

Seamless Stainless Steel Tubes for Instrumentation and Hydraulic Systems

■ STANDARDS:

ASME SA-213/SA-213M; ASTM A269/A269M; ASME SA-312/SA312M;
ASME SA-789/SA-789M; ASME SB-163; ASME SB-444; EN 10216-5; EN 10305-1; SEW 470

■ STEEL GRADES:

TP304L (1.4307), TP3161 (1.4435), TP317L (1.4438), TP321 (1.4541), TP316TI (1.4571),
S 31254, S 31803 (1.4462), S 32205 (1.4462), N 08904, N 06625, N 08825,
1.4878, Balev 304, Balev 316, Balev 304 Elastico

■ BASIC PRODUCT RANGE OF INSTRUMENTATION TUBING:

EN 10216-5

Outside diameter	Wall thickness																		
mm	0.5	0.8	1	1.2	1.4	1.6	2	2.3	2.6	2.8	2.9	3.2	3.6	4	4.5	5	5.4	5.6	6.3
6																			
8																			
10																			
10.2																			
12																			
12.5																			
13.5																			
14																			
16																			
17.2																			
18																			
19																			
19.1																			
20																			
21.3																			
22																			
25																			
25.4																			
26.9																			
30																			
31.8																			
32																			
33.7																			
35																			
38																			
40																			
42.4																			
44.5																			
48.3																			
50																			

Note: other sizes are available agreement

ASME SA-213/SA-213M; ASTM A269/A269M; ASME SA-312/SA-312M;
ASME SA-789/SA-789M; ASME SB-163; ASME SB-444

Outside diameter			Wall thickness																	
inch	mm	mm	0.5	0.71	0.89- 0.91	1	1.2	1.4- 1.5	1.6- 1.65	1.83- 1.9	2.0- 2.03	2.11	2.2- 2.3	2.4- 2.5	2.6- 2.64	2.7	3.0- 3.05	3.18- 3.2	3.5- 3.6	4.0
1/8																				
		6.0																		
1/4	6.35	6.35																		
		7.0																		
5/16	7.94	7.94																		
		9.0																		
3/8	9.53	9.53																		
		10.0																		
		10.2																		
7/16	11.00	11.11																		
		12																		
1/2	12.70	12.7																		
		13																		
		13.5																		
		14-14.3																		
		15																		
5/8		15.88																		
		16																		
		17.2-17.5																		
		18																		
		19.0-19.05																		
		20																		
		20.6-21.34																		
		22																		
		22.23																		
		23.81																		
		25																		
1	25.40	25.4																		
1 1/4	31.75																			
		32																		
		33.4																		
		33.7																		
		35																		
		36																		
1 1/2	38.10	38.10																		
		40																		
		42.0-42.4																		
1 3/4	44.45	44.45																		
		48.0-48.3																		
2	50.58	50.8																		

Surface condition

Inner and outer surfaces
bright annealed

Packing

In OSB or woodenboxes /
adequately protected

Tests

Ultrasonic, underwater test,
hydrotest;
100% PMI testing

Hardness

Max 80HRB

■ DIMENSIONAL TOLERANCES FOR

ASME SA-213/SA-213M; SA-312M

Outside diameter, mm	Tolerance limits of	
	outside diameter	wall thickness
<25.4	±0.10 mm	±10%
25.4 – 38.1	±0.15 mm	±10%
38.2 – 50.8	±0.20 mm	±10%

Roughness of the outer diameter, $R_a \leq 0.8 \mu\text{m}$

ASTM A269/A269M; ASME SA-789/SA-789M

Outside diameter, mm	Tolerance limits of	
	outside diameter	wall thickness
<12.7	±0.13 mm	±15%
12.7 – 38.1	±0.13 mm	±10%
38.2 – 50.8	±0.25 mm	±10%

Roughness of the outer diameter, $R_a \leq 0.8 \mu\text{m}$

ASME SB-163; ASME SB-444

Outside diameter, mm	Tolerance limits of	
	outside diameter	wall thickness
<16.0	±0.13 mm	±15%
16.0 – 38.0	±0.13 mm	±10%
38.1 – 50.8	±0.25 mm	±10%

Roughness of the outer diameter, $R_a \leq 0.8 \mu\text{m}$

EN 10305-1

Outside diameter, mm	Tolerance limits of	
	outside diameter	wall thickness
<30.0	±0.08 mm	±10.0% with min ±0.1 mm
30.0 – 40.0	±0.15 mm	±10.0% with min ±0.1 mm
40.1 – 50.8	±0.20 mm	±10.0% with min ±0.1 mm

