



TECHNICAL DATA OF TUBES CONFORMING TO AS:1074

SCOPE Steel Tubes and Tubulars for ordinary service.

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 and 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 inline 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 |