



TECHNICAL DATA OF TUBES CONFORMING TO EN 10255:2004+A1:2007

SCOPE : Circular non-alloy steel tubes suitable for welding and threading of specified outside diameter 21.3 mm to 165.1 mm

TOLERANCES :

Outside Diameter as per Dimension Table

Thickness :	Medium	Heavy	Light L	Light L1	Light L2
	±10%	±10%	±10%	-8%	-8%

Weight : ±7.5% for M, H & L series (on lot) and +10%/-8% for L1 & L2 series

Mechanical Properties

Yield Strength : 195 MPa (Minimum)
 Tensile Strength : 320 to 520 Mpa
 % Elongation : 20% Minimum

Chemical Properties

Carbon : 0.20 % Max
 Manganese : 1.40 % Max
 Phosphorous : 0.035 % Max
 Sulphur : 0.030 % Max

Bend Test For Tubes upto and including 2"

Black Tube

Bending angle : 90°
 Bending radius : As per EN 10255
 Weld Position : Outside of the bend

Galvanized Tube

Bending angle : 90°
 Bending radius : 8 times to the OD of Tube
 Weld Position : Outside of the bend

Flattening Test For Tubes above 2"

1. Flatten upto 75% of tube dia for weld test (Weld at 12 or 3 o'clock position)
2. Flatten upto 60% of tube dia for raw material test

Leak Tightness Test 100% Hydrotesting at 50 bar for at least 5 seconds or On-line Eddy Current Testing

Galvanizing Test As per EN 10240 / EN ISO 1461

Threading As per EN 10226-1

WORKMANSHIP : All Tubes are finished with Bare, Black Lacquer Coated or Galvanizing (EN 10240 / EN ISO 1461)

MARKING : Each Pipe shall be stencilled as per EN 10255 / Client Requirement

"TIGER/MADE IN UAE M W EN 10255 S195T SIZE-----/LENGTH-----HEAT NO-----"

