



LINE PIPE WITH PLAIN ENDS

1. Standards

- API Spec 5L;
- ASTM A 53;
- EN 10208-1;
- EN 10208-2.

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 and Tab.2

4. Tolerances

Standard	Outside Diameter	Wall Thickness	Weight
API 5L	±0.75%	+15/-12.5%	+10/-3.5% for single lengths -1.75% for carload lots
ASTM A 53	±1%	-12.50%	±10% of the pipe
EN 10208-1 and EN 10208-2	±0.75%	+15/-12.5%	+10/-3.5% of the pipe

5. Chemical Composition (%)

Steel group	C max	Mn max	Si max	S max	P max	V max	Nb max	Ti max
Grade A, L210GA	0.21	0.90	0.40	0.030	0.030			
Grade B, L245GA	0.20	1.15	0.40	0.030	0.030			
L245NB	0.16	1.10	0.40	0.020	0.025			
L290NB	0.17	1.20	0.40	0.020	0.025	0.05	0.05	0.04
L360NB	0.20	1.60	0.45	0.020	0.025	0.10	0.05	0.04
L415NB	0.21	1.60	0.45	0.020	0.025	0.15	0.05	0.04

6. Mechanical Properties

Steel group	Tensile Strength	Yield Strength min.	Elongation	Min impact energy	
	PSI (MPa)	PSI (MPa)		J	°C
Grade A, L210GA	min.48000(331)	min 30000(207)	acc.to the wall tickness		
Grade B, L245GA	min.60000(414)	min.35000(241)			
L245NB	415	245÷440	22	60	0
L290NB	415	290÷440	21	60	0
L360NB	460	360÷510	20	60	0
L415NB	520	415÷565	18	60	0

7. Lengths

Standard	Nominal Length	Min. Length		Average Length		Max. Length	
		ft	m	ft	m	ft	m
API 5L	20ft (6m)	16	4.88	17.5	5.33	22.5	6.86
	40ft (12m)	22	6.71	35.0	10.67	39.4	12.00
ASTM A 53	random lengths: 6÷12m (19.7÷39.3ft) fixed lengths within the random lengths range tubes under 6m (19.7ft) will delivered as multiple lengths tolerances: +100/0 mm (+3.94/0 in)						
EN 10208-1 and EN 10208-2	26.2ft (8m)	19.7	6	21.1	8.5	22.5	11
	36.1ft (11m)	29.5	9	34.45	10.5	39.4	12.00

8. Protection

- Unprotected;
- External varnished with black or clear lacquer;
- If required, the plain end pipes can be delivered with plastic caps at both ends.

9. Marking

According to standard or per customer request.

10. Delivery

In bundles up to 4000 kg (8800 lbs) tied in minimum six places with steel strip.
Quantity tolerances: ±5% per size or / and per total.

11. Mill test report

Mill test reports are issued to customer requirements. Usually they comply with DIN 50049, EN 10204.

12. Quality certified

LR, API 5L, TUV , PED.