Roughness of the outer diameter, $R_a \leq 0.8 \mu\text{m}$

■ DIMENSIONAL TOLERANCES FOR

EN 10216-5

Outside diameter, mm	Tolerance limits of			
	outside diameter		wall thickness	
	tolerance class		tolerance class	
	D3	D4	T3	T4
4.0 – 50.8	±0.75% with min ±0.30 mm	±0.50% with min ±0.10 mm	±10.0% with min ±0.20 mm	±7.5% with min ±0.15 mm

Roughness of the outer diameter, Ra ≤ 0.8 µm

■ TESTING OF FINISHED TUBES & PIPES

Standard	Chemical composition	Relative elongation	Hardness	Flattening	Flaring	IC resistance	Hydrostatic non-destructive testing
ASTM A213	B	B	B	B	B	— ¹⁾	K ²⁾
ASTM A269	B	—	B	—	B	— ¹⁾	K ²⁾
ASTM B163	B	B	—	—	B	— ¹⁾	K ²⁾
ASTM B444	B	B	—	—	—	— ¹⁾	K ²⁾
EN 10216-5	B	B	—	—	B	— ¹⁾	K ²⁾

B – random testing

K – testing of each tube

1) Tubes shall be subjected to intergranular corrosion testing conducted by the Manufacturer in accordance with ASTM A262, Method E, unless otherwise specified.

2) Each tube shall be non-destructive or hydrostatic testing.
The Manufacturer shall specify the type of testing to be conducted, unless otherwise specified in the Order.

An advanced heat treatment technology has been developed at CentraVis for cold finished tubes that allows for UNS S 31803/S 32205 material to meet the mechanical properties of UNS S32750 and S 32760 without the loss of ductility and corrosion properties (offered as an option)

■ MAXIMUM WORKING PRESSURE AT AMBIENT TEMPERATURE

OD		WT		TP304L, TP316L, TP317L, 1.4307, 1.4435, 1.4438		S31254, 1.4547		N08904, 1.4539		S31803, S32205, 1.4462		N08825, 2.4858		N06625, 2.4856	
				psi	bar	psi	bar	psi	bar	psi	bar	psi	bar	psi	bar
0.236	6.00	0.039	1.00	7 977	550	11 241	775	8 340	575	17 586	1 213	8 739	603	15 048	1 038
0.236	6.00	0.059	1.50	11 966	825	16 861	1 163	12 510	863	26 379	1 819	13 108	904	22 572	1 556
0.250	6.35	0.028	0.71	5 352	369	7 541	520	5 595	386	11 798	813	5 862	404	10 095	696
0.250	6.35	0.035	0.89	6 708	463	9 453	652	7 013	484	14 789	1 020	7 349	507	12 654	872
0.250	6.35	0.036	0.91	6 859	473	9 665	666	7 171	494	15 121	1 043	7 514	518	12 939	892
0.250	6.35	0.048	1.22	9 196	634	12 958	893	9 614	663	20 272	1 398	10 074	695	17 347	1 196
0.250	6.35	0.049	1.24	9 347	644	13 170	908	9 771	674	20 605	1 421	10 239	706	17 631	1 216
0.250	6.35	0.059	1.50	11 306	780	15 932	1 098	11 820	815	24 925	1 719	12 386	854	21 328	1 470
0.250	6.35	0.063	1.60	12 060	831	16 994	1 172	12 608	869	26 587	1 833	13 211	911	22 750	1 569
0.250	6.35	0.064	1.63	12 286	847	17 312	1 194	12 845	886	27 085	1 867	13 459	928	23 176	1 598
0.250	6.35	0.065	1.65	12 437	857	17 525	1 208	13 002	896	27 418	1 890	13 624	939	23 461	1 618
0.313	7.94	0.035	0.89	5 365	370	7 560	521	5 609	387	11 827	815	5 877	405	10 120	698
0.313	7.94	0.036	0.91	5 486	378	7 730	533	5 735	395	12 093	834	6 009	414	10 348	713
0.315	8.00	0.039	1.00	5 983	413	8 430	581	6 255	431	13 190	909	6 554	452	11 286	778
0.315	8.00	0.059	1.50	8 974	619	12 646	872	9 382	647	19 784	1 364	9 831	678	16 929	1 167
0.315	8.00	0.079	2.00	11 966	825	16 861	1 163	12 510	863	26 379	1 819	13 108	904	22 572	1 556
0.375	9.53	0.035	0.89	4 470	308	6 299	434	4 673	322	9 854	679	4 897	338	8 432	581
0.375	9.53	0.036	0.91	4 570	315	6 440	444	4 778	329	10 076	695	5 007	345	8 621	594
0.375	9.53	0.048	1.22	6 127	422	8 634	595	6 406	442	13 508	931	6 712	463	11 558	797
0.375	9.53	0.049	1.24	6 228	429	8 775	605	6 511	449	13 729	947	6 822	470	11 748	810
0.375	9.53	0.064	1.63	8 186	564	11 535	795	8 559	590	18 047	1 244	8 968	618	15 443	1 065
0.375	9.53	0.065	1.65	8 287	571	11 677	805	8 664	597	18 269	1 260	9 078	626	15 632	1 078
0.375	9.53	0.080	2.03	10 195	703	14 366	991	10 659	735	22 476	1 550	11 169	770	19 232	1 326
0.375	9.53	0.083	2.11	10 597	731	14 932	1 030	11 079	764	23 362	1 611	11 609	800	19 990	1 378
0.394	10.00	0.039	1.00	4 786	330	6 744	465	5 004	345	10 552	728	5 243	362	9 029	623
0.394	10.00	0.059	1.50	7 179	495	10 117	698	7 506	518	15 827	1 091	7 865	542	13 543	934
0.394	10.00	0.063	1.60	7 658	528	10 791	744	8 006	552	16 883	1 164	8 389	578	14 446	996
0.394	10.00	0.079	2.00	9 573	660	13 489	930	10 008	690	21 103	1 455	10 486	723	18 057	1 245

