

BLACK AND GALVANISED STEEL TUBES (for use in Water, Gas & Air Lines) Conforming to IS 1239(Part-I) 2004, Equivalent to BS 1387/1985

Nominal Bore & Series		Outside Diameter		Wall thickness		Nominal Mass of Steel Tubes				Socket	
		Max.	Min.			Plain end		Screwed & Socketed		Min OD	Min Length
mm	inch.	mm	mm	mm	SWG	kg/mtr	mtr/mt	kg/mtr	mtr/mt	mm	mm
15 L M H	0.50	21.4	21.0	2.0	14	0.947	1056	0.956	1046	27.0	37.0
	0.50	21.8	21.0	2.6	12	1.21	826	1.22	820	27.0	37.0
	0.50	21.8	21.0	3.2	10	1.44	694	1.45	690	27.0	37.0
20 L M H	0.75	26.9	26.4	2.3	13	1.38	725	1.39	719	32.5	39.0
	0.75	27.3	26.5	2.6	12	1.56	641	1.57	637	32.5	39.0
	0.75	27.3	26.5	3.2	10	1.87	535	1.88	532	32.5	39.0
25 L M H	1.00	33.8	33.2	2.6	12	1.98	505	2.00	500	39.5	46.0
	1.00	34.2	33.3	3.2	10	2.41	415	2.43	412	39.5	46.0
	1.00	34.2	33.3	4.0	8	2.93	341	2.95	339	39.5	46.0
32 L M H	1.25	42.5	41.9	2.6	12	2.54	394	2.57	389	49.5	51.0
	1.25	42.9	42.0	3.2	10	3.10	323	3.13	319	49.5	51.0
	1.25	42.9	42.0	4.0	8	3.79	264	3.82	262	49.5	51.0
40 L M H	1.50	48.4	47.8	2.9	11	3.23	310	3.27	306	56.0	51.0
	1.50	48.8	47.9	3.2	10	3.56	281	3.60	278	56.0	51.0
	1.50	48.8	47.9	4.0	8	4.37	229	4.41	227	56.0	51.0
50 L M H	2.00	60.2	59.6	2.9	11	4.08	245	4.15	241	68.0	60.0
	2.00	60.8	59.7	3.6	9	5.03	199	5.10	196	68.0	60.0
	2.00	60.8	59.7	4.5	7	6.19	162	6.26	160	68.0	60.0
65 L M H	2.50	76.0	75.2	3.2	10	5.71	175	5.83	172	84.0	69.0
	2.50	76.6	75.3	3.6	9	6.42	156	6.54	153	84.0	69.0
	2.50	76.6	75.3	4.5	7	7.93	126	8.05	124	84.0	69.0
80 L M H	3.00	88.7	87.9	3.2	10	6.72	149	6.89	145	98.0	75.0
	3.00	89.5	88.0	4.0	8	8.36	120	8.53	117	98.0	75.0
	3.00	89.5	88.0	4.8	6	9.90	101	10.10	99	98.0	75.0
100 L M H	4.00	113.9	113.0	3.6	9	9.75	103	10.00	100	124.0	87.0
	4.00	115.0	113.1	4.5	7	12.20	82	12.50	80	124.0	87.0
	4.00	115.0	113.1	5.4	5	14.50	69	14.80	68	124.0	87.0
125M H	5.00	140.8	138.5	4.8	6	15.90	63	16.40	61	151.0	96.0
	5.00	140.8	138.5	5.4	5	17.90	56	18.40	54	151.0	96.0
150M H	6.00	166.5	163.9	4.8	6	18.90	53	19.50	51	178.0	96.0
	6.00	166.5	163.9	5.4	5	21.30	47	21.90	46	178.0	96.0

TOLERANCE

Class	Thickness	Weight		Length Unless otherwise specified
		Single Tube	Per Load of 10 MT Min	
Light	+ Not Limited	+ 10 %	+ 7.5 %	4 to 7 meters
	- 8.00 %	- 8 %	- 5 %	
Medium & Heavy	+ Not Limited	+ 10 %	+ 7.5 %	
	- 10.00 %	+ 10 %	+ 7.5 %	

SPECIFICATION OF STEEL TUBES FOR WATER AND SEWAGE

Conforming to IS - 3589(2001)

