

PIPES FOR GENERAL CORROSION SERVICE

ASTM A312 – ASME SA312

Seamless and welded pipes for chemical and petrochemical industries

USE High temperature and general corrosive service

STEEL GRADE TP304/TP304L - TP316/TP316L - TP321/TP321H

PROCESSING

- Seamless
- Welded

TOLERANCES **THICKNESS**

Diameter (mm)	Tolerance thickness (%)	
	10,3 < D ≤ 73,0 all t/D ratios	+20
88,9 < D ≤ 457 with t/D ≤ 5%	+22,5	-12,5
88,9 < D ≤ 457 with t/D > 5%	+15,0	-12,5
508,0 ≤ D - welded all t/D ratios	+17,5	-12,5
508,0 ≤ D - seamless t/D ≤ 5%	+22,5	-12,5
508,0 ≤ D - seamless t/D > 5%	+15	-12,5

OUTSIDE DIAMETER

Diameter (mm)	Tolerance (mm)	
	10,3 < D ≤ 48,3	+0,4
48,3 < D ≤ 114,3	+0,8	-0,8
114,3 < D ≤ 219,1	+1,6	-0,8
219,1 < D ≤ 457	+2,4	-0,8
457 < D ≤ 660	+3,2	-0,8
660 < D ≤ 864	+4,0	-0,8
864 < D ≤ 1219	+4,8	-0,8

MASS

The benchmark parameters must be identified in the ANSI B36.10 and ANSI B36.19 standards and for non-standardized sizes the following equation must be applied:

$$M = t(D - t) \times C$$

STRAIGHTNESS

- Seamless: reasonably straight
- Welded: 3,2mm for pipes with a length ≥ 3m

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MARKING

Pipes with $D \leq 48,3\text{mm}$ will be identified by means of a label applied to one end of the bundle

Pipes with $D > 48,3\text{mm}$ will be marked legibly 300mm from one end with the following information:

- Manufacturer's name or trademark
- Reference standard
- Steel grade
- Cast number
- Diameter and thickness
- Length
- Type of manufacture S (seamless) or W (welded)
- Mark the following initials in the cases specified below:
 - ET: eddy-current test
 - UT: ultrasonic test

If not tested with hydraulic test, the manufacturer must affix the initials: NH

CERTIFICATION

UNI EN 10204

SIZE

RANGE

ASME B36.19