■ MAXIMUM WORKING PRESSURE AT AMBIENT TEMPERATURE

OD		WT		TP304L, TP316L, TP317L, 1.4307, 1.4435, 1.4438		S31254, 1.4547		N08904, 1.4539		S31803, S32205, 1.4462		N08825, 2.4858		N06625, 2.4856	
inch	mm	inch	mm	psi	bar	psi	bar	psi	bar	psi	bar	psi	bar	psi	bar
0.473	12.00	0.039	1.00	3 989	275	5 620	388	4 170	288	8 793	606	4 369	301	7 524	519
0.473	12.00	0.059	1.50	5 983	413	8 430	581	6 255	431	13 190	909	6 554	452	11 286	778
0.473	12.00	0.079	2.00	7 977	550	11 241	775	8 340	575	17 586	1 213	8 739	603	15 048	1 038
0.500	12.70	0.035	0.89	3 354	231	4 726	326	3 507	242	7 394	510	3 674	253	6 327	436
0.500	12.70	0.036	0.91	3 430	236	4 833	333	3 585	247	7 561	521	3 757	259	6 469	446
0.500	12.70	0.048	1.22	4 598	317	6 479	447	4 807	331	10 136	699	5 037	347	8 673	598
0.500	12.70	0.049	1.24	4 673	322	6 585	454	4 886	337	10 302	710	5 119	353	8 815	608
0.500	12.70	0.064	1.63	6 143	424	8 656	597	6 422	443	13 543	934	6 729	464	11 588	799
0.500	12.70	0.065	1.65	6 218	429	8 762	604	6 501	448	13 709	945	6 812	470	11 730	809
0.500	12.70	0.080	2.03	7 651	527	10 780	743	7 998	551	16 866	1 163	8 381	578	14 432	995
0.500	12.70	0.083	2.11	7 952	548	11 205	773	8 314	573	17 531	1 209	8 711	601	15 001	1 034
0.552	14.00	0.039	1.00	3 419	236	4 817	332	3 574	246	7 537	520	3 745	258	6 449	445
0.552	14.00	0.059	1.50	5 128	354	7 226	498	5 361	370	11 305	779	5 618	387	9 674	667
0.552	14.00	0.079	2.00	6 838	471	9 635	664	7 148	493	15 074	1 039	7 490	516	12 898	889
0.586	14.88	0.125	3.18	10 229	705	14 413	994	10 694	737	22 550	1 555	11 205	773	19 295	1 330
0.591	15.00	0.039	1.00	3 191	220	4 496	310	3 336	230	7 034	485	3 495	241	6 019	415
0.591	15.00	0.059	1.50	4 786	330	6 744	465	5 004	345	10 552	728	5 243	362	9 029	623
0.591	15.00	0.079	2.00	6 382	440	8 992	620	6 672	460	14 069	970	6 991	482	12 038	830
0.626	15.88	0.048	1.22	3 677	254	5 181	357	3 844	265	8 106	559	4 028	278	6 936	478
0.626	15.88	0.049	1.24	3 737	258	5 266	363	3 907	269	8 239	568	4 094	282	7 050	486
0.626	15.88	0.064	1.63	4 913	339	6 923	477	5 136	354	10 831	747	5 382	371	9 268	639
0.626	15.88	0.065	1.65	4 973	343	7 008	483	5 199	358	10 964	756	5 448	376	9 381	647
0.630	16.00	0.039	1.00	2 991	206	4 215	291	3 127	216	6 595	455	3 277	226	5 643	389
0.630	16.00	0.059	1.50	4 487	309	6 323	436	4 691	323	9 892	682	4 915	339	8 464	584
0.630	16.00	0.079	2.00	5 983	413	8 430	581	6 255	431	13 190	909	6 554	452	11 286	778
0.630	16.00	0.099	2.50	7 479	516	10 538	727	7 819	539	16 487	1 137	8 192	565	14 107	973
0.630	16.00	0.118	3.00	8 974	619	12 646	872	9 382	647	19 784	1 364	9 831	678	16 929	1 167

