



**ARCELORMITTAL TUBULAR
PRODUCTS IASI
ASTM, API 5L
product presentation**

API 5L PIPES

API 5L Specifications for PSL1 pipes

Dimensions : OD: 4 1/2" (114.3 mm) - 8 5/8" (219.1mm)

T: 0.141"(3.6 mm) - 0.322"(8.2 mm)

L: 20 ft (6 m) -40ft (12m) +100/-0 mm or ± 50 mm

Steel: grade A; grade B; X42; X46; X52

Manufacturing process: longitudinally welded

-cold formed with weld seam annealed

Protection :

lacquered

(min 6 months in sheltered environment)(min 25 μ m)

Tightness:

hydrostatic test at max.207 bar

Nondistructive test of weld:

NDT on weld

Tolerances:

with wall thickness:

+ 15% / -12.5%

with diameter on pipe body:

± 0.75 %

with diameter on pipe ends:

- 1/64 (0.4mm) / +1/16(1.6mm)

straightness:

$\leq 0.2\%$ of total length

weight:

+ 10% / -3.5%

Internal weld seam removed:

externally and internally

Ends processings:

bevelled at 30 gr angle(+5/-0)

Marking:

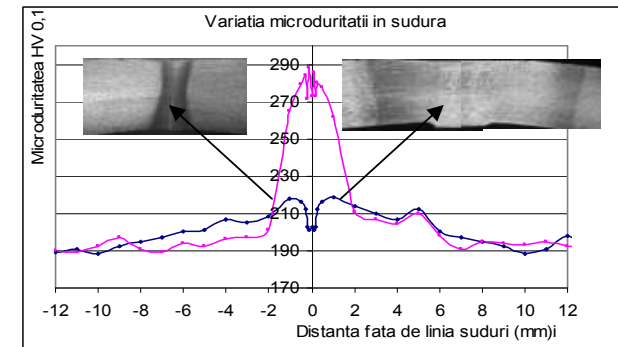
with API 5L monogram

Documents:

inspection certificate type 3.1 or type 3.2 (if requested)

(chemical analysis on charge; traction;

flattening; tightness; nondistructive test of weld)



ArcelorMittal Tubular Products lasi						
API 5L gr.A; gr.B; X42 ; X46 ; X52						
Outside		wall		weight		pieces per
Diameter		thickness				bundles
D		T				6m
in	mm	in	mm	lb/ft	kg/m	
4 1/2	114.3	0.141	3.6	6.57	9.83	19
		0.156	4	7.24	10.88	19
		0.172	4.4	7.96	11.92	19
		0.188	4.8	8.67	12.96	19
		0.203	5.2	9.32	13.99	19
		0.219	5.6	10.02	15.01	19
		0.237	6	10.8	16.02	19
5.9/16	141.3	0.156	4	9.02	13.54	10
		0.188	4.8	10.8	16.16	10
		0.219	5.6	12.51	18.74	10
		0.258	6.6	14.63	21.92	10
		0.172	4.4	11.87	17.78	7
6 5/8	168.3	0.188	4.8	12.94	19.35	7
		0.203	5.2	13.94	20.91	7
		0.219	5.6	15	22.47	7
		0.250	6.4	17.04	25.55	7
		0.280	7.1	18.99	28.22	7
		0.188	4.8	16.96	25.37	7
		0.203	5.2	18.28	27.43	7
8 5/8	219.1	0.219	5.6	19.68	29.48	7
		0.250	6.4	22.38	33.57	7
		0.277	7	24.72	36.61	7
		0.312	7.9	27.73	41.14	7
		0.322	8.2	28.58	42.65	7
		0.219	5.6	19.68	29.48	7
		0.250	6.4	22.38	33.57	7



ASTM A 53 Unalloyed steel tubes, black and galvanized

Dimensions: OD : 1/4" (13.7mm) - 8" (219.1mm)

T: 0.088"(2.24 mm) - 0.322"(8.18 mm)

l : 16 ft(4.88m) la 22ft(6.71 m) +100/-0 mm or ± 50mm

Steel: gr.A; gr.B

Manufacturing process: longitudinally welded type E

-hot stretched reduced up to 2 1/2" OD (76.1mm);

-cold formed for 3"(88.9mm) - 8"(219.1) mm OD;

-cold formed with weld seam annealed, for gr. B , OD > 114.3 mm

Protection:

lacquered (min.6 months in sheltered environment)(min.20-25 µm)

galvanized (min.55 µm)

Ends processing: plain ends for 1/2" - 11/2"

bevelled for 2" - 8" (wall th. ≥ 3.6 mm)

threaded 1/2"-4" OD

Tightness testing:

for 1/4 " - 3" OD NDT 100%

for 4 " - 8" OD hydrostatic test 100%

Non-destructive testing of weld:

NDT 100% for 13.7-114.3 mm OD

NDT on weld for 114.3 -219.1 mm OD

Tolerances:

with wall thickness:

+12.5%

with diameter:

± 1/64 " (0.40 mm) for OD < 1 1/4 "(42.2 mm)

± 1% for OD ≥ 1 1/2" (48.3 mm)

with weight:

± 10 %

Weld seam removed: externally 100%

internally starting with OD ≥ 1"(33.7) mm

Documents:

trial test type 2.2

inspection certificate type 3.1 or type 3.2 (if requested)



ArcelorMittal Tubular Products lasi

ASTM A53 ; gr.A; gr.B

NPS	DN	Outside Diameter		wall thickness		nominal weight		schedule no	pieces per bundle
		OD		T		lb/ft	kg/m		
		in	mm	in	mm				
1/4	8	0.54	13.7	0.088	2.24	0.43	0.63	40	271
				0.119	3.02	0.54	0.8	80	271
3/8	10	0.675	17.1	0.091	2.31	0.57	0.84	40	217
				0.126	3.2	0.74	1.1	80	217
1/2	15	0.84	21.3	0.109	2.77	0.85	1.27	40	169
3/4	20	1.05	26.7	0.113	2.87	1.13	1.69	40	127
1	25	1.315	33.4	0.133	3.38	1.68	2.5	40	91
1 1/4	32	1.66	42.2	0.14	3.56	2.27	3.39	40	61
1 1/2	40	1.9	48.3	0.145	3.68	2.72	4.05	40	61
2	50	2.375	60.3	0.154	3.91	3.66	5.44	40	37
2 1/2	65	2.875	73	0.203	5.16	5.8	8.63	40	37
3	80	3.5	88.9	0.125	3.18	4.51	6.72	...	19
				0.156	3.96	5.58	8.29	...	19
				0.188	4.78	6.66	9.92	...	19
				0.216	5.49	7.58	11.29	40	19
3 1/2	90	4	101.6	0.125	3.18	5.18	7.72	...	19
				0.156	3.96	6.41	9.53	...	19
				0.188	4.78	7.66	11.41	...	19
				0.226	5.74	9.12	13.57	40	19
4	100	4.5	114.3	0.125	3.18	5.85	8.71	...	19
				0.156	3.96	7.24	10.78	...	19
				0.188	4.78	8.67	12.91	...	19
				0.219	5.56	10.02	14.91	...	19
				0.237	6.02	10.8	16.07	40	19
				0.25	6.35	11.36	16.9	...	19
5	125	5.563	141.3	0.156	3.96	9.02	13.41	...	10
				0.188	4.78	10.8	16.09	...	10
				0.219	5.56	12.51	18.61	...	10
				0.258	6.55	14.63	21.77	40	10
6	150	6.625	168.3	0.188	4.78	12.94	19.27	...	7
				0.219	5.56	15	22.31	...	7
				0.25	6.35	17.04	25.36	...	7
				0.28	7.11	18.99	28.26	40	7
8	200	8.625	219.1	0.188	4.47	16.96	25.26	...	7
				0.203	5.16	18.28	27.22	...	7
				0.219	5.56	19.68	29.28	...	7
				0.25	6.35	22.38	33.31	...	7
				0.277	7.04	24.72	36.31	...	7
				0.312	7.92	27.73	41.24	...	7
				0.322	8.18	28.58	42.55	40	7



ASTM A 795 Unalloyed steel tubes, black and galvanized used for protection against fire

Dimensions: OD: 1/2" (21.3mm) - 8" (219.1mm)

T: 0.109"(2.77 mm) - 0.277"(7.04 mm)

L: 16 ft(4.88m) la 22ft(6.71 m) +100/-0 mm or \pm 50mm

Steel : gr.A; gr.B

Manufacturing process: longitudinally welded type E

-hot stretched reduced up to 2 1/2"(76.1mm) OD;

-cold formed for 3" (88.9mm) -8"(219.1) mm OD;

-cold formed with weld seam annealed for gr. B ,OD > 114.3 mm

Protection:

lacquered (min.6 months in sheltered environment)(min.20-25 μ m)

galvanized (min.55 μ m)

Ends processing: plain

threaded 1/2"-4" OD

Tightness testing:

for 1/4 "- 3" OD NDT 100%

for 4 "- 8" OD hydrostatic test 100%

Nondistructive testing of weld:

NDT 100% for 21.3-114.3 mm OD

NDT on weld for 114.3 -219.1 mm OD

Tolerances:

with wall thickness:

+12.5%

with diameter:

+ 1/64 " (0.40 mm) - 1/32"(0.8 mm) for OD < 1 1/2 "(48.3 mm)

\pm 1% for OD \geq 2" (60.3 mm)

with weight:

\pm 5 %

Internal weld seam removed: externally 100%

internally starting with tubes OD \geq 1"(33.7) mm

Documents:

trial report type 2.2

inspection certificate type 3.1 or type 3.2 (if requested)

