPa x 100)									
					Grade A25	Grade A	Grade B	Grade X-42	Grade X-46	Grade X-52	Grade X-56	Grade X-60	Grade X-65	Grade X-70
	D (mm)	t (mm)	Wps (Kg/m)	d (mm)										
16"	406.4	7.10	69.91	392.2	52	62	73	86	95	107	116	123	134	144
	406.4	8.00	78.60	390.4	59	70	82	97	107	120	131	139	151	162
	406.4	9.50	92.98	387.4	70	83	97	115	127	143	155	165	179	193
	406.4	10.00	97.75	386.4	73	88	102	121	134	151	163	174	188	203
	406.4	12.00	116.71	382.4	88	105	123	146	161	181	196	208	226	243
	406.4	12.50	121.42	381.4	92	110	128	152	167	188	204	217	235	254
	406.4	12.70	123.30	381	93	112	130	154	170	191	207	220	239	258
18"	457	5.00	55.73	447	33	39	46	54	60	67	73	77	84	90
	457	5.20	57.94	446.6	34	41	47	56	62	70	75	80	87	94
	457	6.00	66.73	445	39	47	55	65	71	80	87	93	100	108
	457	6.35	70.57	444.3	41	50	58	69	76	85	92	98	106	115
	457	7.10	78.77	442.8	46	55	65	77	85	95	103	110	119	128
	457	8.00	88.58	441	52	62	73	86	95	107	116	124	134	144
	457	9.50	104.84	438	62	74	87	102	113	127	138	147	159	171
	457	10.00	110.23	437	65	78	91	108	119	134	145	154	167	180
	457	12.00	131.68	433	78	94	109	129	143	161	174	185	201	216
	457	12.50	137.02	432	81	98	114	135	149	167	181	193	209	226
	457	12.70	139.15	431.6	83	99	116	137	151	170	184	196	213	229
20"	508	5.00	62.02	498	29	35	41	49	54	60	65	69	75	81
	508	5.20	64.48	497.6	30	37	43	50	56	63	68	72	78	84
	508	6.00	74.28	496	35	42	49	58	64	72	78	83	90	97
	508	6.35	78.55	495.3	37	45	52	62	68	77	83	88	96	103
	508	7.10	87.70	493.8	42	50	58	69	76	86	93	99	107	115
	508	8.00	98.64	492	47	56	66	78	86	96	104	111	120	130
	508	9.50	116.78	489	56	67	78	92	102	114	124	132	143	154
	508	10.00	122.81	488	59	70	82	97	107	120	131	139	151	162
	508	12.00	146.78	484	70	84	98	116	129	145	157	167	181	195
	508	12.50	152.74	483	73	88	102	121	134	151	163	174	188	203
	508	12.70	155.12	482.6	74	89	104	123	136	153	166	176	191	206
24"	610	6.35	94.53	597.3	31	37	43	51	57	64	69	73	80	86
	610	7.10	105.56	595.8	35	42	48	57	63	71	77	82	89	96
	610	8.00	118.76	594	39	47	55	65	71	80	87	93	100	108
	610	9.50	140.68	591	46	56	65	77	85	95	103	110	119	128
	610	10.00	147.96	590	49	59	68	81	89	100	109	116	125	135
	610	12.00	176.96	586	59	70	82	97	107	120	130	139	150	162
	610	12.50	184.18	585	61	73	85	101	111	125	136	145	157	169
	610	12.70	187.06	584.6	62	74	87	103	113	127	138	147	159	172

