



INTERPIPE

EXPERT PIPE SOLUTIONS FOR INDUSTRIAL APPLICATION

SEAMLESS PIPES,
WELDED PIPES AND HOLLOW SECTIONS



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INTERPIPE AT A GLANCE

Interpipe has a vertically – integrated business structure

Interpipe is a global steel pipe producer – one of the top ten largest manufacturers of seamless pipes in the world. In 2013 the company sold over 1 million tons of steel pipes.

The company’s products are supplied to 80 countries all over the world through a chain of commercial offices located in Ukraine, Russia, Kazakhstan, Europe, the USA and the Middle East.

Interpipe structure includes production facilities located in Dnepropetrovsk region, one of the major industrial centers of Ukraine. The company continues to invest heavily in the development and modernization of its mills.

Interpipe has a vertically integrated business structure which includes 5 high efficient mills. Such structure allows controlling product quality at every stage: from manufacturing of raw materials to delivery of final products to customers.

Interpipe Vtormet Dnepropetrovsk, Ukraine



SCRAP
PROCESSING

Interpipe Steel Dnepropetrovsk, Ukraine

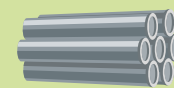


STEEL
PRODUCTION

Interpipe NTRP Dnepropetrovsk, Ukraine

Interpipe Niko Tube Nikopol, Ukraine

Interpipe NMPP Novomoskovsk, Ukraine



SEAMLESS STEEL
PIPES AND RAILWAY
WHEEL PRODUCTION

Selling to customers globally – key markets



North American
Interpipe



Interpipe
Middle East



Interpipe
Kazakhstan



Interpipe
Europe SA



Interpipe M



Interpipe
Ukraine



QUALITY-FOCUSED OPERATIONS

Interpipe considers quality control as a key part of the activities to manufacture products, exceeding customer needs. Quality control is implemented at all stages of production process - starting from continuous casting at the in-house mini mill and up to nondestructive testing of pipe body and pipe ends and shipping to customers.

Our commitment to quality is confirmed by:

- Pipe products certification in compliance with major international standards API 5CT, API 5L, EN (DIN), ASTM, JIS, GOST and customer specifications
- Quality management system as per ISO 9001 and API Q1
- Implementation of a continuous improvement system at the Company mills
- Effectively operating customer reclamation system



ONGOING INVESTMENTS PROGRAM

In our business, investments play a crucial role in making decisions on the Company's future. Interpipe regularly invests in development of its production capacities, improvement of the output quality, and expansion of its product range. Currently we are carrying out a major investment program that will reinforce the Company's vertical integration, boost our capacity in production of high quality products, and enhance our operating efficiency in pipe and wheel production.

SEAMLESS PIPES

ASTM A 106/A106M
ANSI/ASME B36.10M
ASTM A 53/A 53 M

Application: for producing structures, as well as for steam, water, gas and air pipelines, and also in general machine-building and tool-making.

Steel grade – A, B

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
1	1.315	33,4	0.133	3.38	1.68	2.50	STD	40
1 ¼	1.660	42.2	0.140	3.56	2.27	3.39	STD	40
1 ½	1.900	48.3	0.125	3.18	2.37	3.54		30
			0.145	3.68	2.72	4.05	STD	40
2	2.375	60.3	0.141	3.58	3.36	5.01		
			0.156	3.91	3.66	5.44	STD	40
			0.172	4.37	4.05	6.03		
			0.188	4.78	4.39	6.54		
			0.218	5.54	5.03	7.48	XS	80
2 ½	2.875	73.0	0.141	3.58	4.12	6.13		
			0.156	3.96	4.53	6.74		
			0.172	4.37	4.97	7.40		
			0.188	4.78	5.40	8.04		30
			0.203	5.16	5.80	8.63	STD	40
			0.216	5.49	6.13	9.14		
			0.250	6.35	7.01	10.44		
0.276	7.01	7.67	11.41	XS	80			
3	3.500	88.9	0.141	3.58	5.06	7.53		
			0.156	3.96	5.58	8.29		
			0.172	4.37	6.11	9.11		
			0.188	4.78	6.66	9.92		30
			0.216	5.49	7.58	11.29	STD	40
			0.250	6.35	8.69	12.93		
			0.281	7.14	9.67	14.40		
			0.300	7.62	10.26	15.27	XS	80
3 ½	4.000	101.6	0.438	11.13	14.32	21.35		160
			0.156	3.96	6.41	9.53		
			0.172	4.37	7.03	10.48		
			0.188	4.78	7.66	11.41		30
			0.226	5.74	9.12	13.57	STD	
			0.250	6.35	10.02	14.92		
			0.281	7.14	11.17	16.63		
0.318	8.08	12.52	18.63	XS	80			
4	4.500	114.3	0.172	4.37	7.95	11.85		
			0.188	4.78	8.67	12.91		30
			0.203	5.16	9.32	13.89		
			0.219	5.56	10.02	14.91		
			0.237	6.02	10.80	16.07	STD	40
			0.250	6.35	11.36	16.90		
			0.281	7.14	12.67	18.87		
			0.337	8.56	14.98	22.32	XS	80
			0.438	11.13	19.00	28.32		120
0.531	13.49	22.51	33.54		160			

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
5	5.563	141.3	0.258	6.55	14.62	21.77	STD	40
			0.375	9.53	20.78	30.97	XS	80
			0.500	12.70	27.04	40.28		120
			0.625	15.88	32.96	49.11		160
6	6.625	168.3	0.250	6.35	17.04	25.36		
			0.280	7.11	18.97	28.26	STD	40
			0.312	7.92	21.04	31.32		
			0.344	8.74	23.08	34.39		
			0.375	9.53	25.03	37.28		
			0.432	10.97	28.57	42.56	XS	80
			0.500	12.70	32.74	48.73		
			0.562	14.27	36.39	54.20		120
			0.625	15.88	40.09	59.69		
8	8.625	219.1	0.250	6.35	22.38	33.32		20
			0.277	7.04	24.70	36.81		30
			0.312	7.92	27.70	41.24		
			0.322	8.18	28.55	42.55	STD	40
			0.344	8.74	30.42	45.34		
			0.375	9.53	33.04	49.25		
			0.406	10.31	35.64	53.08		60
			0.438	11.13	38.30	57.08		
			0.500	12.70	43.39	64.64	XS	80
			0.562	14.27	48.44	72.08		
			0.594	15.09	50.95	75.92		100
			0.625	15.88	53.45	79.59		
			0.719	18.26	60.71	90.44		120
			0.750	19.05	63.14	93.98		
			0.812	20.62	67.76	100.92		140
			0.875	22.23	72.42	107.92	XXS	
0.906	23.01	74.69	111.27		160			
10	10.750	273.0	0.307	7.8	34.24	51.03		30
			0.344	8.74	38.23	56.98		
			0.365	9.27	40.52	60.29	STD	40
			0.438	11.13	48.28	71.88		
			0.500	12.70	54.74	81.55	XS	60
			0.562	14.27	61.21	91.05		
			0.594	15.09	64.43	96.01		80
			0.625	15.88	67.65	100.69		
			0.719	18.26	77.03	114.70		100
			0.812	20.62	86.26	128.34		
			0.844	21.44	89.29	133.09		120
			0.875	22.23	92.28	137.52		
			0.938	23.83	98.30	146.48		
			1.000	25.40	104.13	155.15	XXS	140
1.125	28.58	115.64	172.33					

