



ARTROM STEEL TUBES S.A.

Draganesti Str. 30, Slatina, jud. OLT, Romania 230119
 Tel: +40 (249) 436862, 434640, 434641 Fax: +40 (249) 434330, 437288
 E-mail: office.slatina@artrom.com www.artrom.com
 EUID: ROONRC.J28/9/1991; J28/9/31.01.1991 VAT No. RO 1510210/1992
 Subscribed and Paid Share Capital: 291.587.538,34 lei

GAS AND WATER SEAMLESS, PLAIN ENDS, BLACK TUBES

1. Standards

- DIN 2440 (has been replaced with EN 10255);
- DIN 2441 (has been replaced with EN 10255);
- UNI 8863 (has been replaced with EN 10255);
- EN 10255;
- ASTM A53.

2. Used for:

- Construction of long distance Pipe Lines for combustible liquids and gases;
- Conveying gas and oil; in oil and natural gas industries.

3. Dimensions

According EN 10255 or ASME B36.10M in dimensional range corresponding to the workshop CPE (Tab.1) or ASSEL (Tab.2).

4. Tolerances

Standard	Outside Diameter	Wall Thickness	Weight
DIN 2440	Acc. Tab.4	-12.5%	+/-10% for single lengths +/-7.5% for carload lots
DIN 2441	Acc. Tab.5	-12.5%	+/-10% for single lengths +/-7.5% for carload lots
EN 10255	Acc Tab.3,Tab.4, Tab.5	+/-12.5%	+/-7.5%
ASTM A 53	±1%	-12.50%	±10% of the pipe

5. Chemical Composition (%)

Steel Grade	Mass fraction, based upon heat and product analyses, [%] max.											
	C	Si	Mn	P	S	V	Nb	Ti	Cu	Ni	Cr	Mo
Grade A	0.25		0.95	0.05	0.045	0.08	Cu+Ni+Cr+Mo+V≤1%		0.40	0.40	0.40	0.15
Grade B	0.30		1.20	0.05	0.045	0.08	Cu+Ni+Cr+Mo+V≤1%		0.40	0.40	0.40	0.15
Fe 330	0.17		0.65	0.040	0.040							
S195T	0.20		1.40	0.035	0.030							

6. Mechanical Properties

Steel Grade	Yield strength		Tensile strength		Elongation [%]
	Rt0,5, PSI (MPa)		Rm, PSI (MPa)		
	minimum	maximum	minimum	maximum	

ARTROM STEEL TUBES S.A. Cod: FCU-01, Ed. 5 Rev. 1/2023



API:
5CT-2357
5L-1271

LRQA:
ISO 9001
ISO 14001
ISO 45001

TUV:
PED/AD-2000 W0/W4
Vd TUV

TUV CPR:
EN 10210-1,2
EN 10255

DNV
RINA

LRQA:
IATF 16949

Grade A	30000(205)	35000(240)	48000(330)	60000(415)	-
Grade B	30000(205)	35000(240)	48000(330)	60000(415)	-
Fe 330	3062(210)	-	4811(330)	7582(520)	Min 22%
S195T	2843(195)	-	4666(320)	7582(520)	Min 20%

7. Lengths

Random lengths or fixed lengths in length range corresponding to the -workshop CPE (Tab.1) or ASSEL (Tab.2).

8. Surface treatment

- Unprotected;
- External varnished with black or clear lacquer.

9. Marking

According to standard or per customer request.

10. Delivery

In bundles up to 4000 kg (8800 lbs) tied in minimum six places with steel strip.
Quantity tolerances: $\pm 5\%$ per size or / and per total.

11. Mill test report

Mill test reports are issued to customer requirements. Usually they comply with DIN 50049, EN 10204.

12. Quality certified

TUV- PED, AD; CE; DNV

Tab.3 Thin-weight (type L1), EN 10255, UNI 8863, STAS 7656

DN	Connecting nominal width of the fittings	OD			WT [mm]
		nom [mm]	min [mm]	max [mm]	
15	1/2	21.3	21.0	21.7	2.3
20	3/4	26.9	26.4	27.1	2.3
25	1	33.7	33.2	34.0	2.9
32	1 1/4	42.4	41.9	42.7	2.9
40	1 1/2	48.3	47.8	48.6	2.9
50	2	60.3	59.6	60.7	3.2
65	2 1/2	76.1	75.2	76.3	3.2
80	3	88.9	87.9	89.4	3.6
100	4	114.3	113.0	114.9	4.0



Tab. 4 Medium-weight (type M), EN 10255, DIN 2440, STAS 7656

DN	Connecting nominal width of the fittings	OD			WT [mm]
		nom [mm]	min [mm]	max [mm]	
15	1/2	21.3	21.0	21.8	2.6
20	3/4	26.9	26.5	27.3	2.6
25	1	33.7	33.3	34.2	3.2
32	1 1/4	42.4	42.0	42.9	3.2
40	1 1/2	48.3	47.9	48.8	3.2
50	2	60.3	59.7	60.8	3.6
65	2 1/2	76.1	75.3	76.6	3.6
80	3	88.9	88.0	89.5	4.0
100	4	114.3	113.1	115.0	4.5

Tab.5 Heavy-weight (type H), EN 10255, DIN 2441, STAS 7656

DN	Connecting nominal width of the fittings	OD			WT [mm]
		nom [mm]	min [mm]	max [mm]	
15	1/2	21.3	21.0	21.8	3.2
20	3/4	26.9	26.5	27.3	3.2
25	1	33.7	33.3	34.2	4.0
32	1 1/4	42.4	42.0	42.9	4.0
40	1 1/2	48.3	47.9	48.8	4.0
50	2	60.3	59.7	60.8	4.5
65	2 1/2	76.1	75.3	76.6	4.5
80	3	88.9	88.0	89.5	5.0
100	4	114.3	113.1	115.0	5.4

