

**GAS AND WATER SEAMLESS, PLAIN ENDS, BLACK TUBES****1. Standards**

- DIN 2440 (has been replaced with EN 10255);
- DIN 2441 (has been replaced with EN 10255);
- UNI 8863 (has been replaced with EN 10255);
- NFA 49-115 (has been replaced with EN 10255);
- STAS 7656 (has been replaced with EN 10255);
- EN 10255.

2. Used for:

- Construction of long distance Pipe Lines for combustible liquids and gases;
- Conveying gas and oil; in oil and natural gas industries.

3. Dimensions

According Tab.1, Tab. 2 and Tab. 3.

4. Tolerances

Standard	Outside Diameter	Wall Thickness	Weight
DIN 2440	Acc Tab.2	-12.5%	+/-10% for single lengths +/-7.5% for carload lots
DIN 2441	Acc Tab.3	-12.5%	+/-10% for single lengths +/-7.5% for carload lots
EN 10255	Acc Tab.1,Tab.2, Tab.3	+/-12.5%	+/-7.5%
STAS 7656	Acc Tab.1	+/-12.5%	+/-10% for single lengths +/-7.5% for carload lots

5. Chemical Composition (%)

Steel group	C max	Mn max	Si max	S max	P max
St 33.2, OL32, OL37, OL44					
Fe 330	0.17	0.65		0.040	0.040
S195T	0.20	1.40		0.030	0.035

6. Mechanical Properties

Steel group	Tensile Strength	Yield Strength min.	Elongation
	MPa	MPa	%
St 33.2, OL32, OL37, OL44	290÷510	185	18
Fe 330	330÷520	210	22
S195T	320÷520	195	20

7. Lengths

- Random lengths: 5÷7 m;
- Fixed lengths within the random lengths range;
- Tolerances: +100/-0 mm.

8. Surface treatment

- Black.

9. Designation

- Regular type.

10. Marking

According to standard or per customer request.

11. Delivery

In bundles up to 4000 kg (8800 lbs) tied in minimum six places with steel strip.

Quantity tolerances: $\pm 5\%$ per size or / and per total.

12. Mill test report

Mill test reports are issued to customer requirements.

Usually they comply with DIN 50049, EN 10204.

13. Quality certified

LR, TUV, PED, CE, DNV, GL, MLPTL.

Tab.1 Thin-weight (type L1), EN 10255, UNI 8863, STAS 7656

DN	Connecting nominal width of the fittings	OD			WT
		<i>Nom</i>	<i>min</i>	<i>max</i>	
		<i>Mm</i>	mm	mm	
15	1/2	21.3	21.0	21.7	2.3
20	3/4	26.9	26.4	27.1	2.3
25	1	33.7	33.2	34.0	2.9
32	1 1/4	42.4	41.9	42.7	2.9
40	1 1/2	48.3	47.8	48.6	2.9
50	2	60.3	59.6	60.7	3.2
65	2 1/2	76.1	75.2	76.3	3.2
80	3	88.9	87.9	89.4	3.6
100	4	114.3	113.0	114.9	4.0

Tab. 2 Medium-weight (type M), EN 10255, DIN 2440, STAS 7656

DN	Connecting nominal width of the fittings	OD			WT
		<i>nom</i>	<i>min</i>	<i>max</i>	
		mm	mm	mm	
15	1/2	21.3	21.0	21.8	2.6
20	3/4	26.9	26.5	27.3	2.6
25	1	33.7	33.3	34.2	3.2
32	1 1/4	42.4	42.0	42.9	3.2
40	1 1/2	48.3	47.9	48.8	3.2
50	2	60.3	59.7	60.8	3.6
65	2 1/2	76.1	75.3	76.6	3.6
80	3	88.9	88.0	89.5	4.0
100	4	114.3	113.1	115.0	4.5

Tab.3 Heavy-weight (tipe H), EN 10255, DIN 2441, STAS 7656

DN	Connecting nominal width of the fittings	OD			WT
		<i>Nom</i>	<i>min</i>	<i>max</i>	
		<i>Mm</i>	mm	mm	
15	1/2	21.3	21.0	21.8	3.2
20	3/4	26.9	26.5	27.3	3.2
25	1	33.7	33.3	34.2	4.0
32	1 1/4	42.4	42.0	42.9	4.0
40	1 1/2	48.3	47.9	48.8	4.0
50	2	60.3	59.7	60.8	4.5
65	2 1/2	76.1	75.3	76.6	4.5
80	3	88.9	88.0	89.5	5.0
100	4	114.3	113.1	115.0	5.4