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



DIMENSION TABLE - EN 10255:2004+A1:2007

Nominal Size			Class	Outside Diameter (mm)		Thick. (mm)	Weight (PE) (Kg/Mtr)	Weight (PE) (Kg/FT)	Weight (TS) (Kg/Mtr)	Weight (TS) (Kg/FT)	Length (PE) (Mtr/Ton)	Length (PE) (FT/Ton)	Length (TS) (Mtr/Ton)	Length (TS) (FT/Ton)	Pcs per Bundle
OD	DN	Inch		Min	Max										
21.3	15	1/2	L1	21.0	21.7	2.30	1.080	0.329	1.090	0.332	925.9	3037.8	917.4	3009.9	160
26.9	20	3/4	L1	26.4	27.1	2.30	1.390	0.424	1.400	0.427	719.4	2360.3	714.3	2343.5	110
33.7	25	1	L1	33.2	34.0	2.90	2.200	0.671	2.220	0.677	454.5	1491.3	450.5	1477.9	80
42.4	32	1 1/4	L1	41.9	42.7	2.90	2.820	0.860	2.850	0.869	354.6	1163.4	350.9	1151.2	61
48.3	40	1 1/2	L1	47.8	48.6	2.90	3.240	0.988	3.280	1.000	308.6	1012.6	304.9	1000.3	51
60.3	50	2	L1	59.6	60.7	3.20	4.490	1.369	4.560	1.390	222.7	730.7	219.3	719.5	37
76.1	65	2 1/2	L1	75.2	76.3	3.20	5.730	1.747	5.850	1.783	174.5	572.6	170.9	560.8	27
88.9	80	3	L1	87.9	89.4	3.60	7.550	2.301	7.720	2.353	132.5	434.5	129.5	425.0	24
114.3	100	4	L1	113.0	114.9	4.00	10.800	3.292	11.100	3.383	92.6	303.8	90.1	295.6	16
21.3	15	1/2	L2	21.0	21.4	2.00	0.947	0.289	0.956	0.291	1056.0	3464.5	1046.0	3431.8	160
26.9	20	3/4	L2	26.4	26.9	2.30	1.380	0.421	1.390	0.424	724.6	2377.4	719.4	2360.3	110
33.7	25	1	L2	33.2	33.8	2.60	1.980	0.604	2.000	0.610	505.1	1657.0	500.0	1640.4	80
42.4	32	1 1/4	L2	41.9	42.5	2.60	2.540	0.774	2.570	0.783	393.7	1291.7	389.1	1276.6	61
48.3	40	1 1/2	L2	47.8	48.4	2.90	3.230	0.985	3.270	0.997	309.6	1015.7	305.8	1003.3	51
60.3	50	2	L2	59.6	60.2	2.90	4.080	1.244	4.150	1.265	245.1	804.1	241.0	790.6	37
76.1	65	2 1/2	L2	75.2	76.0	3.20	5.710	1.740	5.830	1.777	175.1	574.6	171.5	562.8	27
88.9	80	3	L2	87.9	88.7	3.20	6.720	2.048	6.890	2.100	148.8	488.2	145.1	476.2	24
114.3	100	4	L2	113.0	113.9	3.60	9.750	2.972	10.000	3.048	102.6	336.5	100.0	328.1	16
21.3	15	1/2	L	21.0	21.7	2.30	1.080	0.329	1.090	0.332	925.9	3037.8	917.4	3009.9	160
26.9	20	3/4	L	26.4	27.1	2.30	1.400	0.427	1.410	0.430	714.3	2343.5	709.2	2326.8	110
33.7	25	1	L	33.2	34.0	2.90	2.200	0.671	2.220	0.677	454.5	1491.3	450.5	1477.9	80
42.4	32	1 1/4	L	41.9	42.7	2.90	2.820	0.860	2.850	0.869	354.6	1163.4	350.9	1151.2	61
48.3	40	1 1/2	L	47.8	48.6	2.90	3.250	0.991	3.290	1.003	307.7	1009.5	304.0	997.2	51
60.3	50	2	L	59.6	60.7	3.20	4.510	1.375	4.580	1.396	221.7	727.5	218.3	716.3	37
76.1	65	2 1/2	L	75.2	76.0	3.20	5.750	1.753	5.870	1.789	173.9	570.6	170.4	558.9	27
88.9	80	3	L	87.9	88.7	3.20	6.760	2.060	6.930	2.112	147.9	485.3	144.3	473.4	24
114.3	100	4	L	113.0	113.9	3.60	9.830	2.996	10.100	3.078	101.7	333.8	99.0	324.8	16
139.7	125	5	L	138.5	140.8	4.50	15.000	4.572	15.500	4.724	66.7	218.7	64.5	211.7	10
165.1	150	6	L	163.9	166.5	4.50	17.800	5.425	18.400	5.608	56.2	184.3	54.3	178.3	7
21.3	15	1/2	M	21.0	21.8	2.60	1.210	0.369	1.220	0.372	826.4	2711.4	819.7	2689.2	130
26.9	20	3/4	M	26.5	27.3	2.60	1.560	0.475	1.570	0.479	641.0	2103.1	636.9	2089.7	100
33.7	25	1	M	33.3	34.2	3.20	2.410	0.735	2.430	0.741	414.9	1361.3	411.5	1350.1	65
42.4	32	1 1/4	M	42.0	42.9	3.20	3.100	0.945	3.130	0.954	322.6	1058.3	319.5	1048.2	51
48.3	40	1 1/2	M	47.9	48.8	3.20	3.560	1.085	3.600	1.097	280.9	921.6	277.8	911.3	44
60.3	50	2	M	59.7	60.8	3.60	5.030	1.533	5.100	1.554	198.8	652.3	196.1	643.3	30
76.1	65	2 1/2	M	75.3	76.6	3.60	6.420	1.957	6.540	1.993	155.8	511.0	152.9	501.7	24
88.9	80	3	M	88.0	89.5	4.00	8.360	2.548	8.530	2.600	119.6	392.4	117.2	384.6	19
114.3	100	4	M	113.1	115.0	4.50	12.200	3.719	12.500	3.810	82.0	268.9	80.0	262.5	14
139.7	125	5	M	138.5	140.8	5.00	16.600	5.060	17.100	5.212	60.2	197.6	58.5	191.9	10
165.1	150	6	M	163.9	166.5	5.00	19.800	6.035	20.400	6.218	50.5	165.7	49.0	160.8	7
21.3	15	1/2	H	21.0	21.8	3.20	1.440	0.439	1.450	0.442	694.4	2278.4	689.7	2262.6	110
26.9	20	3/4	H	26.5	27.3	3.20	1.870	0.570	1.880	0.573	534.8	1754.5	531.9	1745.1	80
33.7	25	1	H	33.3	34.2	4.00	2.930	0.893	2.950	0.899	341.3	1119.7	339.0	1112.1	55
42.4	32	1 1/4	H	42.0	42.9	4.00	3.790	1.155	3.820	1.164	263.9	865.7	261.8	858.9	44
48.3	40	1 1/2	H	47.9	48.8	4.00	4.370	1.332	4.410	1.344	228.8	750.8	226.8	744.0	37
60.3	50	2	H	59.7	60.8	4.50	6.190	1.887	6.260	1.908	161.6	530.0	159.7	524.1	27
76.1	65	2 1/2	H	75.3	76.6	4.50	7.930	2.417	8.050	2.454	126.1	413.7	124.2	407.6	20
88.9	80	3	H	88.0	89.5	5.00	10.300	3.139	10.500	3.200	97.1	318.5	95.2	312.5	16
114.3	100	4	H	113.1	115.0	5.40	14.500	4.420	14.800	4.511	69.0	226.3	67.6	221.7	12
139.7	125	5	H	138.5	140.8	5.40	17.900	5.456	18.400	5.608	55.9	183.3	54.3	178.3	10
165.1	150	6	H	163.9	166.5	5.40	21.300	6.492	21.900	6.675	46.9	154.0	45.7	149.8	7