■ MAXIMUM WORKING PRESSURE AT AMBIENT TEMPERATURE

OD		WT		TP304L, TP316L, TP317L, 1.4307, 1.4435, 1.4438		S31254, 1.4547		N08904, 1.4539		S31803, S32205, 1.4462		N08825, 2.4858		N06625, 2.4856	
				psi	bar	psi	bar	psi	bar	psi	bar	psi	bar	psi	bar
0.709	18.00	0.039	1.00	2 659	183	3 747	258	2 780	192	5 862	404	2 913	201	5 016	346
0.709	18.00	0.059	1.50	3 989	275	5 620	388	4 170	288	8 793	606	4 369	301	7 524	519
0.709	18.00	0.079	2.00	5 318	367	7 494	517	5 560	383	11 724	808	5 826	402	10 032	692
0.709	18.00	0.099	2.50	6 648	458	9 367	646	6 950	479	14 655	1 010	7 282	502	12 540	865
0.709	18.00	0.118	3.00	7 977	550	11 241	775	8 340	575	17 586	1 213	8 739	603	15 048	1 038
0.751	19.05	0.048	1.22	3 065	211	4 319	298	3 205	221	6 757	466	3 358	232	5 782	399
0.751	19.05	0.049	1.24	3 116	215	4 390	303	3 257	225	6 868	474	3 413	235	5 877	405
0.751	19.05	0.064	1.63	4 095	282	5 771	398	4 282	295	9 028	622	4 486	309	7 725	533
0.751	19.05	0.065	1.65	4 146	286	5 842	403	4 334	299	9 139	630	4 541	313	7 820	539
0.751	19.05	0.083	2.11	5 301	366	7 470	515	5 542	382	11 687	806	5 807	400	10 000	689
0.751	19.05	0.095	2.40	6 030	416	8 497	586	6 304	435	13 293	917	6 606	455	11 375	784
0.751	19.05	0.109	2.77	6 960	480	9 807	676	7 276	502	15 343	1 058	7 624	526	13 128	905
0.751	19.05	0.140	3.56	8 945	617	12 604	869	9 351	645	19 719	1 360	9 798	676	16 873	1 163
0.788	20.00	0.059	1.50	3 590	248	5 058	349	3 753	259	7 914	546	3 932	271	6 772	467
0.788	20.00	0.079	2.00	4 786	330	6 744	465	5 004	345	10 552	728	5 243	362	9 029	623
0.788	20.00	0.099	2.50	5 983	413	8 430	581	6 255	431	13 190	909	6 554	452	11 286	778
0.788	20.00	0.118	3.00	7 179	495	10 117	698	7 506	518	15 827	1 091	7 865	542	13 543	934
0.788	20.00	0.158	4.00	9 573	660	13 489	930	10 008	690	21 103	1 455	10 486	723	18 057	1 245
0.867	22.00	0.059	1.50	3 263	225	4 598	317	3 412	235	7 194	496	3 575	246	6 156	424
0.867	22.00	0.079	2.00	4 351	300	6 131	423	4 549	314	9 592	661	4 767	329	8 208	566
0.985	25.00	0.059	1.50	2 872	198	4 047	279	3 002	207	6 331	437	3 146	217	5 417	374
0.985	25.00	0.079	2.00	3 829	264	5 395	372	4 003	276	8 441	582	4 195	289	7 223	498
0.985	25.00	0.099	2.50	4 786	330	6 744	465	5 004	345	10 552	728	5 243	362	9 029	623
0.985	25.00	0.118	3.00	5 744	396	8 093	558	6 005	414	12 662	873	6 292	434	10 834	747
1.001	25.40	0.048	1.22	2 299	159	3 239	223	2 403	166	5 068	349	2 518	174	4 337	299
1.001	25.40	0.049	1.24	2 337	161	3 293	227	2 443	168	5 151	355	2 560	176	4 408	304
1.001	25.40	0.065	1.65	3 109	214	4 381	302	3 251	224	6 854	473	3 406	235	5 865	404
1.001	25.40	0.083	2.11	3 976	274	5 603	386	4 157	287	8 765	604	4 356	300	7 500	517
1.001	25.40	0.095	2.40	4 523	312	6 373	439	4 728	326	9 970	687	4 954	342	8 531	588
1.001	25.40	0.126	3.20	6 030	416	8 497	586	6 304	435	13 293	917	6 606	455	11 375	784

