

Common Name of Specification

Carbon steel Seamless pipes IBR	ASTM 106 Grade B	Low temp. seamless Pipes	ASTM A333 Grade 6
Carbon steel seamless boiler tube	BS/3059/78/Part II / CDS/360	Low temp. seamless Tubes	ASTM A 334 Grade 1
	BS/3059/78/Part II / HFS/360	Heat Exchanger Tubes	ASTM A 179/ASTM A 214
ERW boiler tubes IBR	BS/3059/1978/Part I ERW/360	API Line Pipes	API 5 L Grade B
CDW boiler tubes IBR	BS/3059/1978/Part I CEW/360	M.S.E.R.W. Pipes	IS 1239 Part - 1-1979
Alloy steel seamless pipes	ASTM 335-P-1, P-5, P-11, P-22, P-9	Hot Dipped, GI Pipes	IS 1239 Part - 1-1979
Alloy steel seamless tubes	ASTM 213-T-11, T-22, T-5	Big Dia ERW Pipes	IS 3589/330 or 410
	ASTM 209 T-1, 209 T-1a	Square & Rectangle Section	ISS 4923/ASTM-A 500
	DIN 17175 Grade 3 15MO3	General Engineering Tubes	BSS 1775, IS 3074/4711/3601
	ASTM 200 P-4, P-11, P-22, P-9	ERW Air heater tubes	BS 1775 or BS/6323/V12-NZF-1982
	ASTM 199 P-4, P-11, P-22, P-9		

Quality		Chemical Analysis									Mechanical Properties			Specific Requirement
SMLS	Weled	Specification	WT	C%	Mn%	P% Max	S% Max	Si%	Cr%	Mo%	Tensile Strength Mpa	Yield Stress Mpa	Elongation in 50 mm Min Longitudinal	
Carbon Steel Pipes / Tubes Conform to Various Specifications as listed below														
*	*	ASTM A53/A	AW	0.25 Max	0.95 Max	0.050	0.060	---	----	----	331 Min	207 Min	36	---
*	*	ASTM A53/B	AW	0.30 Max	1.20 Max	0.050	0.060	---	----	----	413 Min	240 Min	29.5	----
	*	ASTM A 106/A	AW	0.25 Max	0.27-0.93	0.025	0.025	0.10 Min	0.40 Max	0.15 Max	330 Min	205 Min	35/28	Cr,MO, Cu, Ni, VA
		ASTM A 106/B	AW	0.30 Max	0.29-1.06	0.025	0.025	0.10 Min	0.40 Max	0.15 Max	415 Min	240 Min	30/22	.40, .15,.40,.40, .08
		ASTM A 106/C	AW	0.35 Max	0.29-1.06	0.025	0.025	0.10 Min	0.40 Max	0.15 Max	485 Min	275 Min	30/22	Five Elements not to exceed
*	---	ASTM A179	MW	0.06-0.18	0.27-0.63	0.048	0.048	-----	----	----	325 Min	180 Min	35.0	Hardness 75HRB Max
---	*	ASTM A214	MW	0.18 Max	0.27-0.63	0.050	0.050	----	-----	----	385 Min	180 Min	35.0	Hardness 75HRB Max
*	---	ASTM A192	MW	0.06-0.18	0.27-0.63	0.048	0.048	0.25 Max	-----	-----	325 Min	180 Min	35.0	Hardness 77HRB Max
*	*	ASTM A333/1	AW	0.30 Max	0.40-1.06	0.025	0.025	-----	---	----	380 Min	205 Min	25/20	Impact Test-50F40x10J14

