

M08/02-V74

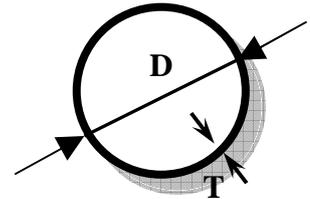
Reg.No: 4729-A  
UNI EN ISO 9001:2015

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

## DATA SHEET- DELIVERY CONDITIONS AND REFERENCE STANDARDS LONGITUDINAL WELDING TUBES (TIG)

**60 mm  $\leq$  outer  $\varnothing \leq$  300 mm**

**0.8 mm  $\leq$  Thickness  $\leq$  4 mm**



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

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

**Tolerance of weld bead protrusion**

weld bead surplus is fully removed from the tube external surface.

The

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

**Tube length (“L”) tolerance:**

- $L > 6000$  mm (-0 mm +15mm) standard, warehouse or upon request
- $1500 \leq L < 6000$  mm (-0 mm +3 mm) profiled
- $L < 1500$  mm (-0 mm +1 mm) tubes cut with rotary shears

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

**Straightness tolerance:  $\leq 2$  mm  $\nabla$  m of tube**

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

# **TECHNICAL DELIVERY CONDITIONS**

**PRODUCTION METHODS:** Tubes manufactured with longitudinal welding through TIG electric arc.

**SUBSTRATE:** S 235 JR, S 275 JO, S 355 JO, DC 01, 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 and out 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 bordered 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