■ MAXIMUM WORKING PRESSURE AT AMBIENT TEMPERATURE

OD		WT		TP304L, TP316L, TP317L, 1.4307, 1.4435, 1.4438		S31254, 1.4547		N08904, 1.4539		S31803, S32205, 1.4462		N08825, 2.4858		N06625, 2.4856	
				psi	bar	psi	bar	psi	bar	psi	bar	psi	bar	psi	bar
1.182	30.00	0.063	1.60	2 553	176	3 597	248	2 669	184	5 628	388	2 796	193	4 815	332
1.182	30.00	0.099	2.50	3 989	275	5 620	388	4 170	288	8 793	606	4 369	301	7 524	519
1.182	30.00	0.118	3.00	4 786	330	6 744	465	5 004	345	10 552	728	5 243	362	9 029	623
1.182	30.00	0.158	4.00	6 382	440	8 992	620	6 672	460	14 069	970	6 991	482	12 038	830
1.251	31.75	0.126	3.20	4 824	333	6 797	469	5 043	348	10 635	733	5 284	364	9 100	627
1.379	35.00	0.079	2.00	2 735	189	3 854	266	2 859	197	6 030	416	2 996	207	5 159	356
1.379	35.00	0.099	2.50	3 419	236	4 817	332	3 574	246	7 537	520	3 745	258	6 449	445
1.379	35.00	0.118	3.00	4 103	283	5 781	399	4 289	296	9 044	624	4 494	310	7 739	534
1.497	38.00	0.079	2.00	2 519	174	3 550	245	2 634	182	5 554	383	2 760	190	4 752	328
1.497	38.00	0.118	3.00	3 779	261	5 324	367	3 950	272	8 330	574	4 139	285	7 128	491
1.497	38.00	0.158	4.00	5 038	347	7 099	489	5 267	363	11 107	766	5 519	381	9 504	655
1.497	38.00	0.197	5.00	6 298	434	8 874	612	6 584	454	13 884	957	6 899	476	11 880	819
1.655	42.00	0.079	2.00	2 279	157	3 212	221	2 383	164	5 025	346	2 497	172	4 299	296
1.655	42.00	0.118	3.00	3 419	236	4 817	332	3 574	246	7 537	520	3 745	258	6 449	445
1.970	50.00	0.158	4.00	3 829	264	5 395	372	4 003	276	8 441	582	4 195	289	7 223	498
1.970	50.00	0.197	5.00	4 786	330	6 744	465	5 004	345	10 552	728	5 243	362	9 029	623

Calculation is made by Formula $P = \frac{2St}{D}$ with considering 75% of the yield strength for steel grade where,

P = hydrostatic test pressure in psi [MPa],

S = pipe wall stress in psi or [MPa],

t = specified wall thickness, nominal wall thickness according to specified ANSI schedule number, or 1.143 times the specified minimum wall thickness, in. [mm],

D = specified outside diameter, outside diameter corresponding to specified ANSI pipe size, or outside diameter calculated by adding $2t$ (as defined above) to the specified inside diameter, in. [mm].

■ CENTRAVIS VALUE PROPOSITION

Hardness of HRB 80 for 304L/316L and HRB 90 for other austenitic grades	>	Ensuring quality of joints (tube material must be softer than the fitting material)
100% EC and UT inline	>	Ultimate quality assurance along the whole length of the tube
100% bright annealed	>	Smooth shiny surface, increased resistance to pitting corrosion
Electronic MTR service	>	Online access to MTR's at any time
Ability to deliver in flexible lengths. Wide range of lengths available	>	Customized lengths to meet customer specifications
Both ends plugged	>	Ensuring tube cleanliness
ISO 9001, 14001, 16949, 17025; OHSAS 18001 certifications	>	Integrated QMS approved according to ISO standards
Approved by Shell, Exxon-Mobil, Saudi Aramco, Norsok M-650, ADCO, ADMA-OPCO, ZADCO	>	Approved by key industry end-users

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