*	*	ASTM A333/6	AW	0.30 Max	0.29- 1.06	0.025	0.025	0.10 Min	----	----	415 Min	240 Min	30/18	Impact Test- 50F40x10J14
*	*	ASTM A334/1	MW	0.30 Max	0.40- 1.06	0.025	0.025	----	---	----	380 Min	205 Min	35/28	-50F40x14 85HRB Max
*	*	ASTM A334/6	MW	0.30 Max	0.29- 1.06	0.025	0.025	0.10 Min	----	----	415 Min	240 Min	30/22	-50F40x14 85HRB Max
*	*	BS/3059/90/Part I/320		0.16 Max	0.30- 0.70	0.040	0.040	----	----	---	320-480	186 Min	25	----
*	*	BS/3059/90/Part II/360		0.17 Max	0.40- 0.80	0.035	0.035	0.10- 0.35	---	----	360-500	235 Min	21	-----
*	----	BS/3059/90/Part II/440		0.12- 0.18	0.90- 1.20	0.035	0.035	0.10- 0.35	----	----	480-560	245 Min	22	---
*	---	ASTM A210/A-1	MW	0.27 Max	0.93 Max	0.048	0.058	0.10 Min	---	----	415 Min	255 Min	30/22	Hardness 79HRB Max
*	---	ASTM A210/C	MW	0.35 Max	0.29- 1.06	0.048	0.058	0.10 Min	----	----	485 Min	275 Min	30/22	Hardness 89HRB Max
*	---	DIN/17175/ST35.8		0.17 Max	0.40- 0.80	0.040	0.040	0.35 Max	---	----	340-480	235 Min	25	---
*	----	DIN/17175/ST45.8		0.22 Max	0.40- 1.20	0.040	0.040	0.10- 0.35	----	----	410-540	255 Min	21	---
*	---	DIN2391ST 35	AW	0.17 Max	0.40 Min	0.25	0.25				340-470	235 Min	25	
*	---	DIN2391ST 45	AW	0.21 Max	0.40 Min	0.25	0.25				440-570	255 Min	21	
*	---	DIN2391ST 52	AW	0.22 Max	1.60 Max	0.25	0.25				490-630	355 Min	22	
---	*	ASTM A178/A	MW	0.06- 0.18	0.27- 0.63	0.050	0.050	0.50- 1.00	---	---	325 Min	172 Min	30/22	----
---	*	ASTM A178/C	MW	0.35 Max	0.80 Max	0.035	0.035	---	---	---	415 Min	255 Min	35	-----
---	*	ASTM A178/D	MW	0.27 Max	1.00- 1.50	0.050	0.050	0.10 Min	---	----	485 Min	180 Min	30	-----
---	*	BS 6323PartV/1	AW	0.13 Max	0.60 Max	0.050	0.050				300 Min	200 Min	10/20	
---	*	BS 6323PartV/2	AW	0.16 Max	0.70 Max	0.050	0.050				340 Min	250 Min	8/15	
---	*	BS 6323PartV/3	AW	0.20 Max	0.90 Max	0.050	0.050	0.35 Max			400 Min	300 Min	7/12	
PSL- 1	---	API 5L GR.A-25	AW	0.21 Max	0.60 Max	0.030	0.030				310 Min	172 Min		SMLS C% .21 Max
PSL- 1	PSL-1	API 5L GR.A	AW	0.22 Max	0.90 Max	0.030	0.030				331 Min	207 Min	Si Unit e=1944 A02 / U09	SMLS C% .22 Max
PSL- 1	PSL-1	API 5L GR.B	AW	0.26 Max	1.20 Max	0.030	0.030				414 Min	241 Min		