N.B.	O.D.	Thickness	Calculated Weight	Calculated Meters	
inch	mm	mm	kg/mtr	mtr/ton	
8"	219.1	4.00	21.22	47.13	
	219.1	4.60	24.33	41.10	
	219.1	5.00	26.40	37.88	
	219.1	5.60	29.48	33.92	
	219.1	6.00	31.53	31.72	
	219.1	6.35	33.31	30.02	
	219.1	7.00	36.61	27.31	
	219.1	7.30	38.11	26.24	
	219.1	8.00	41.63	24.02	
	219.1	8.65	44.87	22.29	
	219.1	9.20	47.60	21.01	
	219.1	9.50	49.08	20.37	
10"	273.0	4.50	29.80	33.56	
	273.0	5.00	33.05	30.26	
	273.0	5.60	36.93	27.08	
	273.0	6.00	39.51	25.31	
	273.0	6.35	41.76	23.95	
	273.0	7.00	45.92	21.78	
	273.0	7.30	47.81	20.92	
	273.0	8.00	52.26	19.14	
	273.0	8.65	56.37	17.74	
	273.0	9.20	59.82	16.72	
	273.0	9.50	61.71	16.20	
	12"	323.9	5.00	39.30	25.45
323.9		5.60	43.96	22.75	
323.9		6.00	47.04	21.26	
323.9		6.35	49.34	20.27	
323.9		7.00	54.70	18.28	
323.9		7.30	56.97	17.55	
323.9		8.00	62.32	16.05	
323.9		8.65	67.22	14.88	
323.9		9.20	71.37	14.01	
323.9		9.50	73.62	13.58	
14"		355.6	5.00	43.21	23.14
		355.6	5.60	48.33	20.69
	355.6	6.00	51.73	19.33	
	355.6	6.35	54.26	18.43	
	355.6	7.00	60.17	16.62	
	355.6	7.30	62.67	15.96	
	355.6	8.00	68.57	14.58	
	355.6	8.65	74.42	13.44	
	355.6	9.20	78.56	12.73	
	355.6	9.50	81.05	12.34	

N.B.	O.D.	Thickness	Calculated Weight	Calculated Meters	
inch	mm	mm	kg/mtr	mtr/ton	
16"	406.4	5.00	49.47	20.21	
	406.4	5.60	55.35	18.07	
	406.4	6.00	59.24	16.88	
	406.4	6.35	62.16	16.09	
	406.4	7.00	68.94	14.51	
	406.4	7.30	71.84	13.92	
	406.4	8.00	78.59	12.72	
	406.4	8.65	84.81	11.79	
	406.4	9.20	90.08	11.10	
	406.4	9.50	92.94	10.76	
	18"	457.0	5.00	55.71	17.95
		457.0	5.60	62.34	16.04
457.0		6.00	66.73	14.99	
457.0		6.35	70.20	14.25	
457.0		7.00	77.68	12.87	
457.0		7.30	80.92	12.36	
457.0		8.00	88.58	11.29	
457.0		8.65	95.60	10.46	
20"	508.0	5.00	61.99	16.13	
	508.0	5.60	69.38	14.41	
	508.0	6.00	74.27	13.46	
	508.0	6.35	77.94	12.83	
	508.0	7.00	86.48	11.56	
	508.0	7.30	90.10	11.10	
	508.0	8.00	98.64	10.14	
	508.0	8.65	107.12	9.34	
	508.0	9.20	113.12	8.84	
	508.0	9.50	116.74	8.57	

STEEL TUBES FOR MECHANICAL & GENERAL ENGINEERING

Confirming to IS: 3601 - 2006

OD	Thickness	Mass
mm	mm	kg/mtr
21.3	1.8	0.866
	2.0	0.952
	2.6	1.200
	3.2	1.430
	4.0	1.710
26.9	1.8	1.110
	2.0	1.230
	2.3	1.400
	2.6	1.560
	3.2	1.870
	4.0	2.260
33.7	2.0	1.560
	2.3	1.780
	2.6	1.990
	3.2	2.410
	4.0	2.930
	4.5	3.240
33.7	2.0	1.560
	2.3	1.780
	2.6	1.990
	3.2	2.410
	4.0	2.930
42.4	2.3	2.270
	2.6	2.550
	3.2	3.090
	3.6	3.440
	4.0	3.790
48.3	5.0	4.610
	5.4	4.930
	2.3	2.610
	2.6	2.930
	2.9	3.250
	3.2	3.560
60.3	3.6	3.970
	4.0	4.370
	4.9	5.240
	5.0	5.340
	5.6	5.900
	5.9	6.160
	2.3	3.290
2.6	3.700	
2.9	4.110	
3.2	4.510	
3.6	5.030	
4.0	5.550	
4.5	6.190	
5.0	6.820	
5.6	7.550	
6.3	8.390	

