

M08/02-V74

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UNI EN ISO 9001:2015

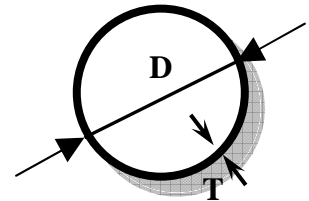
Produzione Tubi Saldati in :  
Acciaio al Carbonio - Acciai di Qualità - Acciaio Inox

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

outer  $\varnothing$  320 – 325 – 330 – 350 – 400 – 404 – 434 – 450 – 500 – 506 mm

outer  $\varnothing$  368 – 630 mm (upon request)

1,5 mm  $\leq$  Thickness  $\leq$  3.5 mm



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

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

**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
- $1500 \leq L < 6000$  mm (-0 mm +5 mm) profiled
- $L < 1500$  mm (-0 mm +3 mm) plasma cutting

**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 featuring helical weld seams with TIG electrodes.

**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 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