



TECHNICAL DATA OF NON ALLOY WELDED TUBES CONFORMING TO EN 10217-1

SCOPE : Welded Tubes of Circular Cross Sections made of Non-Alloy Quality Steel for pressure purposes and with specified room temperature properties.

TOLERANCES :

- Outside Diameter : ± 1% or ± 0.50 mm whichever is greater
- Thickness : ± 10% or ± 0.30 mm whichever is greater
- Length : As mutually agreed with Client
- Straightness : Less than 1 mm per meter
- End Finish : Plain Ends (Square Cut); Roll Grooved

IN-PROCESS TESTING

- In-Line NDT : Full body for NPS 1/2" to 4" and Weld Seam for NPS 3" to 8" tested by Eddy Current Test Machine
- Hydrostatic Test : All pipes hydrostatically tested at pressure 7.0 MPa for holding time 5 seconds minimum
- Flattening Test : Weld located either 0° or 90° from the direction of force
 Flatten until the distance H between plates reaches the value calculated by formula: $H = (1+C) \times T / \{C+(T/D)\}$;
 Where C - 0.09 for steel grade P195TR1&2 & P235TR1&2; C - 0.07 for steel grade P265TR1&2; D - Diameter; T - Thickness; C - Constant
- Drift Expanding : Applicable for Diameter not greater than 150mm and thickness not greater than 10.00 mm.
 Tube specimen expanded with a 60° conical tool until the required percentage increase in diameter is reached

STEEL GRADE	CHEMICAL COMPOSITION (%)														MECHANICAL PROPERTIES						
	C	Si	Mn	P	S	Cr	Mo	Ni	Al	Cu	Nb	Ti	V	Cr+Cu+Mo+Ni	YS Mpa	UTS Mpa	El (%) Min		Impact (J) Min Avg.		
	Max	Max	Max	Max	Max	Max	Max	Max	Min	Max	Max	Max	Max	Max	Min	--	Long.	Trans.	0°C Long.	-10°C Long.	0°C Trans.
P195 TR1	0.130	0.350	0.700	0.025	0.020	0.300	0.080	0.300	--	0.300	0.010	0.040	0.020	0.700	195	320-440	27	25	--	--	--
P195 TR2	0.130	0.350	0.700	0.025	0.020	0.300	0.080	0.300	0.020	0.300	0.010	0.040	0.020	0.700	195	320-440	27	25	40	28	27
P235 TR1	0.160	0.350	1.200	0.025	0.020	0.300	0.080	0.300	--	0.300	0.010	0.040	0.020	0.700	235	360-500	25	23	--	--	--
P235 TR2	0.160	0.350	1.200	0.025	0.020	0.300	0.080	0.300	0.020	0.300	0.010	0.040	0.020	0.700	235	360-500	25	23	40	28	27
P265 TR1	0.200	0.400	1.400	0.025	0.020	0.300	0.080	0.300	--	0.300	0.010	0.040	0.020	0.700	265	410-570	21	19	--	--	--
P265 TR2	0.200	0.400	1.400	0.025	0.020	0.300	0.080	0.300	0.020	0.300	0.010	0.040	0.020	0.700	265	410-570	21	19	40	28	27

WORKMANSHIP : All pipes are finished with Black Lacquer Coating or Galvanizing (EN 10240 / EN ISO 1461)

MARKING : Each Pipe shall be stencilled as per EN 10217-1 / Client Requirement: "TIGER/MADE IN UAE EN 10217-1 GRADE ----- / SIZE---/LENGTH---"

Value Addition: We are limiting the out-of-roundness upto 0.5%D and Straightness 1 mm per meter