

GAS PIPES UNI EN 10255

Seamless and welded steel pipes suitable for screwing

USE Gas and water systems or other uses in similar systems

STEEL GRADE S195T

PROCESSING

- Seamless
- Welded
- Cold drawn

TOLERANCES **THICKNESS**

- Seamless: +/-12,5%*
- Welded medium series: +/-10%
- Light series class L1 -8% / + not limited (delimited by the tolerance on the mass)

* The upper tolerance is not applicable if the actual mass of a bundle does not exceed the Kg/m theoretical mass by +7,5%

OUTSIDE DIAMETER

L1 – Light series			Mass per unit length (Kg/m)			
			Bare pipe		Galvanized pipe	
NPS	Diameter (mm)	Thickness (mm)	Plain end	Threaded and coupled	Plain end	Threaded and coupled
3/8	17,20	2,0	0,742	0,748	0,780	0,786
1/2	21,30	2,3	1,08	1,09	1,13	1,17
3/4	26,90	2,3	1,39	1,40	1,45	1,46
1	33,70	2,9	2,20	2,22	2,28	2,3
1 ¼	42,40	2,9	2,82	2,85	2,92	2,95
1 ½	48,30	2,9	3,24	3,28	3,35	3,39
2	60,30	3,2	4,49	4,56	4,63	4,7
2 ½	76,10	3,2	5,73	5,85	5,91	6,03
3	88,90	3,6	7,55	7,72	7,76	7,93
4	114,30	4,0	10,8	11,1	11,1	11,4

M – Medium series			Mass per unit length (Kg/m)			
			Bare pipe		Galvanized pipe	
NPS	Diameter (mm)	Thickness (mm)	Plain end	Threaded and coupled	Plain end	Threaded and coupled
3/8	17,20	2,3	0,839	0,845	0,876	0,882
1/2	21,30	2,6	1,21	1,22	1,26	1,27
3/4	26,90	2,6	1,56	1,57	1,62	1,63
1	33,70	3,2	2,41	2,43	2,49	2,51
1 ¼	42,40	3,2	3,10	3,13	3,20	3,23
1 ½	48,30	3,2	3,56	3,60	3,67	3,71
2	60,30	3,6	5,03	5,1	5,17	5,24
2 ½	76,10	3,6	6,42	6,54	6,6	6,72
3	88,90	4,0	8,36	8,53	8,57	8,74
4	114,30	4,5	12,20	12,50	12,48	12,80

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MASS

- Seamless:
 - +7,5% of theoretical weight
- Welded:
 - + 10%/-8% for light series class L1
 - +/-7,5% on batch of 10 tons for medium and heavy series

OUT OF ROUNDNESS

Within the outside diameter tolerance limits

STRAIGHTNESS

- $\leq 0,2\%$ on the whole length of the pipe
- This parameter is applicable for pipes with $D \geq 33,7\text{mm}$

MARKING

At a distance of 1m from one end:
manufacturer's trademark / series symbol (L1-M) / S or
W initial for manufacturing process
Each bundle must be identified with a label showing
the following minimum information:

- Manufacturer's name or trademark
- European standard number
- Manufacturing process symbol
S (seamless) or W (welded)
- D (as specific outside diameter) or
R (thread size)
- Series, type or specific wall thickness

CERTIFICATION

UNI EN 10204