

SPIRAL SAW PIPES (IS-3589, Gr-Fe 410)

Weight in Kgs. Per Running Meter & its Corresponding Test Pressure

OD Inch/mm	16" (406.4)		18" (457.2)		20" (508)		22" (558.8)		24" (609.6)		26" (660.41)	
	WT in mm	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.
5.0	49.49	35	55.76	31	62.02	28	68.28	26	74.55	24	80.81	22
5.5	54.37	39	61.26	35	68.15	31	75.04	28	81.93	26	88.82	24
6.0	59.24	42	66.76	38	74.28	34	81.79	31	89.31	28	96.83	26
6.5	64.10	46	72.24	41	80.39	37	88.53	33	96.67	31	104.81	28
7.0	68.94	50	77.71	44	86.48	40	95.25	36	104.02	33	112.79	30
7.5	73.78	51	83.17	47	92.57	42	101.96	39	111.36	35	120.75	33
8.0	78.60	51	88.62	50	98.64	45	108.66	41	118.68	38	128.71	35
8.5	83.40	51	94.05	51	104.70	48	115.35	44	126.00	40	136.64	37
9.0	88.20	51	99.47	51	110.75	51	122.02	46	133.30	42	144.57	39
9.5	92.98	51	104.88	51	116.78	51	128.68	49	140.59	45	152.49	41
10.0	97.75	51	110.28	51	122.81	51	135.33	51	147.86	47	160.39	44
10.5	102.51	51	115.66	51	128.82	51	141.97	51	155.12	50	168.28	46
11.0	107.26	51	121.04	51	134.82	51	148.60	51	162.38	51	176.16	48
11.5	111.99	51	126.40	51	140.80	51	155.21	51	169.62	51	184.02	50
12.0	116.71	51	131.74	51	146.78	51	161.81	51	176.84	51	191.87	51
12.5	121.42	51	137.08	51	152.74	51	168.40	51	184.06	51	199.72	51
13.0	126.12	51	142.40	51	158.69	51	174.97	51	191.26	51	207.54	51
13.5	130.80	51	147.71	51	164.62	51	181.54	51	198.45	51	215.36	51
14.0	135.47	51	153.01	51	170.55	51	188.09	51	205.62	51	223.16	51
14.5	140.13	51	158.30	51	176.46	51	194.63	51	212.79	51	230.95	51
15.0	144.78	51	163.57	51	182.36	51	201.15	51	219.94	51	238.73	51
15.5	149.41	51	168.83	51	188.25	51	207.67	51	227.08	51	246.50	51
16.0	154.04	51	174.08	51	194.12	51	214.17	51	234.21	51	254.25	51
16.5	158.65	51	179.32	51	199.99	51	220.66	51	241.33	51	262.00	51
17.0	163.24	51	184.54	51	205.84	51	227.13	51	248.43	51	269.73	51
17.5	167.83	51	189.75	51	211.68	51	233.60	51	255.52	51	277.44	51
18.0	172.40	51	194.95	51	217.50	51	240.05	51	262.60	51	285.15	51
18.5	176.96	51	200.14	51	223.31	51	246.49	51	269.67	51	292.84	51
19.0	181.51	51	205.31	51	229.12	51	252.92	51	276.72	51	300.52	51
19.5	186.05	51	210.48	51	234.90	51	259.33	51	283.76	51	308.19	51
20.0	190.57	51	215.63	51	240.68	51	265.74	51	290.79	51	315.85	51
20.5	195.08	51	220.76	51	246.45	51	272.13	51	297.81	51	323.49	51
21.0	199.58	51	225.89	51	252.20	51	278.51	51	304.81	51	331.12	51
21.5	204.07	51	231.00	51	257.94	51	284.87	51	311.80	51	338.74	51
22.0	208.54	51	236.10	51	263.66	51	291.22	51	318.78	51	346.34	51
22.5	213.01	51	241.19	51	269.38	51	297.57	51	325.75	51	353.94	51
23.0	217.46	51	246.27	51	275.08	51	303.90	51	332.71	51	361.52	51
23.5	221.89	51	251.33	51	280.77	51	310.21	51	339.65	51	369.09	51
24.0	226.32	51	256.39	51	286.45	51	316.52	51	346.58	51	376.65	51
24.5	230.73	51	261.42	51	292.12	51	322.81	51	353.50	51	384.19	51
25.0	235.13	51	266.45	51	297.77	51	329.09	51	360.41	51	391.72	51

SPIRAL SAW PIPES (IS-3589, Gr-Fe 410)

