

ASTM A 795 - 04

SCHEDULE 10 GRADE A										
		Outside Dia. of Black / Galvanized Tube						Weight of Tube		
SIZE		Minimum		Maximum		Wall thickness		Plain Ends		Pieces
INCH	NB (mm)	Inches	mm	Inches	mm	Inches	mm	lb./Ft.	Kg./Mtr.	per bundle
3/4"	20	1.020	25.90	1.070	27.10	0.083	2.11	0.860	1.280	120
1"	25	1.283	32.60	1.330	33.80	0.109	2.77	1.410	2.090	84
1 1/4"	32	1.630	41.40	1.680	42.60	0.109	2.77	1.810	2.690	61
1 1/2"	40	1.870	47.50	1.920	48.70	0.109	2.77	2.090	3.110	42
2"	50	2.350	59.70	2.400	60.90	0.109	2.77	2.640	3.930	37
2 1/2"	65	2.850	72.30	2.900	73.70	0.120	3.05	3.530	5.260	29
3"	80	3.465	88.00	3.530	89.80	0.120	3.05	4.340	6.460	19
3 1/2"	90	3.960	100.60	4.040	102.60	0.120	3.05	4.980	7.410	19
4"	100	4.450	113.20	4.540	115.40	0.120	3.05	5.620	8.370	14
5"	125	5.510	139.90	5.620	142.70	0.134	3.40	7.780	11.580	7
6"	150	6.560	166.60	6.690	169.98	0.134	3.40	9.300	13.850	7

1. TOLERANCE

- :a) On Thickness : The minimum wall thickness at any point shall be not more than 12.5% under the nominal wall thickness specified.
- : b) On Diameter :For NPS 11/2" & under at any point shall not vary more than + 0.4mm - 0.8mm. For NPS 2" & aboves shall not vary more than +/-1% from the standard specified.
- : c) On Weight: The weight of the pipe shall not vary by more than +/- 5% of the specified value.

2. ENDS

Each end of the pipe shall be furnished plain end unless otherwise specified.

3. PROPERTIES

- :a) Chemical = (Maximum) C - 0.25%, Mn - 0.95%, S - 0.035% & P - 0.035%,
- :b) Mechanical (Minimum) = UTS - 330 N/mm², YS - 205 N/mm² & %Elongation 25 to 30% .

4. FLATTENING TEST (COLD)

- : Weld located at 0 degrees / 90 degrees from the line of direction of source.
- a) During the 1st step, which is a test for ductility of the weld, no cracks or breaks in the inside or outside surfaces at the weld shall occur until the distance between the plates is less than two thirds of the specified diameter of the pipe.
- b) During the 2nd step, no cracks or breaks on the inside or outside surfaces away from the weld, shall occur until the distance between the plates is less than one third of the specified outside diameter of the pipe but is less than five times the wall thickness of the pipe.

c) During the 3rd step, which is a test for soundness, flattening shall be continued until the test specimen breaks or the opposite walls of the pipe meet. Evidence of laminated or unsound material or of incomplete weld that is revealed by the flattening test shall be cause for rejection.

5. LEAK TIGHTNESS TEST

: a) Online NDT (Eddy current)
b) Hydro test at a pressure of 700 PSI to 1200 PSI

6. BLACK VARNISH

: Tubes are uniformly varnished externally over their full lengths.

**7. ZINC COATING
(GALVANIZING)**

: Average 460 Gm/M², but one side should not be less than 400 Gm/M². Free from bare spots, black spots, rough, overcoating, peel off or any other surface defects.

8. THREADING

: For 1/2" to 3/4" - 14 TPI, 1" to 2" - 11.5 TPI and 2 1/2" to 6" = 8 TPI.
Check with standard ASTM ring and plug gauges.

9. MARKING

We can do online by stencilling as per this standard & as per customer needs at one meter interval.

10. PACKING

: Hexagonal type.

11. MILL TEST CERTIFICATE

: We can issue a MTC, certifying that the tubes supplied comply with this ASTM A 795 Standard.