																		SMLS C% .28 Max	
PSL-1	PSL-1	API 5L GR.X-42	AW	0.26 Max	1.30 Max	0.030	0.030					414 Min	290 Min						
																		SMLS C% .28 Max	
PSL-1	PSL-1	API 5L GR.X—46	AW	0.26 Max	1.40 Max	0.030	0.030					434 Min	317 Min						
																		SMLS C% .28 Max	
PSL-1	PSL-1	API 5L GR.X-52	AW	0.26 Max	1.40 Max	0.030	0.030					455 Min	359 Min					SMLS C% .28 Max	
PSL-1	PSL-1	API 5L GR.X-56	AW	0.26 Max	1.40 Max	0.030	0.030					490 Min	386 Min					SMLS C% .28 Max	
PSL-1	PSL-1	API 5L GR.X-60	AW	0.26 Max	1.40 Max	0.030	0.030					517 Min	414 Min					SMLS C% .28 Max	
PSL-1	PSL-1	API 5L GR.X-65	AW	0.26 Max	1.45 Max	0.030	0.030					531 Min	448 Min					SMLS C% ---	
PSL-1	PSL-1	API 5L GR.X-70	AW	0.26 Max	1.65 Max	0.030	0.030					565 Min	483 Min						
																		C.E. Impact Energy	
																		PCM IIW J FT/LB	
PSL-2	PSL-2	API 5L GR. B	AW	0.22 Max	1.20 Max	0.025	0.015					414-758	241-448	Si Unit e=1944 A02 / U09				0.25 0.43 T/L27/41 T/L20/30	
PSL-2	PSL-2	API 5L GR.X-42	AW	0.22 Max	1.30 Max	0.025	0.015					414-758	290-496						0.25 0.43 T/L27/41 T/L20/30
PSL-2	PSL-2	API 5L GR.X-46	AW	0.22 Max	1.40 Max	0.025	0.015					434-758	317-524						0.25 0.43 T/L27/41 T/L20/30
PSL-2	PSL-2	API 5L GR.X-52	AW	0.22 Max	1.40 Max	0.025	0.015					455-758	359-531						0.25 0.43 T/L27/41 T/L20/30
PSL-2	PSL-2	API 5L GR.X-52	AW	0.22 Max	1.40 Max	0.025	0.015					455-758	359-531						0.25 0.43 T/L27/41 T/L20/30
PSL-2	PSL-2	API 5L GR.X-56	AW	0.22 Max	1.40 Max	0.025	0.015					490-758	386-544						0.25 0.43 T/L27/41 T/L20/30 0.25 0.43 T/L27/41 T/L20/30
PSL-2	PSL-2	API 5L GR.X-60	AW	0.22 Max	1.40 Max	0.025	0.015					517-758	414-565						0.25 0.43 T/L27/41 T/L20/30
---	PSL-2	API 5L GR.X-65	AW	0.22 Max	1.45 Max	0.025	0.015					531-758	448-565						0.25 0.43 T/L27/41 T/L20/30
----	PSL-2	API 5L GR.X-70	AW	0.22 Max	1.65 Max	0.025	0.015					565-758	483-565					0.25 0.43 T/L27/41 T/L20/30	
*	*	IS1978/YST 210	AW	0.22 Max	0.90 Max	0.040	0.050					330 Min	210 Min						
*	*	IS1978/YST 240	AW	0.27 Max	1.15 Max	0.040	0.050					410 Min	240 Min						

		IS1979/YST 290	AW	0.28 Max	1.25 Max	0.040	0.050			410 Min	290 Min	E= 1942.57 A02 / U09				
		IS1979/YST 320	AW	0.30 Max	1.35 Max	0.040	0.050			430 Min	320 Min					
		IS1979/YST 360	AW	0.30 Max	1.35 Max	0.040	0.050			450-550	360 Min					
		IS1979/YST 390	AW	0.26 Max	1.35 Max	0.040	0.050			490-520	390 Min					
		IS1979/YST 410	AW	0.26 Max	1.35 Max	0.040	0.050			520-540	410 Min					
		IS1979/YST 450	AW	0.26 Max	1.40 Max	0.040	0.050			530-550	450 Min					
		IS1979/YST 480	AW	0.23 Max	1.60 Max	0.040	0.050			565 Min	480 Min					
--	*	IS 3589 Gr. 330	AW	0.16 Max	1.20 Max	0.040	0.050			330 Min	195 Min	20GL= 5.65				
---	*	IS 3589 Gr. 410	AW	0.20 Max	1.30 Max.	0.040	0.050			410 Min	235 Min	18GL= 5.65				
----	*	IS 3589 Gr. 450	AW	0.25 Max	1.20 Max	0.040	0.050			450 Min	275 Min	15GL= 5.65				
--	*	IS 1161/YST210	AW	0.12 Max	0.60 Max	0.050	0.050			330 Min	210 Min	20GL= 5.65				
--	*	IS 1161/YST240	AW	0.16 Max	1.20 Max	0.050	0.050			410 Min	240 Min	17GL= 5.65				
--	*	IS 1161/YST310	AW	0.25 Max	1.30 Max	0.050	0.050			450 Min	310 Min	14GL= 5.65				



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