OD	Thickness	Mass
mm	mm	kg/mtr
76.1	2.6	5.240
	2.9	5.750
	3.2	6.440
	3.6	7.110
	4.5	7.950
	5.0	8.770
	5.4	9.420
	6.3	10.800
76.1	7.1	12.100
	2.6	5.240
	2.9	5.750
	3.2	6.440
	3.6	7.110
88.9	4.5	7.950
	5.0	8.770
	5.4	9.420
	6.3	10.800
	7.1	12.100
	2.9	6.150
	3.2	6.760
	4.0	8.380
101.6	5.0	10.300
	5.4	11.100
	5.6	11.500
	6.3	12.800
	8.0	16.000
	3.6	8.700
101.6	4.0	9.630
	5.0	11.900
	3.2	8.770
114.3	3.6	9.830
	4.5	12.200
	5.4	14.500
	6.3	16.800
	8.0	21.000
	8.8	22.900
127	4.5	13.600
	5.0	15.000
	5.4	16.200
	3.6	12.100
139.7	4.0	13.400
	4.5	15.000
	5.0	16.600
	5.4	17.900
139.7	6.3	20.700
	8.0	26.000
	8.0	26.000
	10.0	32.000
	10.0	32.000

OD	Thickness	Mass
mm	mm	kg/mtr
152.4	4.5	16.400
	5.0	18.200
	5.4	19.600
165.1	4.5	17.800
	5.0	19.700
	5.4	21.200
168.3	6.3	24.800
	4.0	16.200
	4.5	18.200
	5.0	20.100
193.7	5.4	21.700
	6.3	25.200
	7.1	28.200
	8.0	31.600
	11.0	42.700
	5.0	23.300
219.1	5.4	25.100
	5.9	27.300
	6.3	29.100
	8.0	36.600
244.5	4.5	23.800
	5.0	26.400
	5.6	29.500
	6.3	33.100
	8.0	41.600
273	12.5	63.700
	5.9	34.200
	7.1	41.700
273	8.0	46.100
	5.0	33.000
	6.3	41.400
	7.1	46.600
273	10.0	64.900

Manufacturing Tolerance			
S.no.	Over	Up to and including	Tolerance on O.D
	mm	mm	mm
1	-	25.4	+ 0.15
2	25.4	51	+ 0.18
3	51	63.5	+ 0.25
4	63.5	76.1	+ 0.25
5	76.1	88.9	+ 0.31
6	88.9	101.6	+ 0.36
7	101.6	114.3	+ 0.43
8	114.3	152.4	+ 0.58
9	152.4	168.3	+ 0.65
10	168.3	0	+ 0.75

Manufacturing Tolerance	
Sulphur & Phosphorous	maximum 0.040%

STEEL TUBES MECHANICAL AND GENERAL ENGINEERING COMMERCIAL PIPES

OD in MM	WALL THICKNESS												
	1.00	1.20	1.40	1.60	1.80	2.00	2.20	2.50	2.90	3.20	3.60	4.00	4.30
	Weight in Kgs per meter												
21.30	0.501	0.595	0.687	0.778	-	-	-	-	-	-	-	-	-
26.90	0.639	0.760	0.880	0.998	-	-	-	-	-	-	-	-	-
33.70	0.806	0.962	1.115	1.267	1.417	-	-	-	-	-	-	-	-
42.40	1.021	1.220	1.415	1.610	1.802	1.993	2.225	-	-	-	-	-	-
48.30	1.166	1.393	1.620	1.843	2.063	2.283	2.551	-	-	-	-	-	-
60.30	-	1.748	2.033	2.317	2.597	2.875	3.215	-	-	-	-	-	-
76.10	-	-	2.578	2.940	3.298	3.655	4.090	4.628	-	-	-	-	-
88.90	-	-	-	3.445	3.867	4.287	4.798	5.433	-	-	-	-	-
114.30	-	-	-	4.447	4.993	5.538	6.204	7.031	7.833	-	-	-	-
139.70	-	-	-	-	-	6.792	7.609	8.628	9.783	10.772	-	-	-
165.10	-	-	-	-	-	8.043	9.015	10.225	11.600	12.777	14.337	15.892	17.052

TOLERANCE

Outside Diameter		Tolerance	Thickness	
Over mm	Upto to including mm			
-	25.40	+ 0.15	+ 10%	- 8 %
25.40	51.00	+ 0.18	+ 10%	- 8 %
51.00	63.50	+ 0.25	+ 10%	- 8 %
63.50	76.10	+ 0.25	+ 10%	- 8 %
76.10	88.90	+ 0.31	+ 10%	- 8 %
88.90	101.60	+ 0.36	+ 10%	- 8 %
101.60	114.30	+ 0.43	+ 10%	- 8 %
114.30	152.40	+ 0.58	+ 10%	- 8 %
152.40	168.30	+ 0.65	+ 10%	- 8 %
168.3	-	+ 0.75	+ 10%	- 8 %