Weight in Kgs. Per Running Meter & its Corresponding Test Pressure

OD Inch/mm	28" (711.2)		30" (762)		32" (812.8)		34" (863.6)		36" (914.4)		38" (965.2)	
	WT in mm	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.
5.0	87.07	20	93.34	19	99.60	18	105.87	17	112.13	16	118.39	15
5.5	95.71	22	102.60	21	109.49	19	116.38	18	123.27	17	130.16	16
6.0	104.34	24	111.86	23	119.37	21	126.89	20	134.41	19	141.92	18
6.5	112.96	26	121.10	25	129.24	23	137.38	22	145.53	20	153.67	19
7.0	121.56	28	130.33	26	139.10	25	147.87	23	156.64	22	165.40	21
7.5	130.15	30	139.54	28	148.94	27	158.34	25	167.73	24	177.13	22
8.0	138.73	32	148.75	30	158.77	28	168.79	27	178.81	25	188.84	24
8.5	147.29	34	157.94	32	168.59	30	179.24	28	189.89	27	200.53	25
9.0	155.85	36	167.12	34	178.40	32	189.67	30	200.94	28	212.22	27
9.5	164.39	38	176.29	36	188.19	34	200.09	32	211.99	30	223.89	28
10.0	172.92	40	185.44	38	197.97	35	210.50	33	223.03	31	235.55	30
10.5	181.43	42	194.59	40	207.74	37	220.89	35	234.05	33	247.20	31
11.0	189.94	44	203.72	42	217.50	39	231.28	37	245.06	35	258.84	33
11.5	198.43	46	212.83	43	227.24	41	241.65	38	256.05	36	270.46	34
12.0	206.91	49	221.94	45	236.97	42	252.01	40	267.04	38	282.07	36
12.5	215.37	51	231.03	47	246.69	44	262.35	42	278.01	39	293.67	37
13.0	223.83	51	240.11	49	256.40	46	272.69	43	288.97	41	305.26	39
13.5	232.27	51	249.18	51	266.09	48	283.01	45	299.92	42	316.83	40
14.0	240.70	51	258.24	51	275.78	50	293.32	47	310.85	44	328.39	42
14.5	249.12	51	267.28	51	285.45	51	303.61	48	321.78	46	339.94	43
15.0	257.52	51	276.32	51	295.11	51	313.90	50	332.69	47	351.48	45
15.5	265.92	51	285.33	51	304.75	51	324.17	51	343.59	49	363.00	46
16.0	274.30	51	294.34	51	314.39	51	334.43	51	354.47	50	374.52	48
16.5	282.67	51	303.34	51	324.01	51	344.68	51	365.35	51	386.02	49
17.0	291.02	51	312.32	51	333.62	51	354.91	51	376.21	51	397.50	51
17.5	299.37	51	321.29	51	343.21	51	365.13	51	387.06	51	408.95	51
18.0	307.70	51	330.25	51	352.80	51	375.34	51	397.89	51	420.44	51
18.5	316.02	51	339.19	51	362.37	51	385.54	51	408.72	51	431.89	51
19.0	324.32	51	348.13	51	371.93	51	395.73	51	419.53	51	443.33	51
19.5	332.62	51	357.05	51	381.47	51	405.90	51	430.33	51	454.76	51
20.0	340.90	51	365.95	51	391.01	51	416.06	51	441.12	51	466.17	51
20.5	349.17	51	374.85	51	400.53	51	426.21	51	451.89	51	477.57	51
21.0	357.43	51	383.73	51	410.04	51	436.35	51	462.66	51	488.96	51
21.5	365.67	51	392.61	51	419.54	51	446.47	51	473.41	51	500.34	51
22.0	373.90	51	401.46	51	429.02	51	456.58	51	484.14	51	511.70	51
22.5	382.13	51	410.31	51	438.50	51	466.68	51	494.87	51	523.06	51
23.0	390.33	51	419.15	51	447.96	51	476.77	51	505.58	51	534.40	51
23.5	398.53	51	427.97	51	457.41	51	486.85	51	516.29	51	545.72	51
24.0	406.71	51	436.78	51	466.84	51	496.91	51	526.97	51	557.04	51
24.5	414.88	51	445.58	51	476.27	51	506.96	51	537.65	51	568.34	51
25.0	423.04	51	454.36	51	485.68	51	517.00	51	548.32	51	579.63	51

SPIRAL SAW PIPES (IS-3589, Gr-Fe 410)

