

Spiral-welded

Steel pipes – spiral-welded

The pipes are manufactured in line with the following standards: EN 10208-2, EN 10208-1, DIN 1626, DIN 17120, API Spec 5L i EN 10219 and PN-79/H74244.

Outer diameter of spiral-welded steel pipes manufactured by Izostal S.A. ranges from 323.9 mm to 1422 mm; the pipes are delivered with straight or bevelled end faces. Tightness test and automatic, non-destructive ultrasound and/or radiological test (the latter at the customer's request) are carried out prior to delivery.

Upon arranging technical specification we deliver pipes of diameter and wall thickness values outside of the range specified in the abovementioned chart, provided the desired diameter value is within the outer diameter range of 323.9 mm and 1422 mm.. Minimum length: 4 metres; maximum length: 14.2 metres.

The pipes are made of killed, unalloyed and low-alloy standard, quality or special steel, depending on the required mechanical and technical performance as well as the intended use.

The pipes are delivered in black, without the protective coating, externally coated with extrusion moulded three layer polyethylene coating, additionally coated externally with cement and internally coated with epoxy or cement coating, in line with the customer's requirements.

Delivery of pipes with other anticorrosive protection requires earlier arrangements.

Delivery condition standard		Strength class or steel grade				
PN-79/H-74244		G 235	G 295	G 335		
EN 10208-1		L235 GA L245 GA	L290 GA	L360 GA		
EN 10208-2		L245NB/MB	L290NB/MB	L360NB/MB	L415NB/MB	L450MB L485MB
DIN 1626		St 37.0	St 44.0	St 52.0		
DIN 17120		RSt 37-2 St 37-3	St 44-2 St 44-3	St 52-3		
API Spec 5L		B	X42	X52	X60	X65 X70
Outer diameter		Wall thickness mm/inch				
mm	cal					

323,9	12,75	5,0 – 10,0 0,197 – 0,394				
335,6	14	5,0 – 8,8 0,197 – 0,364				
357	18	5,6 – 11,0 0,220 – 0,433				
508	20	6,3 – 14,2 0,248 – 0,559				
559	22	6,3 – 14,2 0,248 – 0,559			6,3 – 12,5 0,248 – 0,492	
610	24	7,1 – 14,2 0,280 – 0,559		7,1 – 12,5 0,280 – 0,492		
660	26	7,1 – 14,2 0,280 – 0,559		7,1 - 12,5 0,280 – 0,492	7,1 – 11,0 0,280 – 0,394	
711	28	8,0 – 14,2 0,315 – 0,559	8,0–12,5 0,315–0,492		8,0–11,0 0,315–0,433	8,0 – 10,0 0,315– 0,394
762	30	8,0 – 12,5 0,315 – 0,492		8,0 – 11,0 0,315 – 0,433		8,0 – 10,0 0,315 – 0,394
813	32	8,0 – 12,5 0,315 – 0,492		8,0 – 11,0 0,315 – 0,433		8,0 – 8,8 0,315 – 0,346
864	34	6,3 – 12,5 0,248 – 0,492				
914	36	6,3 – 12,5 0,248 – 0,492				
1016	40	7,1 - 2,5 0,280 – 0,492				
1220	44	7,1 - 12,5 0,280 – 0,492				
1422	56	7,1 - 12,5 0,280 – 0,492				