Tab.1 Dimensions - Line pipe HOT ROLLING ASSEL MILL

Nominal	OD		WT		Weight		L max		Identification		
	in	mm	in	mm	lb/ft	kg/m	ft	m	API	STD/XS/XXS	Sch.
2 1/2	2.874	73	0.276	7.01	7.67	11.41	26.2	8	5L	XS	80
			0.375	9.53	10.02	14.92	26.2	8			160
			0.552	14.02	13.70	20.39	26.2	8	5L	XXS	
3	3.500	88.9	0.250	6.35	8.69	12.93	26.2	8	5L		
			0.281	7.14	9.67	14.40	26.2	8	5L		
			0.300	7.62	10.26	15.27	26.2	8	5L	XS	80
			0.438	11.13	14.34	21.35	26.2	8			160
			0.600	15.24	18.60	27.68	26.2	8	5L	XXS	
3 1/2	4.000	101.6	0.250	6.35	10.02	14.92	26.2	8	5L		
			0.281	7.14	11.17	16.63	26.2	8	5L		
			0.318	8.08	12.52	18.64	26.2	8	5L	XS	80
4	4.500	114.3	0.250	6.35	11.36	16.91	40.0	12.2	5L		
			0.281	7.14	12.67	18.87	40.0	12.2	5L		
			0.312	7.92	13.97	20.78	39.4	12	5L		
			0.337	8.56	15.00	22.32	39.4	12	5L	XS	80
			0.438	11.13	19.02	28.32	36.1	11	5L		120
			0.531	13.49	22.53	33.54	32.8	10	5L		160
			0.674	17.12	27.57	41.03	27.9	8.5	5L	XXS	
5	5.563	141.3	0.258	6.55	14.63	21.77	40.0	12.2	5L	STD	40
			0.281	7.14	15.87	23.62	40.0	12.2	5L		
			0.312	7.92	17.51	26.05	39.4	12	5L		
			0.344	8.74	19.19	28.57	39.4	12	5L		
			0.375	9.53	20.80	30.97	36.1	11	5L	XS	80
			0.500	12.70	27.06	40.28	32.8	10	5L		120
			0.625	15.88	32.99	49.12	29.5	9	5L		160
			0.750	19.50	38.59	58.57	26.2	8	5L	XXS	
6	6.625	168.3	0.280	7.11	18.99	28.26	40.0	12.2	5L	STD	40
			0.312	7.92	21.06	31.33	39.4	12	5L		
			0.344	8.74	23.10	34.39	37.7	11.5	5L		
			0.375	9.53	25.05	37.31	36.1	11	5L		
			0.432	10.97	28.60	42.56	36.1	11	5L	XS	80
			0.500	12.70	32.74	48.73	32.8	10	5L		
			0.562	14.27	36.43	54.21	29.5	9	5L		120
			0.625	15.88	40.09	59.69	27.9	8.5	5L		
			0.719	18.26	45.39	67.57	26.2	8	5L		160
			0.750	19.05	47.10	70.12	26.2	8	5L		
			0.864	21.95	53.21	79.22	26.2	8		XXS	
8	8.625	219.1	0.719	18.26	60.77	90.44	27.9	8.5	5L		120
			0.750	19.05	63.14	93.98	27.9	8.5	5L		
			0.812	20.62	67.82	100.93	27.9	8.5	5L		140
			0.875	22.23	72.49	107.93	27.9	8.5	5L	XXS	
			0.906	23.01	74.76	111.27	27.9	8.5			160
			1.000	25.40	81.51	121.33	26.2	8	5L		

Note: 1. For sizes with OD/WT > 12.5 it is necessary to consult the supplier at ordering time;
2. Lengths: 5÷7m or 10÷12m.

Tab.2 Dimensions - Line pipe HOT ROLLING CPE MILL

Nominal	OD		WT		Weight		Lmax		Identification		
	in	mm	in	mm	lb/ft	kg/m	ft	m	API	STD/XS/XXS	Sch.
1/2	0.840	21.3	0.109	2.77	0.85	1.27	29.5	9	5L	STD	40
			0.147	3.73	1.09	1.62			5L	XS	80
3/4	1.050	26.7	0.113	2.87	1.13	1.69	29.5	9	5L	STD	40
			0.154	3.91	1.48	2.20			5L	XS	80
1	1.315	33.4	0.133	3.38	1.68	2.50	29.5	9	5L	STD	40
			0.179	4.55	2.17	3.24			5L	XS	80
			0.250	6.35	2.85	4.24					160
1 1/4	1.660	42.2	0.140	3.56	2.27	3.39	29.5	9	5L	STD	40
			0.191	4.85	3.00	4.47			5L	XS	80
			0.250	6.35	3.77	5.61					160
1 1/2	1.900	48.3	0.145	3.68	2.72	4.05	39.4	12	5L	STD	40
			0.200	5.08	3.63	5.41			5L	XS	80
			0.281	7.14	4.86	7.25					160
2	2.375	60.3	0.154	3.91	3.66	5.44	39.4	12	5L	STD	40
			0.172	4.37	4.05	6.03			5L		
			0.188	4.78	4.40	6.54			5L		
			0.218	5.54	5.03	7.48			5L	XS	80
			0.250	6.35	5.68	8.45			5L		
			0.344	8.74	6.29	11.11					160
2 1/2	2.875	73.0	0.216	5.49	6.14	9.14	39.4	12	5L	STD	40
			0.250	6.35	7.02	10.44					160
			0.276	7.01	7.67	11.41			5L	XS	80
3	3.500	88.9	0.216	5.49	7.58	11.29	39.4	12	5L	STD	40
			0.300	7.62	10.26	15.27			5L	XS	80
			0.438	11.13	14.34	21.35					160
3 1/2	4.000	101.6	0.226	5.74	9.12	13.57	39.4	12	5L	STD	40
			0.318	8.08	12.52	18.64			5L	XS	80
4	4.500	114.3	0.237	6.02	10.80	16.08	39.4	12	5L	STD	40
			0.337	8.56	15.00	22.32			5L	XS	80
			0.438	11.13	19.02	28.32					120

Note: Lengths: 6m or 9m or 12m