TOLERANCE ON OUTSIDE DIAMETER, WALL THICKNESS, WEIGHT AND LENGTH OR PIPE

SPEC	OUT SIDE DIAMETER		WALL THICKNESS	WEIGHT	LENGTH							
	PIPE BODY	PIPE END			NORMAL		Avg. (MIN)		MINIMUM		MAXIMUM	
					ft	mtr	ft	mtr	ft	mtr	ft	mtr
API 5L & IS/ISO:3183	<2-3/8" (60.3mm) OD = +0.40mm, -0.80mm ≥2-3/8" (60.3mm) OD = ±0.0075 D	< 2 3/8" (60.8mm): +0.4mm, -0.8mm > 2 3/8" (60.8mm) to ≤ 6 5/8" (168.3mm) +1.60mm, -0.40mm > 6 5/8" (168.3mm) ± 0.005 D (but max.of ±1.6mm)	≤ 5.0mm WT ± 0.5mm > 5.0mm WT to < 15.0mm WT ± 0.1t ≥ 15.0mm WT ± 1.5mm	Single length of pipe + 10%, - 3.5% Car loades - 40,000 lb (18,144 Kg.) or more - 1.75%, less - 3.5%	20 40	6.0 12.0	17.5 35	5.3 10.7	9.0 14.0	2.74 4.27	22.5 45.0	6.86 13.72
IS:1239 & BS:1387	As per table	N.A.	Light - 8% + not limited Medium & Heavy - 10%, + not limited	Carload 10 MT Light +7.5%, -5%, M & H ± 7.5% Single Tube Light -8% + 10% Med & Heavy ± 10%	-	6.0 12.0	-	-	-	4.0 7.0	-	7.0 10.0
IS:3589	Upto 610mm OD = ± 0.75%	N.A.	± 10%	Carload 10MT and above ± 7.5%	-	6.0 12.0	-	-	-	4.00 7.00	-	7.0 14.0
IS:4270	± 1.0%	-	Upto 406.4mm OD = +15% - 12.5%	+ 10% - 8%	-	6.0	-	-	-	4.00	-	12.0
IS:1161	Upto 48.3mm OD + 0.4mm, -0.8mm Over 48.3mm ± 1.0%	N.A.	+ -10%,	Carload 10 MT ± 7.5 % Single Tube ± 10%	-	6.0	-	-	-	4.0	-	12.0
IS:9295	± 0.8%	N.A.	±10%	Single Length : ±10% Carload per 10 tonnes : ±7.5%	-	6.0	-	-	-	4.0	-	12.0
IS:1914 Pt-IV	+ 0, -1%	N.A.	+ 10%, -5%	N.A.	Tolerance - Upto 9 mtr +3, -0mm Above 9 mtr +6, -0mm							
IS:2416 Pt-IV	± 0.75% (± 0.30mm min.)	N.A.	+ 10%, -5%	N.A.	Tolerance - Upto 9 mtr +3, -0mm Above 9 mtr +6, -0mm							
IS:11714 Pt-III	As per table	N.A.	+ 18%, -0	+ 10%, -0	Tolerance - Below 50mm + 3.2, -0mm 50mm & above + 4.8, -0mm							
BS:3059 Pt-I	± 0.75% (± 0.30mm min.)	N.A.	Upto 3.25mm ± 10% Over 3.25mm ± 7.5%	N.A.	Tolerance - Upto 6 mtr +6, -0mm Above 6 mtr 1.5mm will increase for every 3 mtr increase of length. (12mm max.)							
BS:3059 Pt-II	± 0.75% (± 0.30mm min.)	N.A.	± 10% (excluding weld area)	N.A.								
BS:6323 Pt-V	As per table	N.A.	Less than 3mm + 10% 3mm & above + 8%	N.A.	-	-	-	-	-	3	-	12.0
ASTM A-53	1-1/2 NPS & under = ± 0.4mm 2" NPS and over = ±1.0%	N.A.	At any point -12.5%(Max)	±10%	20 40	6.0 12.0	35	10.6	16 22	4.88 12.0	22	12.0
ASTM- A178 & A214	<1" (25.4mm): ± 0.10mm 1" (25.4mm) to 1-1/2" (38.1mm) Incl: ± 0.15mm > 1-1/2" (38.1mm) to 2" (50.8mm) excl: ± 0.20mm 2" (50.8mm) to 2-1/2" (63.5mm) excl: ± 0.25mm 2-1/2" (63.5mm) to 3" (76.2mm) excl: ± 0.30mm 3" (76.2mm) to 4" (101.6mm) Incl: ± 0.38mm > 4" (101.6mm) to 7-1/2" (190.5mm) Incl: + 0.38mm, - 0.64mm > 7-1/2" (190.5mm) to 9" (228.6mm) Incl: +0.38mm, - 1.14mm	N.A.	+ 18%, -0	+ 10%, -0	< 2" (50.8mm) O.D. : +3mm, - 0 ≥ 2" (50.8mm) O.D. : +5mm, - 0							
IBR	± 0.75% (But min 0.30mm)	N.A.	for grade WC1: ≤ 3.2mm: ± 10% > 3.2mm: ± 7.5% for grade WC2 & WC3: ± 10%	N.A.	tolerance - Upto & incl. 6 mm, - 0 and above 6 mtrs.: 1.5mm will increase for every 3 mtr increase of length. (12mm max.)							
RDSO ETI/OHE/11	33.7mm OD + 0.8, - 1.0mm 38.0mm OD + 0.32- 0.2mm 49.0mm OD + 0.32- 0.2mm	28.4 (Std. ID) & 27.70 (Min. ID) 29.9 (Std. ID) & 29.58 (Min. ID) 40.9 (Std. ID) & 40.58 (Min. ID)	-0.31mm, + not limited -0.35mm, + not limited -0.35mm, + not limited	N.A. N.A. N.A.	Tolerance - As agreed							

