

M08/02-V74

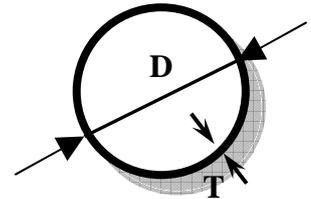
Reg.No: 4729-A
UNI EN ISO 9001:2015

Produzione Tubi Saldati in :
Acciaio al Carbonio - Acciai di Qualità - Acciaio Inox

DATA SHEET- DELIVERY CONDITIONS AND REFERENCE STANDARDS HELICAL WELDING TUBES (MIG/MAG)

300 mm \leq outer $\varnothing \leq$ 1600 mm

1,5 mm \leq Thickness \leq 10 mm



Diameter tolerance: $D = \pm 1\%$ OUTER \varnothing

Thickness tolerance: $T = \pm 10\%$

Tolerance of weld bead protrusion: ≤ 3 mm

Linear mass (“M”) tolerance of a single tube: $M = \pm 10\%$

Tube Length (“L”) tolerance:

- $L > 6000$ mm (-0 mm +15 mm) standard, warehouse or upon request
- $1000 \leq L < 6000$ mm (-0 mm +5 mm) profiled
- $L < 1000$ mm (-0 mm +3 mm) plasma cutting

Ovality (“O”) tolerance on diameter: $O < 2\%$ of OUTER \varnothing

Straightness tolerance: ≤ 2 mm ∇ m of tube

Cut verticality tolerance: $90^\circ \pm 1^\circ$

TECHNICAL DELIVERY CONDITIONS

PRODUCTION METHODS: Tubes featuring helical MIG/MAG wire weld seams.

SUBSTRATE: S 235 JR, S 275 JO, S 355 JO, DD 11, DD 13, AISI 304, AISI 316, AISI 310 S; other materials upon request (minimum quantity previously defined with customer).

APPEARANCE: Rough welded externally calibrated tubes have smooth in surfaces, furthermore they usually have a thin oil coat on the outside surface. Tubes have a manufactory coarse finish; slight imperfections are allowed provided that thickness is kept within the lower tolerance limits. Unless otherwise indicated by customer, welds can be repaired.

END FINISH: Unless otherwise indicated upon ordering, tubes are realized with flat ends, but they can be belled or smoothed upon request.

CORROSION-RESISTANT COATINGS: upon customer's request. Types:

- Hot-dip galvanising;
- Primers and epoxy varnishes;
- Polyethylene/ polyolefin bands.

PACKING: Loose or upon customer's request

CHECKS: Visual and dimensional check on each tube; destructive and non-destructive testing of a sample of the batch under inspection upon customer agreement.

DELIVERY/COLLECTION: Ex works, Via Selice 291/E, Conselice (RA). From Monday to Friday, from 8:00 am to 11:30 am, and from 01:30 pm to 05:00 pm. All materials must be accompanied by a Transport Document stating the relevant customer's order.

REQUIRED DOCUMENTATION

- Certification complying with UNI EN ISO 9001 Quality Management System;
- Acceptance test certificate for steel sheets complying with UNI EN 10204 “ 3.1”;
- Adhesive label on each tube indicating material, dimensions and production batch;
- Other documents to be agreed upon at the negotiation stage