

ALLOY PIPES FOR HIGH TEMPERATURES

ASTM A335 - ASME SA335

Seamless pipes in low and high alloy steel

USE	In high temperature, also suitable to be curved and flanged
STEEL GRADE	P5 - P9 - P11 - P22 - P91
PROCESSING	► Seamless
MATERIAL	Steel alloys, mainly characterized by chrome-molybdenum According to the requirements of standards, the pipes shall be supplied heat treated
TOLERANCES	THICKNESS

Thickness (mm)	Tolerance %	
$10,3 < D \leq 73,0$; all ratios t/D	+20,0	-12,5
$D > 73$; t/D $\leq 5\%$	+22,5	-12,5
$D > 73$; t/D $> 5\%$	+15,0	-12,5

OUTSIDE DIAMETER

Diameter (mm)	Tolerance (mm)	
$10,3 < D \leq 48,3$	+0,40	-0,40
$48,3 < D \leq 114,3$	+0,79	-0,79
$114,3 < D \leq 219,1$	+1,59	-0,79
$219,1 < D \leq 323,8$	+2,38	-0,79
$D > 323,8$	+/- 1% of the specific outside diameter	

OUT OF ROUNDNESS

Within the tolerance limits for the outside diameter

MASS

The mass per unit of length for pipes $\leq 323,8$ mm must not vary by + 10% / - 3,5% from the values specified

For pipes $> 323,8$ mm the mass per unit of length must not vary by + 10% / - 5% from the values specified

The benchmark parameters must be identified in the ANSI B36.10 and ANSI B36.19 standards and for non-standardized sizes the following equation must be applied:

$$M = t(D - t) \times C$$

STRAIGHTNESS

- Reasonably straight

ALLOY PIPES FOR HIGH TEMPERATURES

ASTM A335 - ASME SA335

Seamless pipes in low and high alloy steel

MARKING

Pipes with $D \leq 48,3\text{mm}$ will be identified by means of a label applied to one end of the bundle

Pipes with $D > 48,3\text{mm}$ will be marked legibly 300mm from one end with the following information:

- Manufacturer's name or trademark
- Reference standard
- Steel grade
- Diameter and thickness
- Length
- Cast number
- Mark the following symbols in the cases specified below:
 - EC: eddy-current test
 - UT: ultrasonic test
 - FL: flux leakage test
 - Value of the pressure used for the hydrostatic test:
Hydrostatic test

CERTIFICATION

UNI EN 10204

SIZE

RANGE

ASME B36.10