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
12	12.750	323.8	0.312	7.92	41.45	61.71		
			0.330	8.38	43.77	65.2		30
			0.344	8.74	45.58	67.93		
			0.375	9.53	49.56	73.88	STD	
			0.406	10.31	53.52	79.73		40
			0.438	11.13	57.59	85.84		
			0.500	12.70	65.42	97.46	XS	
			0.562	14.27	73.15	108.92		60
			0.625	15.88	81.01	120.59		
			0.688	17.48	88.63	132.04		80
			0.750	19.05	95.21	143.17		
			0.812	20.62	103.63	154.17		
			0.844	21.44	107.32	159.86		100
			0.875	22.23	110.97	165.37		
			0.938	23.83	118.33	176.33		
			1.000	25.40	125.49	186.97	XXS	120
			1.062	26.97	132.57	197.48		
1.125	28.58	139.67	208.14		140			
1.250	31.75	153.53	228.74					
1.312	33.32	160.27	238.76		160			
14	14.000	355.6	0.312	7.92	45.61	67.9		20
			0.344	8.74*	50.17	74.76		
			0.375	9.53	54.57	81.33	STD	30
			0.406	10.31	59.00	87.79		
			0.438	11.13	63.44	94.55		40
			0.594	15.09	85.05	126.71		60
			0.750	19.05	106.13	158.10		80
			0.938	23.83	130.85	194.96		100
			1.094	27.79	150.79	224.65		120
			1.250	31.75	170.21	253.56		140
			1.406	35.71	189.11	281.70		160
			2.000	50.8	256.32	381.83		
			2.125	53.97	269.50	401.50		
2.200	55.88	277.25	413.01					
2.500	63.5	307.05	457.40					
16	16	406.4	0.375	9.53	62.64	93.27	STD	30
			0.406	10.31	67.68	100.71		
			0.438	11.13	72.86	108.49		
			0.469	11.91	77.87	115.87		
			0.500	12.7	82.85	123.31	XS	40
			0.562	14.27	92.75	138		
			0.625	15.88	102.72	152.94		
			0.656	16.66	107.76	160.13		60
			0.688	17.48	112.62	167.66		
			0.750	19.05	122.27	181.98		
			0.812	20.62	131.84	196.18		80
			0.844	21.44	136.74	203.54		
			0.875	22.23	141.48	210.61		
			0.938	23.83	151.03	224.83		
			1.000	25.4	160.35	238.66		100
			1.031	26.19	164.98	245.57		
			1.062	26.97	169.59	252.37		
			1.125	28.58	178.89	266.3		
			1.188	30.18	188.11	280.01		120
1.219	30.96	192.61	286.66					
1.250	31.75	197.1	293.35		140			
1.438	36.53	223.85	333.21					

— Seamless pipes with OD 16" are produced according ASTM A53 / ASTM A106M upon agreement

ASTM A333 SEAMLESS PIPES FOR OPERATIONS AT LOW TEMPERATURES

Dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Steel grades
	in	mm	in	mm	lb/ft	kg/m	
2	2.375	60.3	0.154	3.910	3.650	5.440	
			0.218	5.540	5.030	7.480	
2 ½	2.875	73	0.276	7.010	7.670	11.410	
			0.357	9.530	10.020	14.900	
3	3.500	88.9	0.216	5.490	7.590	11.290	
			0.300	7.620	10.260	15.270	
			0.314	8.000	10.730	15.960	
			0.438	11.130	14.340	21.350	
3 ½	4.000	101.6	0.600	15.240	18.600	27.680	
			0.226	5.740	9.120	13.570	
			0.318	8.080	12.520	18.630	
			0.237	6.020	10.800	16.070	
4	4.500	114.3	0.314	8.000	14.090	20.970	
			0.337	8.560	15.000	22.320	
			0.438	11.130	19.020	28.320	
			0.531	13.490	22.530	33.540	
			0.674	17.190	27.570	41.030	
5	5.563	141.3	0.258	6.550	14.630	21.770	
			0.375	9.530	20.800	30.940	
			0.500	12.700	27.060	40.280	
			0.625	15.880	32.990	49.110	
			0.750	19.050	38.590	57.430	
			0.250	6.350	17.040	25.360	
6	6.625	168.3	0.280	7.110	18.990	28.260	
			0.312	7.920	21.060	31.320	
			0.344	8.740	23.100	34.390	
			0.375	9.530	25.050	37.280	
			0.432	10.970	28.600	42.560	
			0.500	12.700	32.740	48.730	
			0.562	14.270	36.430	54.200	
			0.625	15.880	40.090	59.690	
			0.719	18.260	45.390	67.560	
8	8.625	219.1	0.864	21.950	53.210	79.220	
			0.250	6.350	22.380	33.320	
			0.277	7.040	24.720	36.310	
			0.312	7.920	27.730	41.240	
			0.322	8.180	28.580	42.550	
			0.344	8.740	30.450	45.340	
			0.375	9.530	33.070	49.200	
			0.406	10.310	35.670	53.080	
			0.438	11.130	38.330	57.080	
			0.500	12.700	43.430	64.640	
			0.562	14.270	48.440	72.080	
			0.594	15.090	51.000	75.920	
			0.625	15.880	53.450	79.590	
			0.719	18.260	60.770	90.440	
			0.750	19.050	63.140	93.980	
0.812	20.620	67.820	100.920				
0.875	22.230	72.490	107.880				
0.906	23.010	74.760	111.270				
1.000	25.400	81.510	121.330				

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Nominal size	Outside diameter		Wall thickness		Weight per length unit		Steel grades
	in	mm	in	mm	lb/ft	kg/m	
10	10.750	273	0.250	6.350	28.060	41.760	
			0.279	7.090	31.230	46.490	
			0.307	7.800	34.280	51.010	
			0.344	8.740	38.280	56.960	
			0.365	9.270	40.520	60.290	
			0.438	11.130	48.300	71.870	
			0.500	12.700	54.790	81.520	
			0.562	14.270	61.210	91.050	
			0.594	15.090	64.500	95.970	
			0.625	15.880	67.650	100.690	
			0.719	18.260	77.090	114.710	
			0.812	20.620	86.260	128.340	
			0.844	21.440	89.380	133.000	
			0.875	22.230	92.370	137.480	
			0.938	23.830	98.390	146.430	
			1.000	25.400	104.230	155.090	
1.125	28.580	115.730	169.180				
1.250	31.750	126.940	188.900				
12	12.750	323.8	0.281	7.140	37.460	55.760	
			0.312	7.920	41.480	61.700	
			0.330	8.380	43.810	65.180	
			0.344	8.740	45.620	67.900	
			0.375	9.530	49.610	73.780	
			0.406	10.310	53.570	79.700	
			0.438	11.130	57.650	85.820	
			0.500	12.700	65.480	97.430	
			0.562	14.270	73.220	108.920	
			0.625	15.880	81.010	120.590	
			0.688	17.480	88.710	132.040	
			0.750	19.050	95.210	143.170	
			0.812	20.620	103.630	154.170	
			0.844	21.440	107.420	159.860	
			0.875	22.230	111.080	165.330	
			0.983	23.830	118.440	176.290	
1.000	25.400	125.610	186.910				
1.062	26.970	132.690	197.430				
1.125	28.580	139.810	208.000				
1.250	31.750	153.670	228.680				
1.312	33.320	160.420	238.680				
14	14.000	355.6	0.312	7.920	45.650	67.900	
			0.344	8.740	50.220	74.760	
			0.375	9.530	54.620	81.250	
			0.438	11.130	63.500	94.550	
			0.469	11.910	67.840	100.940	
			0.500	12.700	72.160	107.390	
			0.593	15.090	84.980	126.470	
			0.750	19.050	106.230	158.100	
			0.938	23.830	130.980	194.960	
			1.094	27.790	150.930	224.650	
			1.250	31.750	170.370	253.560	
			1.406	35.710	189.290	281.700	
			2.000	50.800	256.560	381.830	
			2.125	53.970	269.760	401.440	
2.200	55.880	277.510	413.010				
2.500	63.500	307.340	457.400				

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■ – Production upon agreement with the mill

DIN EN 10255

UNALLOYED STEEL TUBES SUITABLE FOR WELDING AND THREADING

Application: for transportation fluids and general purpose

Dimensions and weight for Hot-rolled

Nominal size, mm	Outside diameter, mm		H (heavy-weight)		M (medium-weight)		Steel grades
	max.	min.	Wall thickness, mm	Weight per length unit, kg/m	Wall thickness, mm	Weight per length unit, kg/m	
33.7	34.2	33.3	-	-	3.2	2.41	S 195 T
42.4	42.9	42.0	4.0	3.79	3.2	3.1	
48.3	48.8	47.9	4.0	4.37	3.2	3.56	
60.3	60.8	59.7	4.5	6.19	3.6	5.03	
76.1	76.6	75.3	4.5	7.93	3.6	6.42	
88.9	89.5	88.0	5.0	10.3	4.0	8.36	
114.3	115.0	113.1	5.4	14.5	4.5	12.2	

Dimensions and weight for Hot-rolled – Type L and L1

Nominal size, mm	Outside diameter, mm		Type L		Type L1		Steel grades
			Wall thickness, mm	Weight per length unit, kg/m	Wall thickness, mm	Weight per length unit, kg/m	
	max.	min.					
33.7	34.0	33.2	2.9	2.2	2.9	2.2	S 195 T
42.4	42.7	41.9	2.9	2.82	2.9	2.82	
48.3	48.6	47.8	2.9	3.25	2.9	3.24	
60.3	60.7	59.6	3.2	4.51	3.2	4.49	
76.1	76.3	75.2	-	-	3.2	5.73	
88.9	89.4	87.9	-	-	3.6	7.55	
114.3	114.9	113	-	-	4.0	10.8	



EN 10210 / EN 10297 / DIN 1629

Application: commercial pipes for instrumentation, construction, pipeworks and other general engineering purposes

Dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm																		
	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8	10,0	11,0	12,5	14,2	16,0	17,5	20,0
33,7	1,99	2,20	2,41	2,67															
38,0	2,27	2,51	2,75	3,05	3,35														
42,4	2,55	2,82	3,09	3,44	3,79	4,21	4,61												
44,5			3,26	3,63	4,00	4,44	4,87												
48,3	2,93	3,25	3,56	3,97	4,37	4,86	5,34												
51,0	3,10	3,44	3,77	4,21	4,64	5,16													
57,0		3,87	4,25	4,74	5,23	5,83	6,41	7,10	7,88										
60,3		4,11	4,51	5,03	5,10	6,19	6,27	7,55	8,39										
63,5		4,33	4,76	5,32	5,87	6,55	7,21	8,00	8,89										
70,0				5,90	6,51	7,27	8,01	8,89	0,03										
73,0				6,16	6,81	7,60	8,38	9,31	10,36	11,54	12,82	13,93	15,54	16,82	18,65				
76,1		5,24	5,75	6,44	7,11	7,95	8,77	9,74	11,93	12,08	13,44	14,61	16,30	17,66	19,61				
82,5				7,00	7,74	8,66	9,56	10,62	11,84	13,20	14,70	15,99	17,88	19,40	21,58	23,92	26,24		
88,9				7,57	8,38	9,36	10,35	11,50	12,83	14,32	15,96	17,38	19,46	21,13	23,55	26,16	28,77		
95,0					8,98	10,04	11,10	12,35	13,78	15,39	17,16	18,71	20,96	22,79	25,43	28,29	31,17	33,45	36,99
101,6				8,70	9,63	10,78	11,91	13,26	14,81	16,55	18,47	20,14	22,59	24,58	27,47	30,61	33,78	36,30	40,25
108,0				9,27	10,26	11,49	12,70	14,14	15,80	17,67	19,73	21,53	24,17	26,31	29,44	32,85	36,30	39,06	43,40
114,3				9,83	10,88	12,18	13,48	15,01	16,78	18,77	20,97	22,90	25,72	28,02	31,38	35,05	38,79	41,78	46,51
121,0							14,30	15,94	17,82	19,94	22,29	24,35	27,37	29,84	33,45	37,40	41,43	44,67	49,82
127,0							15,04	16,77	18,75	20,99	23,48	25,65	28,85	31,47	35,30	39,50	43,80	47,26	52,78
133,0							15,78	17,59	19,69	22,04	24,66	26,95	30,33	33,10	37,15	41,60	46,17	49,85	55,73
139,7							16,61	18,52	20,73	23,22	25,98	28,41	31,99	34,91	39,21	43,95	48,81	52,74	59,04
146,0							17,39	19,39	21,70	24,32	27,23	29,78	33,54	36,62	41,15	46,16	51,30	55,46	62,15
152,4							18,18	20,27	22,70	25,44	28,49	31,16	35,12	38,36	43,13	48,40	53,82	58,22	65,30
159,0							18,99	21,19	23,72	26,60	29,79	32,60	36,75	40,15	45,16	50,71	56,43	61,07	68,56
168,3									25,17	28,23	31,63	34,61	39,04	42,67	48,03	53,96	60,10	65,08	73,15
177,8									26,64	29,89	33,50	36,68	41,38	45,25	50,96	57,29	63,84	69,18	77,83
193,7									29,11	32,67	36,64	40,13	45,30	49,56	55,86	62,86	70,12	76,04	85,67
203,0									30,56	34,30	38,47	42,15	47,59	52,09	58,72	66,11	73,79	80,06	90,26
216,0									32,58	36,58	41,04	44,97	50,80	55,61	62,73	70,67	78,92	85,67	96,67
219,1									33,06	37,12	41,65	45,64	51,57	56,45	63,69	71,75	80,14	87,01	98,20
229,0										38,85	43,60	47,79	54,01	59,14	66,74	75,22	84,04	91,28	103,09
244,5									37,01	41,57	46,66	51,15	57,83	63,34	71,52	80,65	90,16	97,97	110,73
254,0									38,48	43,23	48,53	53,21	60,17	65,92	74,45	83,98	93,91	102,07	115,41
267,0									40,50	45,51	51,10	56,03	63,38	69,45	78,45	88,53	99,04	107,68	121,83
273,0									41,43	46,56	52,28	57,34	64,86	71,07	80,30	90,63	101,41	110,27	124,79
298,5										51,02	57,31	62,87	71,15	77,99	88,16	99,56	111,47	121,27	137,36
305,0										52,16	58,60	64,28	72,75	79,76	90,16	101,84	114,03	124,08	140,57
323,9										55,47	62,32	68,38	77,41	84,88	95,99	108,45	121,49	132,23	149,89
330,0											63,53	69,71	78,92	86,54	97,88	110,59	123,90	134,87	152,90
339,7											65,44	71,81	81,31	89,17	100,87	113,99	127,73	139,05	157,69
343,0											66,09	72,53	82,12	90,06	101,88	115,14	129,03	140,48	159,31
355,6											68,57	75,26	85,23	93,48	105,77	119,56	134,00	145,92	165,53
368,0											71,03	77,95	88,28	96,85	109,59	123,89	138,89	151,27	171,64
377,0											79,91	90,50	99,29	112,36	127,05	142,44	155,15	176,08	
406,4											86,29	97,76	107,26	121,43	137,35	154,05	167,84	190,58	
426,0												102,59	112,58	127,47	144,21	161,78	176,30	200,25	

— Production upon agreement with the mill

Dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm														Steel grades		
	22,2	25,0	28,0	30,0	32,0	36,0	40,0	45,0	50,0	55,0	60,0	65,0	70,0	75,0	EN 10210	DIN 1629	EN 10297
33,7																	
38,0																	
42,4																	
44,5																	
48,3																	
51,0																	
57,0																	
60,3																	
63,5																	
70,0																	
73,0																	
76,1																	
82,5																	
88,9																	
95,0	39,86																
101,6	43,47																
108,0	46,97	51,17	55,24														
114,3	50,42	55,06	59,59														
121,0	54,09	59,19	64,22														
127,0	57,38	62,89	68,36	71,76													
133,0	60,66	66,59	72,50	76,20	79,71												
139,7	64,33	70,72	77,13	81,16	84,99												
146,0	67,78	74,60	81,48	85,82	89,97	97,66											
152,4	71,28	78,55	85,90	90,56	95,02	103,34											
159,0	74,90	82,62	90,46	95,44	100,22	109,20											
168,3	79,99	88,35	96,88	102,32	107,56	117,46	126,56										
177,8	85,19	94,21	103,44	109,35	115,06	125,89	135,93										
193,7	93,89	104,01	114,42	121,11	127,61	140,01	151,62	165,02									
203,0	98,99	109,74	120,84	127,99	134,95	148,26	160,79	175,34	188,66								
216,0	106,10	117,76	129,82	137,61	145,21	159,81	173,62	189,77	204,69								
219,1	107,80	119,67	131,96	139,90	147,65	162,56	176,67	193,21	208,51								
229,0	113,22	125,77	138,79	147,23	155,47	171,35	186,44	204,20	220,72								
244,5	121,71	135,33	149,50	158,70	167,70	185,11	201,73	221,40	239,83	257,03							
254,0	126,91	141,18	156,06	165,72	175,19	193,54	211,10	231,94	251,55	269,92	287,06						
267,0	134,02	149,20	165,03	175,34	185,45	205,08	223,93	246,37	267,58	287,55	306,29						
273,0	137,31	152,90	169,18	179,78	190,19	210,41	229,85	253,03	274,98	295,69	315,17	333,42					
298,5	151,27	168,62	186,79	198,65	210,31	233,05	254,99	281,33	306,42	330,28	352,90	374,30	394,46	413,39			
305,0	154,83	172,63	191,27	203,46	215,44	238,82	261,41	288,54	314,43	340,07	362,52	384,72	405,68	425,41			
323,9	165,18	184,28	204,33	217,44	230,36	255,60	280,06	309,51	337,74	364,73	390,49	415,02	438,28	460,34			
330,0	168,52	188,04	208,54	221,95	235,17	261,07	286,07	316,28	345,26	373,01	399,52	424,79	448,84	471,65			
339,7	173,83	194,02	215,24	229,13	242,83	269,63	295,64	327,05	357,22	386,16	413,87	440,34	465,58	489,59			
343,0	175,63	196,05	217,51	231,57	245,43	272,56	298,89	330,71	361,29	390,64	418,75	445,63	471,28	495,70			
355,6	182,53	203,83	226,22	240,89	255,37	283,75	311,33	344,69	376,83	407,73	437,37	465,80	493,00	518,97			
368,0	189,32	211,47	234,77	250,06	265,16	294,75	323,56	358,45	392,11	424,55	455,74	485,71	514,44	541,94			
377,0	194,25	217,02	240,99	256,73	272,26	302,74	332,44	368,44	407,77	439,21	471,80	500,14	529,98	558,58			
406,4	210,33	235,13	261,28	278,46	295,45	328,83	361,42	401,05	439,44	476,60	512,53	547,23	580,69	612,92			
426,0	221,07	247,23	274,83	292,98	310,93	346,25	380,77	422,82	463,64	503,22	541,57	578,68	614,56	649,21			