Weight in Kgs. Per Running Meter & its Corresponding Test Pressure

OD Inch/mm	40" (1016)		42" (1066.8)		44" (1117.6)		46" (1168.4)		48" (1219.2)		50" (1270)	
	WT in mm	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.
5.0	124.66	14	130.92	13	137.18	13	143.45	12	149.71	12	155.97	11
5.5	137.05	16	143.94	15	150.83	14	157.72	14	164.61	13	171.50	12
6.0	149.44	17	156.96	16	164.47	15	171.99	15	179.51	14	187.02	14
6.5	161.81	18	169.96	18	178.10	17	186.24	16	194.38	15	202.53	15
7.0	174.17	20	182.94	19	191.71	18	200.48	17	209.25	17	218.02	16
7.5	186.52	21	195.92	20	205.31	19	214.71	18	224.10	18	233.50	17
8.0	198.86	23	208.88	22	218.90	21	228.92	20	238.95	19	248.97	18
8.5	211.18	24	221.83	23	232.48	22	243.13	21	253.77	20	264.42	19
9.0	223.49	25	234.77	24	246.04	23	257.32	22	268.59	21	279.87	20
9.5	235.79	27	247.69	26	259.59	24	271.50	23	283.40	22	295.30	22
10.0	248.08	28	260.61	27	273.13	26	285.66	25	298.19	24	310.72	23
10.5	260.35	30	273.51	28	286.66	27	299.82	26	312.97	25	326.12	24
11.0	272.62	31	286.40	30	300.18	28	313.96	27	327.74	26	341.52	25
11.5	284.87	33	299.27	31	313.68	30	328.09	28	342.49	27	356.90	26
12.0	297.10	34	312.14	32	327.17	31	342.20	30	357.23	28	372.27	27
12.5	309.33	35	324.99	34	340.65	32	356.31	31	371.97	29	387.62	28
13.0	321.54	37	337.83	35	354.11	33	370.40	32	386.68	31	402.97	29
13.5	333.74	38	350.65	36	367.57	35	384.48	33	401.39	32	418.30	31
14.0	345.93	40	363.47	38	381.01	36	398.55	34	416.08	33	433.62	32
14.5	358.11	41	376.27	39	394.44	37	412.60	36	430.76	34	448.93	33
15.0	370.27	42	389.06	40	407.85	39	426.64	37	445.43	35	464.22	34
15.5	382.42	44	401.84	42	421.26	40	440.60	38	460.09	37	479.51	35
16.0	394.56	45	414.60	43	434.65	41	454.69	39	474.73	38	494.78	36
16.5	406.69	47	427.36	44	448.03	42	468.70	41	489.37	39	510.04	37
17.0	418.80	48	440.10	46	461.39	44	482.69	42	503.99	40	525.28	38
17.5	430.90	50	452.83	47	474.75	45	496.67	43	518.59	41	540.52	40
18.0	442.99	51	465.54	49	488.09	46	510.64	44	533.19	42	555.74	41
18.5	455.07	50	478.24	50	501.42	48	524.60	46	547.77	44	570.95	42
19.0	467.13	51	490.94	51	514.74	49	538.54	47	562.34	45	586.14	43
19.5	479.19	51	503.62	51	528.04	50	552.47	48	576.90	46	601.33	44
20.0	491.23	51	516.28	51	541.34	51	566.39	49	591.45	47	616.50	45
20.5	503.26	51	528.94	51	554.62	51	580.30	50	605.98	48	631.66	46
21.0	515.27	51	541.58	51	567.89	51	594.19	51	620.50	50	646.81	48
21.5	527.27	51	554.21	51	581.14	51	608.07	51	635.01	51	661.94	49
22.0	539.26	51	566.82	51	594.38	51	621.94	51	649.50	51	677.06	50
22.5	551.24	51	579.43	51	607.62	51	635.80	51	663.99	51	692.18	51
23.0	563.21	51	592.02	51	620.84	51	649.65	51	678.46	51	707.27	51
23.5	575.16	51	604.60	51	634.04	51	663.48	51	692.92	51	722.36	51
24.0	587.11	51	617.17	51	647.24	51	677.30	51	707.37	51	737.43	51
24.5	599.03	51	629.73	51	660.42	51	691.11	51	721.80	51	752.49	51
25.0	610.95	51	642.27	51	673.59	51	704.91	51	736.22	51	767.54	51

SPIRAL SAW PIPES (IS-3589, Gr-Fe 410)

