



TECHNICAL DATA OF PIPES CONFORMING TO ASTM F1083

SCOPE : Welded Galvanized Steel Pipes in NPS 1" (33.4mm) to NPS 8" (219.1mm) in Nominal Wall Thicknesses.

TOLERANCES

Outside Diameter : -1/64"/+1/32" (-0.40/+0.80mm) for size upto & including NPS 1-1/2" and $\pm 1\%$ of the specified O.D. for NPS 2" & above
 Thickness : Minimum wall thickness 12.5% max under the specified wall thickness and not specified on positive side
 Weight : $\pm 10\%$ of specified weight
 Length : 1.2 to 8.0 Mtr (4FT to 25FT)
 Straightness : The finished pipe shall be reasonably straight.
 End Finish : Plain Ends (Square Cut); unless otherwise specified

IN-PROCESS TESTING

Bend Test : For upto NPS 2"
 Bending Angle 90° and Bending Diameter 12 times the O.D. of pipe (No crack on body and weld)
 Flattening Test : For above NPS 2" (Weld located either 0° or 90° from the direction of force)
 Flatten upto 2/3 of O.D. for weld, upto 1/3 of O.D. for body and Full flattening for lamination

GRADE	CHEMICAL COMPOSITION (%) Max. (Informative only)										MECHANICAL PROPERTIES (MPa) Min.		
	C	Mn	P	S	Cr	Cu	Ni	Mo	V	Cr+Cu+Ni+Mo+V	YS	UTS	%El
Regular	0.250	0.950	0.045	0.045	0.400	0.400	0.400	0.150	0.080	1.00	205	330	To be calculated as per formula
High Strength	0.300	1.200	0.045	0.045	0.400	0.400	0.400	0.150	0.080	1.00	345	415	

WORKMANSHIP : As per ASTM F1083, all pipes are finished with Galvanizing (as per ASTM A90 / A123) and free of defects.

MARKING : Each pipe shall be stenciled as per ASTM F1083 / Client Requirement
 "TIGER/MADE IN U.A.E. ASTM F1083 NPS --" SCH NO--- GRADE HEAT NO.----- LENGTH----- "

Value Addition: We are limiting the diameter tolerance upto $\pm 0.50\%D$ and Straightness 1 mm per meter