

Black & Galvanized Pipe

BS : 1387 of 1985 (Black and Galvanised Steel Pipes)

CLASS	Normal Bore		Outside Diameter		Thick-ness	Weight of Black Pipes				Weight of Galavanised Pipes (Calculated)				No.of Pcs Per Bundle
			Max.	Min.		Plain Ended		Screwed & Socketed		Plain Ended		Screwed & Socketed		
	Inch	mm	mm	mm	mm	kg/mtr	mtr/ton	kg/mtr	mtr/ton	kg/mtr	mtr/ton	kg/mtr	mtr/ton	
YELLOW LIGHT (A)	½	15	21.4	21.0	2.00	0.947	1056	0.956	1046	1.000	1000	1.007	993	160
	¾	20	26.9	26.4	2.30	1.380	725	1.390	719	1.440	694	1.460	685	110
	1	25	33.8	33.2	2.60	1.980	505	2.000	500	2.060	485	2.090	478	80
	1¼	32	42.5	41.9	2.60	2.540	394	2.570	389	2.640	379	2.680	373	61
	1½	40	48.5	47.8	2.90	3.230	310	3.270	306	3.350	298	3.400	294	51
	2	50	60.2	59.6	2.90	4.080	245	4.150	241	4.220	237	4.300	233	37
	2½	65	76.0	75.2	3.20	5.710	175	5.830	172	5.890	170	6.020	166	27
	3	80	88.7	87.9	3.20	6.720	149	6.890	145	6.930	144	7.100	141	24
4	100	113.9	113.0	3.60	9.750	103	10.000	100	10.030	100	10.280	97	16	
BLUE MEDIUM (B)	½	15	21.7	21.1	2.60	1.210	826	1.220	820	1.250	800	1.260	794	130
	¾	20	27.2	26.6	2.60	1.560	641	1.570	637	1.620	617	1.640	610	100
	1	25	34.2	33.4	3.20	2.410	415	2.430	412	2.490	402	2.510	398	65
	1¼	32	42.9	42.1	3.20	3.100	323	3.130	319	3.200	312	3.230	310	51
	1½	40	48.8	48.0	3.20	3.570	280	3.610	277	3.680	272	3.720	269	44
	2	50	60.8	59.8	3.60	5.030	199	5.100	196	5.170	193	5.250	190	30
	2½	65	76.6	75.4	3.60	6.430	156	6.550	153	6.610	151	6.730	149	24
	3	80	89.5	88.1	4.00	8.370	119	8.540	117	8.580	117	8.760	114	19
4	100	114.9	113.3	4.50	12.200	82	12.500	80	12.480	80	12.690	79	14	
5	125	140.6	138.7	5.00	16.600	60	17.100	58	16.940	59	17.440	57	10	
6	150	166.1	164.1	5.00	19.700	51	20.300	49	20.100	50	20.710	48	7	
RED HEAVY (C)	½	15	21.7	21.1	3.20	1.440	694	1.450	690	1.490	671	1.500	667	110
	¾	20	27.2	26.6	3.20	1.870	535	1.880	532	1.930	518	1.950	513	80
	1	25	34.2	33.4	4.00	2.940	340	2.960	338	3.010	332	3.040	329	55
	1¼	32	42.9	42.1	4.00	3.800	263	3.830	261	3.900	256	3.930	254	44
	1½	40	48.8	48.0	4.00	4.380	228	4.420	226	4.490	223	4.530	221	37
	2	50	60.8	59.8	4.50	6.190	162	6.260	160	6.330	158	6.400	156	27
	2½	65	76.6	75.4	4.50	7.930	126	8.050	124	8.110	123	8.230	121	20
	3	80	89.5	88.1	5.00	10.300	97	10.500	95	10.510	95	10.710	93	16
4	100	114.9	113.3	5.40	14.500	69	14.800	68	14.770	68	14.990	67	12	
5	125	140.6	138.7	5.40	17.900	56	18.400	54	18.210	55	18.630	54	10	
6	150	166.1	164.1	5.40	21.300	47	21.900	46	21.680	46	22.220	45	7	

TOLERANCES

A. Thickness

1. Light Tubes	+ Not limited -8%	2. Medium and Heavy Tubes	+Not limited -10%
----------------	----------------------	---------------------------	----------------------

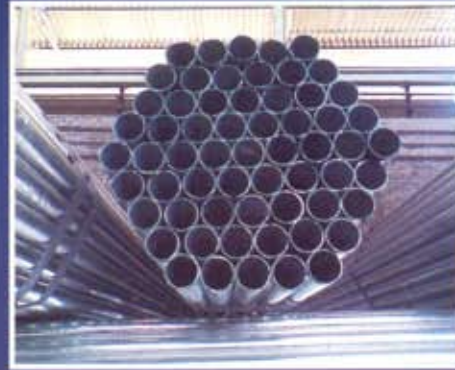
B. Weight

1. Single tube (Light series)	+ 10% -8%	2. Single tube (Medium & Heavy series)	±10%
3. For Quantities per Load of 10 tonnes minimum (Light series)	±5%	4. For Quantities per Load of 10 tonnes minimum (Medium & heavy series)	±7.5%