Weight in Kgs. Per Running Meter & its Corresponding Test Pressure

OD Inch/mm	52" (1320.8)		54" (1371.6)		56" (1422.4)		58" (1473.2)		60" (1524)		62" (1574.8)		64" (1625.6)	
	WT in mm	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.	TP in kg/cm2	weight in Kg/rmtr.
5.0	162.24	11	164.80	10	174.77	10	181.03	10	187.29	9	193.56	9	199.82	9
5.5	178.39	12	181.22	12	192.17	11	199.06	11	205.95	10	212.84	10	219.73	10
6.0	194.54	13	197.62	13	209.57	12	217.09	12	224.60	11	232.12	11	239.64	11
6.5	210.67	14	214.00	14	226.95	13	235.10	13	243.24	12	251.38	12	259.53	11
7.0	226.79	15	230.38	15	244.33	14	253.10	14	261.86	13	270.63	13	279.40	12
7.5	242.89	16	246.74	16	261.69	15	271.08	15	280.48	14	289.87	14	299.27	13
8.0	258.99	17	263.09	17	279.03	16	289.05	16	299.08	15	309.10	15	319.12	14
8.5	275.07	19	279.43	18	296.37	17	307.02	17	317.66	16	328.31	16	338.96	15
9.0	291.14	20	295.76	19	313.69	18	324.96	18	336.24	17	347.51	16	358.79	16
9.5	307.20	21	312.07	20	331.00	19	342.90	19	354.80	18	366.70	17	378.60	17
10.0	323.24	22	328.37	21	348.30	20	360.83	20	373.35	19	385.88	18	398.41	18
10.5	339.28	23	344.66	22	365.58	21	378.74	20	391.89	20	405.04	19	418.20	19
11.0	355.30	24	360.94	23	382.86	22	396.64	21	410.42	21	424.20	20	437.98	19
11.5	371.30	25	377.20	24	400.12	23	414.52	22	428.93	22	443.34	21	457.74	20
12.0	387.30	26	393.46	25	417.37	24	432.40	23	447.43	23	462.46	22	477.50	21
12.5	403.28	27	409.70	26	434.60	25	450.26	24	465.92	24	481.58	23	497.24	22
13.0	419.25	28	425.92	27	451.83	26	468.11	25	484.40	25	500.68	24	516.97	23
13.5	435.21	29	442.14	28	469.04	27	485.95	26	502.86	25	519.77	25	536.68	24
14.0	451.16	30	458.34	29	486.24	28	503.77	27	521.31	26	538.85	26	556.39	25
14.5	467.09	32	474.53	30	503.42	29	521.59	28	539.75	27	557.92	26	576.08	26
15.0	483.02	33	490.71	31	520.60	30	539.39	29	558.18	28	576.97	27	595.76	27
15.5	498.92	34	506.88	32	537.76	31	557.18	30	576.59	29	596.01	28	615.43	27
16.0	514.82	35	523.03	34	554.91	32	574.95	31	595.00	30	615.04	29	635.08	28
16.5	530.71	36	539.17	35	572.05	33	592.72	32	613.39	31	634.06	30	654.73	29
17.0	546.58	37	555.30	36	589.17	34	610.47	33	631.76	32	653.06	31	674.36	30
17.5	562.44	38	571.42	37	606.28	35	628.21	34	650.13	33	672.05	32	693.98	31
18.0	578.29	39	587.52	38	623.39	36	645.93	35	668.48	34	691.03	33	713.58	32
18.5	594.12	40	603.61	39	640.47	37	663.65	36	686.82	35	710.00	34	733.18	33
19.0	609.95	41	619.69	40	657.55	38	681.35	37	705.15	36	728.95	35	752.76	34
19.5	625.76	42	635.76	41	674.61	39	699.04	38	723.47	37	747.90	36	772.33	34
20.0	641.55	44	651.81	42	691.66	40	716.72	39	741.77	38	766.83	37	791.88	35
20.5	657.34	45	667.86	43	708.70	41	734.38	40	760.06	39	785.75	37	811.43	36
21.0	673.11	46	683.89	44	725.73	42	752.04	41	778.34	40	804.65	38	830.96	37
21.5	688.88	47	699.90	45	742.74	43	769.68	42	796.61	41	823.54	39	850.48	38
22.0	704.62	48	715.91	46	759.75	44	787.31	43	814.87	42	842.43	40	869.99	39
22.5	720.36	49	731.90	47	776.73	45	804.92	44	833.11	42	861.29	41	889.48	40
23.0	736.09	50	747.88	48	793.71	46	822.52	45	851.34	43	880.15	42	908.96	41
23.5	751.80	51	763.85	49	810.68	48	840.12	46	869.55	44	898.99	43	928.43	42
24.0	767.50	51	779.81	50	827.63	49	857.69	47	887.76	45	917.83	44	947.89	42
24.5	783.19	51	795.75	51	844.57	50	875.26	48	905.95	46	936.64	45	967.34	43
25.0	798.86	51	811.68	51	861.50	51	892.82	49	924.13	47	955.45	46	986.77	44

Note:

* Above Testing pressure is conforming to IS-35879, Gr-Fe 410

* The Hydraulic test pressure shall be the pressure calculated as per the following formula : $P = 2ST/D$

Where P = hydraulic test pressure Mpa.

D= specified outside dia of the pipe in mm,

T=specified thickness of the tube in mm &

S = Stree 60% of the specified minimum yield stress in Mpa.

The maximum test pressure to be limited to 5 Mpa wherever applicable.

* Tolerance as per IS 3589 is : Wall Thickness +20% / -12.5%
Outside Diameter + 0.75 %

* Higher Test Pressure of upto 210 kgs/cm2 can also be treated upon client's specific requirement.