CHEMICAL COMPOSITION & MECHANICAL PROPERTIES

Specification	Grade	Chemical Composition (%) Max.							Mechanical Properties								Impact Energy J (Ft.lb) (min.)	
		C	Mn	P	S	Si	C.E.		Yield Strength				Tensile Strength					% Elongation e(min)
							PCM	IIV	Min		Max		Min		Max			
									PSI	Mpa	PSI	Mpa	PSI	Mpa	PSI	Mpa		
API 5L PSL - 1 & IS/ISO:3183 PSL - 1	L210 or A	0.22	0.90	0.030	0.030	-	-	-	30,500	210	-	-	48,600	335	-	-	U.S Customary Unit $e = 625,000 A^{0.2} / U^{0.9}$ S.I Unit $e = 1940 A^{0.2} / U^{0.9}$ Legend : e = Specified min. elongation A= Tensile test piece cross sectional area. U= Specified min. tensile strength.	-
	L245 or B	0.26	1.20	0.030	0.030	-	-	-	35,500	245	-	-	60,200	415	-	-		-
	L290 or X-42	0.26	1.30	0.030	0.030	-	-	-	42,100	290	-	-	60,200	415	-	-		-
	L320 or X-46	0.26	1.40	0.030	0.030	-	-	-	46,400	320	-	-	63,100	435	-	-		-
	L360 or X-52	0.26	1.40	0.030	0.030	-	-	-	52,200	360	-	-	66,700	460	-	-		-
	L390 or X-56	0.26	1.40	0.030	0.030	-	-	-	56,600	390	-	-	71,100	490	-	-		-
	L415 or X-60	0.26	1.40	0.030	0.030	-	-	-	60,200	415	-	-	75,400	520	-	-		-
	L450 or X-65	0.26	1.45	0.030	0.030	-	-	-	65,300	450	-	-	77,600	535	-	-		-
L485 or X-70	0.26	1.65	0.030	0.030	-	-	-	70,300	485	-	-	82,700	570	-	-	-		
IS:1239	-	0.20	1.30	0.040	0.040	-	-	-	-	-	-	-	320	-	-	12 UPTO 25 mm NB 20 ABOVE 25 mm	-	
IS:3589	Fe 330	0.16	1.20	0.040	0.040	-	-	-	-	195	-	-	-	330	-	-	20 18 15 $GL = 5.65\sqrt{Area}$	-
	Fe 410	0.20	1.30	0.040	0.040	-	-	0.45	-	235	-	-	-	410	-	-		-
	Fe 450	0.25	1.20	0.040	0.040	-	-	0.45	-	275	-	-	-	450	-	-		-
IS:1161	YST-210	0.12	0.60	0.040	0.040	-	-	-	-	210	-	-	-	330	-	-	20 17 14 $GL = 5.65\sqrt{Area}$	Distance between plates Forweld-75%, 85%, 85%
	YST-240	0.16	1.20	0.040	0.040	-	-	-	-	240	-	-	-	410	-	-		For parent- 60%, 75%, 75% N.A.
	YST-310	0.25	1.30	0.040	0.040	-	-	0.45	-	310	-	-	-	450	-	-		-
IS:4270	Fe410	-	-	0.040	0.040	-	-	-	-	235	-	-	-	410	-	-	15 13 $GL = 5.65\sqrt{Area}$	Hardness= 230 HV max
	Fe 450	-	-	0.040	0.040	-	-	-	-	275	-	-	-	450	-	-		-
IS:9295	YST-210	-	-	0.06	0.06	-	-	-	-	210	-	-	-	330	-	-	20 18 15 $GL = 5.65\sqrt{Area}$	Drift test = minimum increase in OD after expansion shall be 2.5% Flattering distance between plates for weld = 75% and for parent = 60%
	YST-240	-	-	0.06	0.06	-	-	-	-	240	-	-	-	410	-	-		
	YST-310	-	-	0.06	0.06	-	-	-	-	310	-	-	-	450	-	-		