S235JRH,
S275JOH,
S275J2H,
355JOH,
S355J2H,
S355K2H,
S275NH,
S275NLH,
S355NH,
S355NLH,
S420NH,
S420NLH,
S460NH,
S460NLH

St37.0,
St44.0,
St52.0

E235 -
E470

EN 10216-1 / EN 10216-2 / EN 10216-3

STEEL TUBES DESIGNATED FOR PRESSURE PURPOSES

Dimensions and weight for Hot-rolled

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm																							
	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8	10,0	11,0	12,5	14,2	16,0							
33,7	1,99	2,20	2,41	2,67																				
38,0	2,27	2,51	2,75	3,05	3,35																			
42,4	2,55	2,82	3,09	3,44	3,79	4,21	4,61																	
44,5			3,26	3,63	4,00	4,44	4,87																	
48,3	2,93	3,25	3,56	3,97	4,37	4,86	5,34																	
51,0	3,10	3,44	3,77	4,21	4,64	5,16																		
57,0		3,87	4,25	4,74	5,23	5,83	6,41	7,10	7,88															
60,3		4,11	4,51	5,03	5,10	6,19	6,27	7,55	8,39															
63,5		4,33	4,76	5,32	5,87	6,55	7,21	8,00	8,89															
70,0				5,90	6,51	7,27	8,01	8,89	0,03															
73,0				6,16	6,81	7,60	8,38	9,31	10,36	11,54	12,82	13,93	15,54	16,82	18,65									
76,1		5,24	5,75	6,44	7,11	7,95	8,77	9,74	11,93	12,08	13,44	14,61	16,30	17,66	19,61									
82,5				7,00	7,74	8,66	9,56	10,62	11,84	13,20	14,70	15,99	17,88	19,40	21,58	23,92								
88,9				7,57	8,38	9,36	10,35	11,50	12,83	14,32	15,96	17,38	19,46	21,13	23,55	26,16								
95,0					8,98	10,04	11,10	12,35	13,78	15,39	17,16	18,71	20,96	22,79	25,43	28,29								
101,6				8,70	9,63	10,78	11,91	13,26	14,81	16,55	18,47	20,14	22,59	24,58	27,47	30,61	33,78							
108,0				9,27	10,26	11,49	12,70	14,14	15,80	17,67	19,73	21,53	24,17	26,31	29,44	32,85	36,30							
114,3				9,83	10,88	12,18	13,48	15,01	16,78	18,77	20,97	22,90	25,72	28,02	31,38	35,05	38,79							
121,0								14,30	15,94	17,82	19,94	22,29	24,35	27,37	29,84	33,45	37,40	41,43						
127,0								15,04	16,77	18,75	20,99	23,48	25,65	28,85	31,47	35,30	39,50	43,80						
133,0								15,78	17,59	19,69	22,04	24,66	26,95	30,33	33,10	37,15	41,60	46,17						
139,7								16,61	18,52	20,73	23,22	25,98	28,41	31,99	34,91	39,21	43,95	48,81						
146,0								17,39	19,39	21,70	24,32	27,23	29,78	33,54	36,62	41,15	46,16	51,30						
152,4								18,18	20,27	22,70	25,44	28,49	31,16	35,12	38,36	43,13	48,40	53,82						
159,0								18,99	21,19	23,72	26,60	29,79	32,60	36,75	40,15	45,16	50,71	56,43						
168,3										25,17	28,23	31,63	34,61	39,04	42,67	48,03	53,96	60,10						
177,8										26,64	29,89	33,50	36,68	41,38	45,25	50,96	57,29	63,84						
193,7										29,11	32,67	36,64	40,13	45,30	49,56	55,86	62,86	70,12						
203,0										30,56	34,30	38,47	42,15	47,59	52,09	58,72	66,11	73,79						
216,0										32,58	36,58	41,04	44,97	50,80	55,61	62,73	70,67	78,92						
219,1										33,06	37,12	41,65	45,64	51,57	56,45	63,69	71,75	80,14						
229,0											38,85	43,60	47,79	54,01	59,14	66,74	75,22	84,04						
244,5											37,01	41,57	46,66	51,15	57,83	63,34	71,52	80,65	90,16					
254,0											38,48	43,23	48,53	53,21	60,17	65,92	74,45	83,98	93,91					
267,0											40,50	45,51	51,10	56,03	63,38	69,45	78,45	88,53	99,04					
273,0											41,43	46,56	52,28	57,34	64,86	71,07	80,30	90,63	101,41					
298,5												51,02	57,31	62,87	71,15	77,99	88,16	99,56	111,47					
305,0												52,16	58,60	64,28	72,75	79,76	90,16	101,84	114,03					
323,9												55,47	62,32	68,38	77,41	84,88	95,99	108,45	121,49					
330,0													63,53	69,71	78,92	86,54	97,88	110,59	123,90					
339,7														65,44	71,81	81,31	89,17	100,87	113,99	127,73				
343,0															66,09	72,53	82,12	90,06	101,88	115,14	129,03			
355,6																68,57	75,26	85,23	93,48	105,77	119,56	134,00		
368,0																	71,03	77,95	88,28	96,85	109,59	123,89	138,89	
377,0																		79,91	90,50	99,29	112,36	127,05	142,44	
406,4																			86,29	97,76	107,26	121,43	137,35	154,05
426,0																				102,59	112,58	127,47	144,21	161,78

— Production upon agreement with the mill

Dimensions and weight for Hot-rolled

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm															Steel grades		
	17,5	20,0	22,2	25,0	28,0	30,0	32,0	36,0	40,0	45,0	50,0	55,0	60,0	65,0	70,0		75,0	
33,7																		
38,0																		
42,4																		
44,5																		
48,3																		
51,0																		
57,0																		
60,3																		
63,5																		
70,0																		
73,0																		
76,1																		
82,5																		
88,9																		
95,0																		
101,6																		
108,0																		
114,3																		
121,0																		
127,0																		
133,0																		
139,7																		
146,0																		
152,4																		
159,0																		
168,3	65,08	73,15	79,99	88,35														
177,8	69,18	77,83	85,19	94,21														
193,7	76,04	85,67	93,89	104,01	114,42	121,11	127,61	140,01	151,62									
203,0	80,06	90,26	98,99	109,74	120,84	127,99	134,95	148,26	160,79	175,34	188,66							
216,0	85,67	96,67	106,10	117,76	129,82	137,61	145,21	159,81	173,62	189,77	204,69							
219,1	87,01	98,20	107,80	119,67	131,96	139,90	147,65	162,56	176,67	193,21	208,51							
229,0	91,28	103,09	113,22	125,77	138,79	147,23	155,47	171,35	186,44	204,20	220,72							
244,5	97,97	110,73	121,71	135,33	149,50	158,70	167,70	185,11	201,73	221,40	239,83	257,03						
254,0	102,07	115,41	126,91	141,18	156,06	165,72	175,19	193,54	211,10	231,94	251,55	269,92	287,06					
267,0	107,68	121,83	134,02	149,20	165,03	175,34	185,45	205,08	223,93	246,37	267,58	287,55	306,29					
273,0	110,27	124,79	137,31	152,90	169,18	179,78	190,19	210,41	229,85	253,03	274,98	295,69	315,17					
298,5	121,27	137,36	151,27	168,62	186,79	198,65	210,31	233,05	254,99	281,33	306,42	330,28	352,90					
305,0	124,08	140,57	154,83	172,63	191,27	203,46	215,44	238,82	261,41	288,54	314,43	346,07	362,52					
323,9	132,23	149,89	165,18	184,28	204,33	217,44	230,36	255,60	280,06	309,51	337,74	364,73	390,49					
330,0	134,87	152,90	168,52	188,04	208,54	221,95	235,17	261,07	286,07	316,28	345,26	373,01	399,52					
339,7	139,05	157,69	173,83	194,02	215,24	229,13	242,83	269,63	295,64	327,05	357,22	386,16	413,87					
343,0	140,48	159,31	175,63	196,05	217,51	231,57	245,43	272,56	298,89	330,71	361,29	390,64	418,75					
355,6	145,92	165,53	182,53	203,83	226,22	240,89	255,37	283,75	311,33	344,69	376,83	407,73	437,37					
368,0	151,27	171,64	189,32	211,47	234,77	250,06	265,16	294,75	323,56	358,45	392,11	424,55	455,74					
377,0	155,15	176,08	194,25	217,02	240,99	256,73	272,26	302,74	332,44	368,44	407,77	444,80	474,21					
406,4	167,84	190,58	210,33	235,13	261,28	278,46	295,45	328,83	361,42	401,05	439,44	476,60	512,53					
426,0	176,30	200,25	221,07	247,23	274,83	292,98	310,93	346,25	380,77	422,82	463,64	503,22	541,57					

P235TR1-P355N

GOST 8731-74/ GOST 8732-78

HOT-ROLLED SEAMLESS STEEL PIPES

Application: for constructing pipelines, producing car elements and mechanisms, structure details, columns, long-well beams, fundamental piles, anti-landslip bearings, in road building, etc.

Dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm												
	2.5	3.0	3.2	3.5	4.0	4.5	5.0	5.5	6.0	6.5	7.0	7.5	8.0
32.0		2.15	2.27	2.46	2.76								
33.7		2.27	2.41	2.61	2.93								
38.0		2.59	2.75	2.98	3.35								
42.0		2.89	3.06	3.32	3.75	4.16							
42.4		2.91	3.09	3.36	3.79	4.21							
45.0		3.11	3.30	3.58	4.04	4.49							
48.3		3.35	3.56	3.87	4.37	4.86							
50.0		3.48	3.69	4.01	4.54	5.05	5.55	6.04					
51.0	2.99	3.55	3.77	4.10	4.64	5.16	5.67	6.17					
57.0	3.36	4.00	4.25	4.62	5.23	5.83	6.41	6.99	7.55	8.10	8.63		
60.0				4.88	5.52	6.16	6.78	7.39	7.99	8.58			
60.3				4.90	5.55	6.19	6.82	7.43	8.03				
63.5				5.18	5.87	6.55	7.21	7.87	8.51				
70.0				5.74	6.51	7.27	8.01	8.75	9.47				
73.0				6.00	6.81	7.60	8.38	9.16	9.91	10.66	11.39	12.11	12.82
76.0				6.26	7.10	7.93	8.75	9.56	10.36	11.14	11.91	12.67	13.42
83.0				6.86	7.79	8.71	9.62	10.51	11.39	12.26	13.12	13.96	14.80
89.0				7.38	8.38	9.38	10.36	11.33	12.28	13.22	14.16	15.07	15.98
95.0					8.98	10.04	11.10	12.14	13.17	14.19	15.19	16.18	17.16
102.0					9.67	10.82	11.96	13.09	14.21	15.31	16.40	17.48	18.55
108.0					10.26	11.49	12.70	13.90	15.09	16.27	17.44	18.59	19.73
114.0					10.85	12.15	13.44	14.72	15.98	17.23	18.47	19.70	20.91
121.0							14.30	15.67	17.02	18.35	19.68	20.99	22.29
127.0							15.04	16.48	17.90	19.32	20.72	22.10	23.48
133.0							15.78	17.29	18.79	20.28	21.75	23.21	24.66
140.0							16.65	18.24	19.83	21.40	22.96	24.51	26.04
146.0							17.39	19.06	20.72	22.36	24.00	25.62	27.23
152.0							18.13	19.87	21.60	23.32	25.03	26.73	28.41
159.0							18.99		22.64	24.45	26.24	28.02	29.79
168.0									23.97	25.89	27.79	29.69	31.57
178.0									25.45	27.81	29.52	31.54	33.54
180.0									25.75	30.06	29.87	31.91	33.93
194.0									27.82	31.50	32.28	34.50	36.70
203.0									29.15	34.06	33.84	36.16	38.47
219.0									31.52		36.60	39.12	41.63
245.0									35.36		41.09	43.93	46.76
273.0									39.51		45.92	49.11	52.28
299.0											50.41		57.41
325.0											54.90	58.73	62.54
351.0													67.67
356.0													68.66
377.0													
406.0													
426.0													

— Production upon agreement with the mill

Outside diameter, mm	Weight per length unit. kg/m. wall thickness. mm													Steel grades			
	8.5	9.0	9.5	10.0	11.0	12.0	13.0	14.0	15.0	16.0	17.0	18.0	19.0				
32.0																	
33.7																	
38.0																	
42.0																	
42.4																	
45.0																	
48.3																	
50.0																	
51.0																	
57.0																	
60.0																	10. 20. 35.
60.3																	45. 50. 09Г2С.
63.5																	10Г2. 20Х.
70.0																	40Х.15ХМ.
73.0	13.52	14.21	14.88	15.54	16.82	18.05		20.37	21.46	22.49							30ХМА. 15Х.
76.0	14.15	14.87	15.58	16.28	17.63	18.94	20.20	21.41	22.57	23.68							15ХА. 35Х.
83.0	15.62	16.42	17.22	18.00	19.53	21.01	22.44	23.82	25.15	26.44	27.67	28.85	29.99				20ХМ.20Г.
89.0	16.87	17.76	18.63	19.48	21.16	22.79	24.37	25.89	27.37	28.80	30.19	31.52	32.80				30Г2. 35Г2.
95.0	18.13	19.09	20.03	20.96	22.79	24.56	26.29	27.97	29.59	31.17	32.70	34.18	35.61				10ХСНД. 15ГС.
102.0	19.60	20.64	21.67	22.69	24.69	26.63	28.53	30.38	32.18	33.93	35.64	37.29	38.89				10Г2Б. 38ХА.
108.0	20.86	21.97	23.08	24.17	26.31	28.41	30.46	32.45	34.40	36.30	38.15	39.95	41.70				45Х. 18ХГ.
114.0	22.12	23.31	24.48	25.65	27.94	30.19	32.38	34.53	36.62	38.67	40.67	42.62					33ХС. 30ХМ.
121.0	23.58	24.86	26.12	27.37	29.84	32.26	34.62	36.94	39.21	41.43	43.60	45.72					15ХФ. 35ХМ.
127.0	24.84	26.19	27.53	28.85	31.47	34.03	36.55	39.01	41.43	43.80	46.12	48.39					40ХФА. 40ХН.
133.0	26.10	27.52	28.93	30.33	33.10	35.81	38.47	41.09	43.65	46.17	48.63	51.05	53.42				45ХН. 12ХН2.
140.0	27.57	29.08	30.57	32.06	34.99	37.88	40.72	43.50	46.24	48.93	51.57	54.16					12ХН3А.
146.0	28.82	30.41	31.98	33.54	36.62	39.66	42.64	45.57	48.46	51.30	54.08	56.82					20ХН3А.
152.0	30.08	31.74	33.39	35.02	38.25	41.43	44.56	47.65	50.68	53.66	56.60	59.48	62.32				20Х2Н4А.
159.0	31.55	33.29	35.03	36.75	40.15	43.50	46.81	50.06	53.27	56.43	59.53	62.59	65.60				30ХН3А.
168.0	33.43	35.29	37.13	38.97	42.59	46.17	49.69	53.17	56.60	59.98	63.31	66.59	69.82				30ХГСА.
178.0	35.53	37.51	39.48	41.43	45.30	49.13	52.90	56.62	60.30	63.92	67.50	71.03	74.50				30ХГСН2А.
180.0	35.95	37.95	39.95	41.92	45.85	49.72	53.54	57.31	61.04	64.71	68.34	71.91	75.44				40ХН2МА.
194.0	38.89	41.06	43.23	45.38	49.64	53.86	58.03	62.15	66.22	70.24	74.21	78.13	82.00				38Х2Н2МА.
203.0	40.77	43.06	45.33	47.60	52.09	56.52	60.91	65.25	69.55	73.79	77.98	82.12	86.22				18Х2Н4МА.
219.0	44.13	46.61	49.08	51.54	56.43	61.26	66.04	70.78	75.46	80.10	84.69	89.23	93.71				38Х2МЮА.
245.0	49.58	52.38	55.17	57.95	63.48	68.95	74.38	79.76	85.08	90.36	95.59	100.77	105.90				
273.0	55.45	58.60	61.73	64.86	71.07	77.24	83.36	89.42	95.44	101.41	107.33	113.20	119.02				
299.0	60.90	64.37	67.83	71.27	78.13	84.93	91.69	98.40	105.06	111.67	118.23	124.74	131.20				
325.0	66.35	70.14	73.92	77.68	85.18	92.63	100.03	107.38	114.68	121.93	129.13	136.28	143.38				
351.0	71.80	75.91	80.01	84.10	92.23	100.32	108.36	116.35	124.29	132.19	140.03	147.82	155.56				
356.0		77.02	81.18	85.33	93.59	101.80	109.97	118.08	126.14	134.16	142.12	150.04	157.91				
377.0		81.68	86.10	90.51	99.29	108.02	116.70	125.33	133.91	142.44	150.93	159.36	167.75				
406.0		88.12	92.89	97.66	107.15	116.60	126.00	135.34	144.64	153.89	163.09	172.24	181.34				
426.0				102.59	112.58	122.52	132.41	142.25	152.04	161.78	171.47	181.11	190.71				

Dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wallthickness, mm																				Steel grades			
	20,0	22,0	24,0	25,0	26,0	28,0	30,0	32,0	34,0	35,0	36,0	38,0	40,0	42,0	45,0	48,0	50,0	56,0	60,0	63,0		70,0	75,0	
73.0																								
76.0																								
83.0																								
89.0	34.03	36.35	38.47																					
95.0	36.99	39.61																						
102.0	40.44	43.40	46.17																					
108.0	43.40	46.66	49.72	51.17	52.58	55.24																		
114.0	46.36	49.91	53.27	54.87	56.43	59.38																		
121.0	49.82	53.71	57.41	59.19	60.91	64.22	67.33																	
127.0	52.78	56.97	60.96	62.89	64.76	68.36	71.76																	
133.0	55.73	60.22	64.51	66.59		72.50	76.20	79.71																
140.0	59.19	64.02	68.66	70.90		77.34	81.38	85.23	88.88	90.63	92.33													
146.0	62.15	67.28	72.21	74.60	76.94	81.48	85.82	89.97	93.91		97.66													
152.0	65.11	70.53	75.76	78.30	80.79	85.62	90.26	94.70	98.94		102.99													
159.0	68.56	74.33	79.90	82.62		90.46	95.44	100.22	104.81		109.20		117.39											
168.0	73.00	79.21	85.23	88.16		96.67	102.10	107.33	112.36	114.80	117.19	121.83	126.27		136.50									
178.0	77.93																							
180.0	78.92	85.72	92.33	95.56		104.96	110.98	116.80	122.42		127.85	133.07			149.82									
194.0	85.82	93.32	100.62	104.19	107.72	114.63	121.33	127.85	134.16	137.24	140.27	146.19	151.91	157.44	165.36									
203.0	90.26	98.20	105.95	109.74	113.49	120.84	127.99	134.95	141.70	145.01	148.26	154.63	160.79	166.76	175.34	183.48	188.66							
219.0	98.15	106.88	115.42	119.61	123.75	131.89	139.83	147.57	155.12	158.82	162.47	169.62	176.58		193.10		208.39		235.27					
245.0	110.98	120.99	130.80	135.64	140.42	149.84	159.07	168.09	176.92	181.26	185.55	193.99	202.22	210.26	221.95	233.20	240.45	261.02	273.74					
273.0	124.79	136.18	147.38	152.90	158.38	169.18	179.78	190.19	200.40	205.43	210.41	220.23	229.85	239.27	253.03	266.34	274.98	299.69	315.17	326.27				
299.0	137.61	150.29	162.77	168.93	175.05	187.13	199.02	210.71	222.20	227.87	233.50	244.59	255.49	266.20	281.88	297.12	307.04	335.59	353.65	366.67	395.32	414.31		
325.0	150.44	164.39	178.15	184.96	191.72	205.09	218.25	231.23	244.00	250.31	256.58	268.96	281.14	293.13	310.73	327.90	339.10	371.50	392.12	407.06	440.21	462.40		
351.0	163.26	178.50	193.54	200.99	208.39	223.04	237.49	251.74	265.80	272.76	279.66	293.32	306.79	320.06	339.59	358.68	371.16	407.41	430.59	447.46	485.09	510.49		
356.0	165.73	181.21	196.50	204.07	211.60	226.49	241.19	255.69	269.99	277.07	284.10	298.01	311.72	325.24	345.14	364.60	377.32	414.31	437.99	455.23	493.72	519.74		
377.0	176.08	192.61	208.93	217.02	225.06	240.99	256.73	272.26	287.60	295.20	302.74	317.69	332.44	346.99	368.44	389.45	403.22	443.32	469.06	487.85	529.98	558.58		
406.0	190.39	208.34	226.10	234.90	243.66	261.02	278.18	295.15	311.92	320.23	328.49	344.87	361.04	377.03	400.63	423.78	438.97	483.37	511.97	532.91	580.04	612.22		
426.0	200.25	219.19	237.93	247.23	256.48	274.83	292.98	310.93	328.69	337.49	346.25	363.61	380.77	397.74	422.82	447.46	463.64	510.99	541.57	563.98	614.56	649.21		

— Production upon agreement with the mill



WELDED PIPES

ASTM A 53/A 53 M, ANSI/ASME B36.10M

Application: for producing structures, as well as for steam, water, gas and air pipelines, and also in general machine-building and tool-making. Steel grade – A, B
Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
1/2	0.840	21.3	0.109	2.77	0.85	1.27		
3/4	1.050	26.7	0.113	2.87	1.13	1.69		
1	1.315	33.4	0.133	3.38	1.68	2.50	STD	40
1 ¼	1.660	42.2	0.140	3.56	2.27	3.39	STD	40
1 ½	1.900	48.3	0.125	3.18	2.37	3.54		30
			0.145	3.68	2.72	4.05	STD	40
2	2.375	60.3	0.141	3.58	3.36	5.01		
			0.156	3.91	3.66	5.44	STD	40
3	3.500	88.9	0.125	3.18	4.51	6.72		
3 ½	4.000	101.6	0.125	3.18	5.18	7.72		
4	4.500	114.3	0.125	3.18	5.85	8.71		
8	8.625	219.1	0.188	4.78	16.98	25.26		
			0.203	5.15	18.26	27.22		
			0.219	5.56	19.66	29.28		
			0.250	6.35	22.38	33.32		20
			0.277	7.04	24.70	36.81		30
			0.312	7.92	27.70	41.24		
			0.322	8.18	28.55	42.55	STD	40
			0.344	8.74	30.42	45.34		
			0.375	9.53	33.04	49.25		
10	10.750	273.0	0.406	10.31	35.64	53.08		60
			0.203	5.16	22.87	34.09		
			0.219	5.56	24.63	36.68		
			0.250	6.35	28.04	41.77		20
			0.279	7.09	31.20	46.51		
			0.307	7.8	34.24	51.03		30
			0.344	8.74	38.23	56.98		
0.365	9.27	40.52	60.29	STD	40			
12	12.750	323.8	0.219	5.56	29.31	43.65		
			0.250	6.35	33.38	49.73		20
			0.281	7.14	37.42	55.77		
			0.312	7.92	41.45	61.71		
			0.330	8.38	43.77	65.2		30
			0.344	8.74	45.58	67.93		
			0.375	9.53	49.56	73.88	STD	
			0.406	10.31	53.52	79.73		40
14	14.000	355.6	0.219	5.56	32.23	47.99		
			0.250	6.35	36.71	54.69		10
			0.281	7.14	41.17	61.35		
			0.312	7.92	45.61	67.9		20
			0.344	8.74	50.17	74.76		
			0.375	9.53	54.57	81.33	STD	30
			0.406	10.31	59.00	87.79		
16	16	406.4	0.250	6.35	42.05	62.64		10
			0.281	7.14	47.17	70.3		
			0.312	7.92	52.27	77.83		20

Pipe dimensions and weight

Nominal size	Outside diameter		Wall thickness		Weight per length unit		Weight class	Schedule
	in	mm	in	mm	lb/ft	kg/m		
16	16	406.4	0.344	8.74	57.52	85.71		
			0.375	9.53	62.64	93.27	STD	30
			0.406	10.31	67.68	100.71		
20	20	508	0.250	6.35	52.78	78.55		10
			0.281	7.14	59.23	88.19		
			0.312	7.92	65.66	97.67		
			0.344	8.74	72.28	107.6		
			0.375	9.52	78.87	117.02	STD	20
			0.406	10.31	84.04	126.53		

DIN EN 10255 UNALLOYED STEEL TUBES SUITABLE FOR WELDING AND THREADING

Application: for transportation fluids and general purpose

Nominal size, mm	H (heavy-weight)				M (medium-weight)		Type L1				Type L2				Steel grades
	Outside diameter, mm		Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	Outside diameter, mm		Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	Outside diameter, mm		Wall thickness, mm	Weight per length unit, kg/m (plain ends green pipe)	
	max.	min.					max.	min.			max.	min.			
21,3	-	-	-	-	2,6	1,21	21,7	21	2,3	1,08	21,4	21,0	2,0	0,947	S195T
26,9	21,8	21,0	3,2	1,44	2,6	1,56	27,1	26,4	2,3	1,4	26,9	26,4	2,3	1,38	
33,7	-	-	-	-	3,2	2,41	34,0	33,2	2,9	2,2	33,8	33,2	2,6	1,98	
42,4	42,9	42,0	4,0	3,79	3,2	3,1	42,7	41,9	2,9	2,82	42,5	41,9	2,6	2,54	
48,3	48,8	47,9	4,0	4,37	3,2	3,56	48,6	47,8	2,9	3,25	48,4	47,8	2,9	3,23	
60,3	-	-	-	-	3,6	5,03	60,7	59,6	3,2	4,51	60,2	59,6	2,9	4,08	
76,1	-	-	-	-	3,6	6,42	76	75,2	3,2	5,75	76,0	75,2	3,2	5,71	
88,9	-	-	-	-	4,0	8,36	88,7	87,9	3,6	7,55	88,7	87,9	3,2	6,72	
114,3	-	-	-	-	-	-	113,9	113,9	4,0	10,8	113,9	113	4,0	9,75	