C. Length

4 to 6.5 meters unless otherwise specified





GI Pipe Product Range -Local

Nominal Size (NPS)	Grade	Outer Dia (mm)		Wall Thickness (mm)	Pipe Standard	Threading Standard	Standard Black Pipe Weight		Pipes/ Bundles	Length (Meter)	Acceptance Criteria
		Max.	Min.				Kg/m	Meter/Ton			
½"	EL	21.00	20.60	1.80	GTL	BS-21	0.843	1186	169	1.00-6.50	Good Surface finish with full Galvanizing
¾"	EL	26.60	26.10	2.00	GTL	BS-21	1.201	833	127	1.00-6.50	Good Surface finish with full Galvanizing
1"	EL	33.50	32.80	2.30	GTL	BS-21	1.750	572	91	1.00-6.50	Good Surface finish with full Galvanizing
1¼"	EL	42.20	41.60	2.30	GTL	BS-21	2.246	445	61	1.00-6.50	Good Surface finish with full Galvanizing
1½"	EL	48.10	47.50	2.60	GTL	BS-21	2.898	345	61	1.00-6.50	Good Surface finish with full Galvanizing
2"	EL	60.20	59.30	2.60	GTL	BS-21	3.664	273	37	1.00-6.50	Good Surface finish with full Galvanizing
2½"	EL	75.70	74.90	2.90	GTL	BS-21	5.178	193	37	1.00-6.50	Good Surface finish with full Galvanizing
3"	EL	88.40	87.60	2.90	GTL	BS-21	6.086	164	24	1.00-6.50	Good Surface finish with full Galvanizing
4"	EL	113.50	112.60	3.20	GTL	BS-21	8.668	115	19	1.00-6.50	Good Surface finish with full Galvanizing
5"	EL	139.00	138.00	3.60	GTL	BS-21	11.976	84	07	1.00-6.50	Good Surface finish with full Galvanizing
6"	EL	165.00	163.00	3.60	GTL	BS-21	14.240	70	07	1.00-6.50	Good Surface finish with full Galvanizing

Note : Any specific thickness required can be manufactured

ERW Pipes & Tubes / Black Steel Pipes & Tubes / Galvanized Pipes & Tubes



ERW Steel Tube for Line Pipes in Oil & Natural Gas Conforming to IS : 1978-82

NB (mm)	OD (mm)	Wall Thickness (mm)	Plain End Weight (Kg/m)	Test Pressure (Min)		NB (mm)	OD (mm)	Wall Thickness (mm)	Plain End Weight (Kg/m)	Test Pressure (Min)	
				Grade Yst 210 STD 100Kpa	Grade Yst 240 STD 100Kpa					Grade Yst 210 STD 100Kpa	Grade Yst 240 STD 100Kpa
80	88.90	3.20	6.76	89	104	200	219.10	4.80	25.37	54	63
		3.60	7.57	101	117			5.60	29.48	63	74
		4.00	8.37	112	130			6.40	33.57	73	84
		4.40	9.17	123	143			7.00	36.61	79	92
		4.80	9.95	134	156						
		5.50	11.31	154	172						
90	101.60	3.60	8.70	88	102	250	273.10	4.80	31.76	44	51
		4.00	9.63	98	114			5.60	36.94	51	59
		4.40	10.55	108	125			6.40	42.09	58	68
		4.80	11.46	117	137			7.10	46.57	65	75
		5.70	13.48	139	162			7.80	51.03	71	83
		6.40	15.02	156	182			8.70	56.72	79	92
100	114.30	3.60	9.83	78	91	300	323.90	4.80	37.77	37	43
		4.00	10.88	87	101			5.60	43.96	43	50
		4.80	12.96	104	121			6.40	50.11	49	57
		5.20	13.99	113	132			7.10	55.47	54	63
		5.60	15.01	122	142			7.90	61.56	61	71
		6.00	16.02	130	152			8.40	65.35	64	75
125	141.30	3.60	10.90	56	65	350	355.60	4.80	41.52	34	39
		4.00	13.94	70	82			5.20	44.93	36	42
		4.80	16.16	84	98			6.40	55.11	45	52
		5.60	18.74	98	115			7.10	61.02	50	58
		6.60	21.92	116	135			7.90	67.74	55	64
		7.10	23.50	125	145			8.70	74.42	61	71
150	168.30	3.60	14.62	53	62	400	406.40	4.80	47.54	29	34
		4.00	16.21	59	76			5.20	51.45	32	37
		4.80	19.35	71	81			5.60	55.35	34	40
		5.20	20.91	77	89			6.40	63.13	39	46
		5.60	22.47	83	96			7.10	69.91	43	51
		6.40	25.55	94	110			7.90	77.63	48	56
	7.10	28.22	105	122	8.70	85.32	53	62			
					9.50	92.98	58	68			

A. Outside Diameter - The outside diameter tolerances shall be as follows,

Pipe Body For Size	Tolerance
48.3 mm and less	+0.40 mm - 0.80 mm
60.3 mm and above	+/-1%

B. Wall Thickness- The Tolerances on the wall thickness of line pipes shall be as follows :

Type	For	Tolerance
Welded Pipes	73.0 mm and smaller	+20.0% -12.5%
	88.9 mm O.D. & Larger	+18.0% -12.5%

C. Weight

Single Lengths
Standard Weight, regular weight, extra strong and double extra strong pipe

Grade Yst - 210 and Yst - 240	+10.0% } -3.5% }
Special plain end pipes - All Grades	+10.0% } -5.0% }
Car loads lots For min 18000 Kg : Grade Yst 210 & Yst 240	-1.75% } -2.5% }

