



TECHNICAL DATA OF TUBES CONFORMING TO AS:1074

SCOPE Steel Tubes and Tubulars for ordinary service i.e. threaded steel tubes and tubulars, and plain end steel tubes of specified size DN 15 to DN 150. Three designated series Light, Medium and Heavy. Stringent requirement of specific nature are provided as specified by purchaser.

TOLERANCES

Outside Diameter and Tolerances as per below Table

Thickness Light Series : -8% / +Unlimited; Medium & Heavy Series : -10% / +Unlimited

Weight -8% & +10% (for single tube)

Mechanical Properties Yield Strength : 195 MPa Min ; Tensile Strength : 320 to 460 MPa ; Elongation : 20% Min

Chemical Properties Phosphorous : 0.045 % Max ; Sulphur : 0.045 % Max ; Carbon Equivalent : 0.40 % Max

Ductility Test For Tubes upto & including 2"

Black Tube Bending angle: 180° ; Bending radius : 6 times to the OD of Tube; Weld Position : 3 O'clock

Galvanized Tube Bending angle: 90° ; Bending radius : 8 times to the OD of Tube; Weld Position : 3 O'clock

Ductility Test For Tubes above 2"

1. Flatten upto 75% of tube dia for weld test (Weld at 3 O'clock position)

2. Flatten upto 60% of tube dia for raw material test

Leak Tightness Test 100% Hydrotesting at 5 MPa or online eddy current testing or ultrasonic testing

Galvanizing Test As per AS 4792

Threading As per AS 1722-1

Size		Class	O.D. (mm)		Thick. (mm)	Weight (Plain End) (Kg/mtr.)	Weight (Socketed) (Kg/mtr.)	Pcs per Bundle
DN	Inch		Min	Max				
15	½"	L	21.0	21.4	2.00	0.947	0.956	217
20	¾"	L	26.4	26.9	2.30	1.380	1.390	127
25	1"	L	33.2	33.8	2.60	1.980	2.000	91
32	1¼"	L	41.9	42.5	2.60	2.540	2.570	61
40	1½"	L	47.8	48.4	2.90	3.230	3.270	61
50	2"	L	59.6	60.2	2.90	4.080	4.150	37
65	2½"	L	75.2	76.0	3.20	5.710	5.830	37
80	3"	L	87.9	88.7	3.20	6.720	6.890	19
100	4"	L	113.0	113.9	3.60	9.750	10.000	19
15	½"	M	21.1	21.7	2.60	1.210	1.220	217
20	¾"	M	26.6	27.2	2.60	1.560	1.570	127
25	1"	M	33.4	34.2	3.20	2.410	2.430	91
32	1¼"	M	42.1	42.9	3.20	3.100	3.130	61
40	1½"	M	48.0	48.8	3.20	3.570	3.610	61
50	2"	M	59.8	60.8	3.60	5.030	5.100	37
65	2½"	M	75.4	76.6	3.60	6.430	6.550	37
80	3"	M	88.1	89.5	4.00	8.370	8.540	19
100	4"	M	113.3	114.9	4.50	12.200	12.500	19
125	5"	M	138.7	140.6	5.00	16.600	17.100	13
150	6"	M	164.1	166.1	5.00	19.700	20.300	10
15	½"	H	21.1	21.7	3.20	1.440	1.450	217
20	¾"	H	26.6	27.2	3.20	1.870	1.880	127
25	1"	H	33.4	34.2	4.00	2.940	2.960	91
32	1¼"	H	42.1	42.9	4.00	3.800	3.830	61
40	1½"	H	48.0	48.8	4.00	4.380	4.420	61
50	2"	H	59.8	60.8	4.50	6.190	6.260	37
65	2½"	H	75.4	76.6	4.50	7.930	8.050	37
80	3"	H	88.1	89.5	5.00	10.300	10.500	19
100	4"	H	113.3	114.9	5.40	14.500	14.800	19
125	5"	H	138.7	140.6	5.40	17.900	18.400	13

150	6"	H	164.1	166.1	5.40	21.300	21.900	10
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