EN 10217-1 UNALLOYED STEEL TUBES WITH SPECIFIED ROOM TEMPERATURE PROPERTIES

Application: for using under pressing load
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm																	Steel grades		
	1,5	1,8	2,0	2,3	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8	10,0		11,0	
17,2	0,58	0,68	0,75	0,85																
21,3	0,73	0,87	0,95	1,08	1,20	1,32														
26,9		1,11	1,23	1,40	1,56	1,72	1,87													
32,0		1,34	1,48	1,69	1,89	2,08	2,27	2,52	2,76											
33,7		1,42	1,56	1,78	1,99	2,20	2,41	2,67	2,93											
42,4		1,80	1,99	2,28	2,55	2,83	3,09	3,45	3,79											
48,3		2,06	2,28	2,61	2,93	3,25	3,56	3,97	4,37											
51,0		2,18	2,42	2,76	3,10	3,44	3,77	4,21	4,64											
57,0		2,45	2,71	3,10	3,49	3,87	4,25	4,74	5,23											
60,3			2,88	3,30	3,70	4,11	4,51	5,03	5,55											P195TR1/ TR2 -
76,1			3,66	4,19	4,71	5,24	5,75	6,44	7,11											P265TR1/ TR2
88,9			4,29	4,91	5,53	6,15	6,76	7,57	8,38											
101,6			4,91	5,63	6,35	7,06	7,77	8,70	9,63											
108,0			5,23	6,00	6,76	7,52	8,27	9,27	10,30											
114,3			5,54	6,35	7,16	7,97	8,77	9,80	10,90	12,20										
219,1										23,82	26,40	29,50	33,10	37,10	41,60	45,64	51,57			
273,0											33,00	36,90	41,40	46,60	52,30	57,30	64,86			
323,9												44,00	49,30	55,50	62,30	68,40	77,40			
355,6												48,30	54,30	61,00	68,60	75,30	85,20			
406,4													62,20	69,90	78,60	86,30	97,80			
508,0														77,00	87,70	98,60	108,00	123,00	134,82	

— Production upon agreement with the mill

EN 10217-2 / EN 10217-3 UNALLOYED STEEL TUBES WITH SPECIFIED ROOM TEMPERATURE PROPERTIES

Application: for using under pressing load
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm									Steel grades	
	4,50	5,0	5,6	6,3	7,1	8,0	8,8	10,0	11,0	EN 10217-2	EN 10217-3
219,1	23,82	26,4	29,5	33,1	37,1	41,6	45,64	51,57		P195GH P235GH P265GH	P355N
273,0		33,0	36,9	41,4	46,6	52,3	57,3	64,86			
323,9			44,0	49,3	55,5	62,3	68,4	77,4			
355,6			48,3	54,3	61,0	68,6	75,3	85,2			
406,4				62,2	69,9	78,6	86,3	97,8			
508,0					77,9	87,7	98,6	108,0	123,0	134,8	

— Production upon agreement with the mill



EN 10219:2006

WELDED STRUCTURAL ROUND PIPES FOR METAL STRUCTURES

Application: on-ground and underground construction, bridge and crane building
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm														Steel grades	
	2	2,5	3	4	4,5	5	5,6	6	6,3	7,1	8	9,5	10	11		
21,3	0,95	1,08														S235JRH
26,9	1,23	1,40	1,56													
33,7	1,56	1,78	1,99													
42,4	1,99	2,28	2,55	2,83												
48,3	2,28	2,61	2,93	3,25												
60,3	2,88	3,56	3,70	4,11												
76,1	3,66	4,19	4,71	5,24												
88,9	4,29	4,91	5,53	6,15												
101,6			6,35	7,06												
114,3			7,16	7,97												
219,1					23,82	26,40	29,50	31,53	33,10	37,10	41,60	49,10	51,57			S235JRH - S355J2H
273						33,00	36,90	39,51	41,40	46,60	52,30	61,73	64,86			
323,9							44,00	47,04	49,30	55,50	62,30	73,66	77,41			
355,6							48,30	51,73	54,30	61,00	68,60	81,09	85,23			
406,4								59,25	62,20	69,90	78,60	92,99	97,76			
508									77,90	87,70	98,60	116,79	122,81	134,82		

— Production upon agreement with the mill

EN 10224:2002

UNALLOYED STEEL PIPES AND FITINGS FOR PIPELINES

Application: for water transportation (including drinking water)
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm																Steel grades
	2,0	2,3	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8	10,0	11,0	
21,3	0,95	1,08	1,20														L235
26,9	1,23	1,40	1,56	1,72	1,87												
33,7	1,56	1,78	1,99	2,20	2,41												
42,4	1,99a	2,27	2,55	2,82	3,09	3,09	3,79										
48,3	2,28	2,61	2,93	3,25	3,56	3,56	4,37										
60,3	2,88	3,29	3,76	4,11	4,51	4,51	5,55										
76,1	3,66	4,19	4,71	5,24	5,75	5,75	7,11										
88,9	4,29	4,91	5,53	6,15	6,76	6,76	8,38										
101,6					7,77	7,77	9,63										
114,3					8,77	8,77	10,88										
219,1								23,82	26,40	29,50	33,10	37,10	41,60	45,64	51,56		L235 L275 L355
273									33,00	36,90	41,40	46,60	52,30	57,36	64,86		
323,9										44,00	49,30	55,50	62,30	68,38	77,41		
355,6										48,30	54,30	61,00	68,60	75,26	85,23		
406,4											62,20	69,90	78,60	86,29	97,76		
508											77,90	87,70	98,60	108,34	122,81	134,82	

— Production upon agreement with the mill

GOST 10705-80

ERW LONGITUDINALLY WELDED STEEL TUBES

Application: for pipelines and different purpose structure
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm																				Steel grades				
	1,5	2,0	2,2	2,5	2,8	3,0	3,2	3,5	3,8	4,0	4,5	5,0	5,5	6,0	6,5	7,0	7,5	8,0	8,5	9,0		9,5	10,0		
21,3		0,95																						08кп, 08пс, Ст1кп, Ст1пс, Ст2сп, Ст2пс, Ст3сп, Ст3пс, 10, 10пс, 20, 20пс	
27		1,23	1,35	1,51																					
32		1,48	1,62	1,82	2,02	2,15																			
33		1,53	1,67	1,88	2,09	2,22																			
40	1,42	1,87	2,05	2,31	2,57	2,74																			
42		1,97	2,16	2,44	2,71	2,89																			
45		2,12	2,32	2,62	2,91	3,11																			
48		2,27	2,48	2,81	3,12	3,33	3,54	3,84																	
51	1,83	2,42	2,65	2,99	3,33	3,55	3,77	4,10																	
57		2,71	2,97	3,36	3,74	4,00	4,25	4,62																	
60				3,55	3,95	4,22	4,48	4,88	5,27																
76				4,53	5,05	5,40	5,75	6,26	6,26	7,10															
89						6,36	6,77	7,38	7,98	8,38															
102						7,32	7,80	8,50	9,20	9,67	10,82														
108						7,77	8,27	9,02	9,76	10,26	11,49														
114						8,21	8,74	9,54	10,33	10,85	12,15														
159										17,14	18,99	20,82	22,64	24,44	26,24									Ст3сп, Ст3пс, 10, 10пс, 20, 20пс, К50, К52, К55, К60 (17Г1С-У, 09Г2С, 09Г3Ф, 13ХФА, 13Г1С-У, 10Г2ФБЮ)	
219											26,39	28,96	31,52	34,06	36,60	39,12	41,63								
273											33,05	36,28	39,51	42,72	45,92	49,11	52,28	55,44	58,60						
325												43,34	47,20	51,06	54,90	58,73	62,54	66,35	70,14	73,92	77,68				
355,6												47,49	51,73	55,95	60,18	64,38	68,58	72,75	76,93	81,08	85,23				
406,4													59,25	64,10	68,95	73,77	78,60	83,40	88,20	92,98	97,76				
426													62,15	67,25	72,33	77,41	82,47	87,52	92,55	97,58	102,59				
530																90,29	96,64	102,99	109,32	115,64	121,94	128,24			

