

ERW longitudinally welded steel tubes

GOST 10705-80
GOST 10704-91

Application: for pipelines and different purpose structures

Pipe dimensions and weight

Outside diameter, mm	Weight per meter, kg, for wall thickness mm															
	1,0	1,2	1,4	1,5	1,6	1,8	2,0	2,2	2,5	2,8	3,0	3,2	3,5	3,8	4,0	4,5
12	0,271	0,320	0,366	0,388	0,410	-	-	-	-	-	-	-	-	-	-	-
13	0,296	0,349	0,401	0,425	0,450	-	-	-	-	-	-	-	-	-	-	-
14	0,321	0,379	0,435	0,462	0,489	-	-	-	-	-	-	-	-	-	-	-
15	0,345	0,408	0,470	0,499	0,529	-	-	-	-	-	-	-	-	-	-	-
16	0,370	0,438	0,504	0,536	0,568	-	-	-	-	-	-	-	-	-	-	-
17	0,395	0,468	0,539	0,573	0,608	-	-	-	-	-	-	-	-	-	-	-
18	0,419	0,497	0,573	0,610	0,719	-	-	-	-	-	-	-	-	-	-	-
19	0,444	0,527	0,608	0,647	0,687	0,764	0,838	-	-	-	-	-	-	-	-	-
20	0,469	0,556	0,642	0,684	0,726	0,808	0,888	-	-	-	-	-	-	-	-	-
21,3	0,501	0,595	0,687	0,732	0,777	0,866	0,952	-	-	-	-	-	-	-	-	-
22	0,518	0,616	0,711	0,758	0,805	0,897	0,986	-	-	-	-	-	-	-	-	-
25	0,592	0,704	0,815	0,869	0,923	1,03	1,13	1,24	1,39	-	-	-	-	-	-	-
26	0,617	0,734	0,849	0,906	0,963	1,07	1,18	1,29	1,45	-	-	-	-	-	-	-
27	0,641	0,764	0,884	0,943	1,00	1,12	1,23	1,35	1,51	-	-	-	-	-	-	-
28	0,666	0,793	0,918	0,980	1,04	1,16	1,28	1,40	1,57	-	-	-	-	-	-	-
30	0,715	0,852	0,987	1,05	1,12	1,25	1,38	1,51	1,70	-	-	-	-	-	-	-
32	0,765	0,911	1,06	1,13	1,20	1,34	1,48	1,62	1,82	2,02	2,15	-	-	-	-	-
33	0,798	0,941	1,09	1,17	1,24	1,38	1,53	1,67	1,88	2,09	2,22	-	-	-	-	-
33,7	-	0,962	1,12	1,19	1,27	1,42	1,56	1,71	1,92	2,13	2,27	-	-	-	-	-
36	-	1,03	1,19	1,28	1,36	1,52	1,68	1,83	2,07	2,29	2,44	-	-	-	-	-
38	-	1,09	1,26	1,35	1,44	1,61	1,78	1,94	2,19	2,43	2,59	-	-	-	-	-
40	-	-	1,33	1,42	1,52	1,70	1,87	2,05	2,31	2,57	2,74	-	-	-	-	-
42	-	-	1,40	1,50	1,59	1,78	1,97	2,16	2,44	2,71	2,89	-	-	-	-	-
45	-	-	1,51	1,61	1,71	1,92	2,12	2,32	2,62	2,91	3,11	-	-	-	-	-
48	-	-	1,61	1,72	1,83	2,05	2,27	2,48	2,81	3,12	3,33	3,54	3,84	-	-	-
51	-	-	1,71	1,83	1,95	2,18	2,42	2,65	2,99	3,33	3,55	3,77	4,10	-	-	-
54	-	-	1,82	1,94	2,07	2,32	2,56	2,81	3,18	3,54	3,77	4,01	-	-	-	-
57	-	-	1,92	2,05	2,19	2,45	2,71	2,97	3,36	3,74	4,00	4,25	4,62	-	-	-
60	-	-	2,02	2,16	2,30	2,58	2,86	3,14	3,55	3,95	4,22	4,48	4,88	5,27	-	-
63,5	-	-	2,14	2,29	2,44	2,74	3,03	3,33	3,76	4,19	4,48	4,76	-	-	-	-
76	-	-	-	-	-	-	-	-	4,53	5,05	5,40	5,75	6,26	6,77	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

Pipe dimensions and weight (continued)

Outside diameter, mm	Weight per meter, kg, for wall thickness mm											
	4,5	5,0	5,5	6,0	6,5	7,0	7,5	8,0	8,5	9,0	9,5	10,0
159	17,15	18,99	20,82	22,64	24,44	26,24	-	-	-	-	-	-
168	18,14	20,10	22,04	23,97	25,89	27,79	-	-	-	-	-	-
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	-	-	-	-
325	-	-	43,34	47,20	51,06	54,90	58,73	62,54	66,35	70,14	73,91	-
355,6	-	-	47,49	51,73	55,95	60,18	64,38	68,58	72,75	76,93	81,08	-
406,4	-	-	54,38	59,25	64,10	68,95	73,77	78,60	83,40	88,20	92,98	-
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

Lengths supplied:

- Random length: no less than 2 m with diameter up to 30 mm;
no less than 3 m with diameter over 30 up to 70 mm;
no less than 4 m with diameter over 70 up to 114 mm;
no less than 5 m with diameter 159 mm and more;
- Fixed length: from 5 up to 9 m with diameter up to 70 mm;
from 6 up to 9 m with diameter over 70 up to 219 mm;
from 10 up to 12 m with diameter over 219 up to 426 mm.
- Multiple lengths having no less than 250 mm and not exceeding low limit specified for fixed length pipes.

Steel hardness:

Steel Grades	Chemical compound according to
St1sp, St1kp, St1ps, St2sp, St2kp, St2ps, St3sp, St3kp, St3ps	GOST 380
08, 08kp, 08ps, 10, 10kp, 10ps, 15, 15kp, 15ps, 20, 20kp, 20ps	GOST 1050

Steel Grade "sp" is killed steel

Steel Grade "ps" is semi-killed steel

Steel Grade "kp" is boiled steel

Obligatory requirements:

- Carrying out hydraulic pressure testing;
- Carrying out weld's quality non-destructive testing;
- Carrying out flattening test;
- Carrying out expanding test (for pipes with diameter 20 mm and more, with wall thickness less than 0,06Dn and diameter 63,5 mm).