CHEMICAL COMPOSITION & MECHANICAL PROPERTIES

Speci- fication	Type	Grade	CHEMICAL COMPOSITION								MECHANICAL PROPERTIES								Remarks Impact / Hardness	
			C		Mn		P	S	Si		YIELD STRENGTH		TENSILE STRENGTH				% Elongation (min) e			
			Min	Max	Min	Max	Max	Max	Min	Max	PSI	Mpa	PSI	Mpa	PSI	Mpa		PSI		Mpa
IS:2416 Pt-IV	ERW	310	0.08	0.25	0.35	1.40	0.050	0.050	-	0.35	-	152	-	-	-	304	-	402	(100 - RM / 9.81) / C C=2.20 RM = Measured T.S.	
		360	0.08	0.25	0.35	1.40	0.050	0.050	-	0.35	-	177	-	-	-	353	-	451		
		440	0.08	0.25	0.35	1.40	0.050	0.050	-	0.35	-	201	-	-	-	402	-	500		
IS:11714 Pt-III	ERW	-	0.06	0.18	0.27	0.63	0.035	0.035	-	0.25	-	-	-	-	-	-	-	-	77 HRB (Max)	
IS:1914 Pt-IV	ERW	320	0.08	0.25	0.35	1.40	0.050	0.050	-	0.35	-	176	-	-	-	320	-	480	(100 - RM / 9.81) / C C=2.20 RM = Measured T.S.	
		360	0.08	0.25	0.35	1.40	0.050	0.050	-	0.35	-	198	-	-	-	360	-	500		
		440	0.08	0.25	0.35	1.40	0.050	0.050	-	0.35	-	242	-	-	-	440	-	580		
BS:1387	ERW	-	-	0.20	-	1.20	0.045	0.045	-	-	-	195	-	-	-	320	-	460	12 UPTO 25 mm NB 20 ABOVE 25 mm	
BS:3059 Part-I	ERW	320	-	0.16	0.30	0.70	0.040	0.040	-	0.35	-	195	-	-	-	320	-	480	25	
BS:3059 Part-II	ERW	360	-	0.17	0.40	0.80	0.035	0.035	0.10	0.35	-	235	-	-	-	360	-	500	24	
		440	0.12	0.18	0.90	1.20	0.035	0.035	0.10	0.35	-	245	-	-	-	480	-	580	21	
BS:6323 Part-V	ERW	ERW-1	-	0.13	-	0.60	0.050	0.050	-	-	-	200	-	-	-	300	-	-	D/a < 2 0 D/a > 20/10 10 20 8 15 7 12	
		ERW-2	-	0.16	-	0.70	0.050	0.050	-	-	-	250	-	-	-	340	-	-		
		ERW-3	-	0.20	-	0.90	0.050	0.050	-	0.35	-	300	-	-	-	400	-	-		
ASTM A-53	ERW	A	-	0.25	-	0.95	0.050	0.045	-	-	30,000	205	-	-	48,000	330	-	-	$e = 625,000 A^{0.2} / U^{0.9}$ at GL 50.8 mm	
		B	-	0.30	-	1.20	0.050	0.045	-	-	35,000	240	-	-	60,000	415	-	-		
ASTM A-178	ERW	A	0.06	0.18	0.27	0.63	0.035	0.035	-	-	26,000	180	-	-	47,000	325	-	-	35	
		C	-	0.35	-	0.80	0.035	0.035	-	-	37,000	255	-	-	60,000	415	-	-	30	
ASTM-A-214	ERW	-	-	0.18	0.27	0.63	0.035	0.035	-	-	-	-	-	-	-	-	-	-	72 HRB (Max)	
IBR	ERW	W C1	-	0.16	0.30	0.70	0.040	0.040	-	0.35	-	195	-	-	-	320	-	480	25	
		W C2	-	0.17	0.40	0.80	0.035	0.035	0.10	0.35	-	235	-	-	-	360	-	500	24	
		W C3	0.12	0.18	0.90	1.20	0.035	0.035	0.10	0.35	-	245	-	-	-	440	-	580	21	
RDSO (ETI / OHE /11)	ERW	YST-310	-	-	-	-	0.060	0.060	-	-	-	310	-	-	-	440	-	-	14	Exp-7.5% fo ID