GOST 20295-85

STEEL WELDED TUBES FOR GAS AND OIL MAIN PIPELINES

Application: for construction of gas and oil main pipelines, oil-products pipelines, process and field pipelines
Pipe dimensions and weight

Outside diameter, mm	Weight per length unit, kg/m, wall thickness, mm														Steel grades										
	4,5	5,0	5,5	6,0	6,5	7,0	7,5	8,0	8,5	9,0	9,5	10,0	11,0	12,0		13,0	14,0	14,9							
159	17,14	18,99	20,82	22,64	24,44	26,24																		К34 (10, 10пс) К38 (Ст3сп, Ст3пс) К42 (20, 20пс) К50, К52, К55, К60 (17Г1С-У, 09Г2С, 13Г1С-У, 10Г2ФБЮ)	
219		26,39	28,96	31,52	34,06	36,60	39,12	41,63																	
273			33,05	36,28	39,51	42,72	45,92	49,11	52,28	55,44	58,60														
325				43,34	47,20	51,06	54,90	58,73	62,54	66,35	70,14	73,92	77,68												
426					62,15	67,25	72,33	77,41	82,47	87,52	92,55	97,58	102,59												
530							90,29	96,64	102,99	109,32	115,64	121,94	128,24												
1020														224,39	236,74	249,08	273,72	298,31	322,84	347,33	369,33			Ст3сп, 20, 13Г1С-У, 13Г1СБ-У, 17Г1С-У, 10Г2ФБЮ	

— Production upon agreement with the mill

SQUARE AND RECTANGULAR PIPES (HOLLOW SECTIONS)

EN 10219:2006 WELDED STRUCTURAL HOLLOW SECTIONS

Application: on-ground and underground construction, bridge and crane building
Pipe dimensions and weight

Dimensions, mm		Weight per length unit, kg/m, wall thickness, mm										Steel grades
A	B	1,5	1,8	2,0	2,2	2,5	2,8	3,0	3,2	3,5	4,0	
17	17		0,82	0,89	0,96	1,05						
20	20	0,84	0,98	1,08	1,16	1,29						
25	25	1,08	1,27	1,39	1,51	1,68		1,95				
25	28		1,35	1,49	1,61	1,80		2,09				
30	20	1,08	1,27	1,39	1,51	1,68		1,95				
30	25			1,55	1,68	1,88		2,19				
30	30	1,31	1,55	1,70	1,85	2,07		2,42				
35	20			1,55	1,68	1,88	2,07	2,19				
35	30			1,86	2,03	2,27	2,50	2,66				
35	35		1,83	2,02	2,20	2,46	2,72	2,89				
40	20	1,31	1,55	1,70	1,85	2,07	2,29	2,42				
40	25	1,43	1,69	1,86	2,03	2,27	2,50	2,66				
40	28		1,78	1,95	2,13	2,39	2,64	2,80				
40	30		1,83	2,02	2,20	2,47	2,72	2,89				
40	40	1,78	2,12	2,33	2,55	2,85	3,16	3,36	3,56	3,85	4,31	
45	20			1,86	2,03	2,27	2,50	2,66				
45	45		2,40	2,65	2,89	3,25	3,60	3,83	4,06	4,39	4,93	
50	25	1,67	1,97	2,17	2,37	2,66	2,94	3,13	3,31	3,57	3,99	
50	28		2,06	2,27	2,48	2,78	3,08	3,27	3,46	3,74	4,18	
50	30		2,12	2,32	2,55	2,86	3,16	3,36	3,56	3,85	4,31	S235JRH- S275J0H
50	40		2,40	2,65	2,89	3,25	3,60	3,83	4,06	4,39	4,93	
50	45		2,54	2,80	3,06	3,45	3,82	4,07	4,31	4,67	5,25	
50	50		2,68	2,96	3,24	3,64	4,04	4,31	4,56	4,94	5,56	
60	28		2,34	2,58	2,82	3,17	3,52	3,74				
60	30		2,40	2,65	2,89	3,25	3,60	3,83	4,06	4,39	4,93	
60	35			2,80	3,06	3,45	3,82	4,07	4,31	4,67	5,25	
60	40			2,96	3,24	3,64	4,04	4,30	4,56	4,94	5,56	
60	60			3,59	3,93	4,43	4,92	5,25	5,57	6,04	6,82	
70	50			3,59	3,93	4,43	4,92	5,25	5,57	6,04	6,82	
70	70			4,22	4,62	5,21	5,80	6,19	6,57	7,14	8,07	
80	40			3,59	3,93	4,43	4,92	5,25	5,57	6,04	6,82	
80	60			4,22	4,62	5,21	5,80	6,19	6,57	7,14	8,07	
80	80			4,84	5,31	6,00	6,68	7,13	7,58	8,24	9,33	
90	50			4,22	4,62	5,21	5,80	6,19	6,57	7,14	8,07	
90	90			5,47	6,00	6,78	7,56	8,07	8,58	9,43	10,59	
100	40			4,22	4,62	5,21	5,80	6,19	6,57	7,14	8,07	
100	50			4,53	4,96	5,61	6,24	6,66	7,08	7,69	8,70	
100	60			4,84	5,31	6,00	6,68	7,13	7,58	8,24	9,33	
100	80			5,47	6,00	6,78	7,56	8,18	8,71	9,50	10,81	



POLYETHYLENE COATED PIPES

DIN 30670

POLYETHYLENE COATING ON STEEL PIPES AND FITTINGS EXTERNAL

Coating execution:

N – normal execution (at temperatures of up to 50 °C);
S – special execution (at temperatures of up to 70 °C).

Coating thickness:

Pipe nominal outside diameter, mm	Coating thickness, at least, mm	
	Normal thickness (n)	Reinforced thickness (v)
From 100 to 250 inclusive	2.0	2.7
From 250 to 500 inclusive	2.2	2.9
From 500 to 530 inclusive	2.5	3.2

Pipe length: 10-13 m

Coating requirements:

Coating characteristics	Norm	
	Execution type	
	Normal	Special
Dielectric continuity, kV, no less than	Lack of electric current in 25 kV	
Impact strength of (23±2) °C, J but no less, for the tubes in diameter: - 200 mm and over - up to 200 mm	5 4.25	5 4.25
Adherence of coating to steel l/cm, no less than temperature: - (20±5) °C - (50±5) °C	35 15	35 25



EN ISO 21809-2011

EXTERNAL THREE-LAYER POLYETHYLENE COATING

Coating thickness:

Weight of 1 meter of pipe Pm/m (kg/m)	Total coating thickness, at least, mm					
	Class A1	Class A2	Class A3	Class B1	Class B2	Class B3
Pm ≤ 15	1.8	2.1	2.6	1.3	1.8	2.3
15 < Pm ≤ 50	2.0	2.4	3.0	1.5	2.1	2.7
50 < Pm ≤ 130	2.4	2.8	3.5	1.8	2.5	3.1

Coating type:

Coating classes:

Class A – used for application at pipeline service temperatures from minus 20 °C to plus 60 °C.

Class B – used for application at pipeline service temperatures from minus 40 °C to plus 80 °C.

Acceptance testing of pipes with coating:

- external appearance of coating check;
- length measuring of bare ends;
- taper angle measuring coating to the pipe's body;
- dielectric coating integrity testing;
- thickness of coating testing;
- strength test of coating with the impact up to (23±3) °C;

Peel force control:

Class A – at temperatures of plus 23 °C and plus 60 °C;

Class B – at temperatures of plus 23 °C and plus 80 °C;

- cathodic disbondment test;
- hot water coating test.



EN 10288

EXTERNAL TWO-LAYER POLYETHYLENE COATING

Coating thickness:

Composition of the coating	Tube nominal outside diameter, mm	Coating thickness class, mm, at least		
		1	2	3
Two-layer polyethylene coating	Up to 114.3 inclusive	1.5	1.8	2.5
	From 114 to 273 inclusive	1.8	2.0	2.7
	From 273 to 508 inclusive	2.0	2.2	2.9
	From 508 to 762 inclusive	2.2	2.5	3.2

Coating type:

Type 1 – at service temperatures up to plus 60 °C;
Type 2 – at service temperatures up to plus 30 °C;

Acceptance testing of pipes with coating:

- external appearance of coating check;
- length measuring of bare ends;
- taper angle measuring coating to the pipe's body;
- dielectric coating integrity testing;
- thickness of coating testing;
- strength test of coating with the impact up to (20 ± 5) °C;
- peel force control at temperatures of plus (23 ± 2) °C and plus (60 ± 2) °C.



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