

# Welded/Seamless pipe according to UNE EN 10255-M (DIN 2440)

Unalloyed steel tubes are supplied. The symbolic and numerical designation, as well as the values that must be met in the corresponding **Tensile Tests** to which they are subjected:

Steel designation		Tensile test		
Symbolic	Numerical	Upper yield strength ReH min. for a wall thickness T (mm)	Tensile strength Rm	Elongation A min%
		Mpa*	Mpa*	min %
SI95T	I,0026	195	320 a 520	20

\* 1 Mpa = 1 N/mm<sup>2</sup>

The **Chemical Composition** of the welded steel pipe will be according to the requirements of the table shown below:

Steel designation		C	Mn	P	S
Symbolic	Numerical	% máx.	% máx.	% máx.	% máx.
		P235TRI	I,0254	0,20	1,40

This Standard presents a **Table of Dimensions - Masses / Length Unit - Diameter and Thickness Tolerances** referring to the manufactured pipe used in our production process:

External diameter	Wall thickness	Tolerances in the External diameter		Mass per unit length of black pipe
		mm. (máx)	mm. (mín)	Kg/m.
mm.	mm.			
33,7	3,20	34,2	33,3	2,43
42,4	3,20	42,9	42,0	3,13
48,3	3,20	48,8	47,9	3,60
60,3	3,60	60,8	59,7	5,10
76,1	3,60	76,6	75,3	6,54
88,9	4,00	89,5	88,0	8,53
114,3	4,50	115,0	113,1	12,50
139,7	5,00	140,8	138,5	17,10
165,1	5,00	166,5	163,9	20,40



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For the M series welded pipe of the standard, the **Wall Thickness Tolerance** is  $\pm 10\%$ , while for the seamless pipe of this M series of the standard, the tolerance is  $\pm 12.5\%$ .

In the case of welded pipe, the longitudinal weld bead must be ground to a smooth surface finish. The height of this bead must not exceed 60% of the specified pipe wall thickness.

The tubes will be supplied in a standard length, unless the buyer requests another length. The **standard length** will be **6 meters** or **6.40 meters**.

Length Type	Length (L)	Tolerance in Length	
		Welded pipe	Seamless pipe
	m.	mm.	
Standard Lengths	6 m or 6,4 m	[+ 150 mm , - 50 mm]	[± 500 mm]
Random Lengths	4 m ≤ L ≤ 16 m With a range of 2 m, per order line.	Up to 10% of the supplied tubes may be shorter than requested length, but cannot be shorter than 75% of the minimum length range	
Exact Lengths	L ≤ 6 m	[+ 10 mm , 0 mm]	
	6 m < L ≤ 12 m	[+ 15 mm , 0 mm]	
	L > 12 m	[+by agreement, 0 mm]	

For pipes with a diameter equal to or greater than 33.7 mm, the **Total Deviation** of straightness (arrow) with respect to any length of the tube L, where L is the length supplied by the manufacturer, must not exceed 0.002 L.

The **Tolerance for Ovality Defect** is included in the diameter tolerance.

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