ERW Boiler, Super Heater, Heat Exchanger, Condenser & Air Heater Tubes & Pipes

Conforming to BS 3059(Pt-I & II), BS 6323 (Pt-V), ASTM, A-178, A-214, IS 2416 (Pt-IV).

Out side Diameter (mm)	Conventional Mass per Unit length in kg/m for a Tube Thickness in mm of:																									
	2.03	2.34	2.64	2.95	3.25	3.38	3.56	3.66	3.68	3.91	4.06	4.50	5.16	5.49	5.74	6.02	6.35	6.55	7.04	7.11	7.80	7.92	8.18	8.38	9.27	9.52
33.4 / 33.7	1.59	1.81	2.02	2.24	2.44	2.53	-	2.71	-	-	2.97	3.24	-	-	-	-	-	-	-	-	-	-	-	-	-	-
38.0	1.80	2.06	2.30	2.55	2.79	-	-	3.10	-	-	3.40	3.72	-	-	-	-	-	-	-	-	-	-	-	-	-	-
42.2 / 42.4	-	2.31	2.59	2.87	3.14	-	3.41	3.50	-	-	3.84	4.21	-	-	-	-	-	-	-	-	-	-	-	-	-	-
44.5	-	2.43	2.73	3.02	3.31	-	-	3.69	-	-	4.05	4.44	-	-	-	-	-	-	-	-	-	-	-	-	-	-
48.3	-	2.65	2.97	3.30	3.61	-	-	4.03	4.05	-	4.43	4.86	-	-	-	-	-	-	-	-	-	-	-	-	-	-
50.8	-	2.80	3.14	3.48	3.81	-	-	4.25	-	-	4.68	5.06	-	-	-	-	-	-	-	-	-	-	-	-	-	-
57.2	-	-	3.55	3.95	4.32	-	-	4.83	-	-	5.32	5.85	-	-	-	-	-	-	-	-	-	-	-	-	-	-
60.3	-	-	3.75	4.17	4.57	-	-	5.11	-	5.44	5.63	6.19	-	-	-	-	-	-	-	-	-	-	-	-	-	-
63.5	-	-	3.96	4.40	4.83	-	-	5.40	-	-	5.85	6.55	-	-	-	-	-	-	-	-	-	-	-	-	-	-
73.0	-	-	-	-	-	-	-	-	-	-	-	-	8.63	-	-	-	-	-	-	-	-	-	-	-	-	-
76.1	-	-	-	5.32	5.84	-	-	6.54	-	-	7.21	7.95	-	-	-	-	-	-	-	-	-	-	-	-	-	-
88.9	-	-	-	-	6.86	-	-	7.69	-	-	8.49	9.37	-	11.29	-	-	-	-	-	-	-	-	-	-	-	-
101.6	-	-	-	-	-	-	-	8.84	-	-	9.77	10.78	-	-	13.57	-	-	-	-	-	-	-	-	-	-	-
114.3	-	-	-	-	-	-	-	-	-	-	11.04	12.18	-	-	-	16.07	-	-	-	-	-	-	-	-	-	-
127.0	-	-	-	-	-	-	-	-	-	-	-	13.59	-	-	-	-	-	-	-	-	-	-	-	-	-	-
141.3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	21.77	-	-	-	-	-	-	-	-
168.3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	28.26	-	-	-	-	-	-
219.1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	33.31	-	36.31	-	-	-	42.55	-	-	-
273.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	41.75	-	-	-	51.01	-	-	-	60.29	-
323.8	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	49.71	-	-	-	-	-	-	65.18	-	73.78
355.6	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	54.69	-	-	-	-	-	67.90	-	-	81.25

NOTE: (i) Leak Test - hydro Test / NDT test as per specification requirements.

NOTE: Refer current editions of Relevant Specification for Dimension and Properties data. Specifications are subject to change without any prior notice

A= Speciman crosssectional area
U= Specified Min. T.S.



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