

Seamless pipes DIN EN 10216-1 (DIN 1629/1630)

Non-alloy steel tubes with specified room temperature properties

Area of applications	According to rules and standards DVGW and AD 2000-W Merkblätter	
	to 300 °C and working pressure 160 bar	(DIN 1629)
	to 300 °C and unlimited working pressure	(DIN 1630)
Order text for example	Pipe, seamless, DIN EN 10220/10216-1, P235TR1/1.0254, inspection certificate acc. to DIN EN 10204/3.1 60.3 × 2.9 mm	

Materials

Material number	Designation acc. to EN	Designation acc. to DIN
1.0254	P235TR1	St 37.0
1.0258	P265TR1	St 44.0
1.0255	P235TR2	St 37.4
1.0259	P265TR2	St 44.4

Scope of tests	TR1 without impact test TR2 impact test at 0 °C (optional -10 °C) Only TR2 approved under PED
Designation of grades	TR1/TR2 Formed, normal annealed or normalizing formed TR2 Normalizing formed
Delivery lengths	5 to 7 m or double random lengths
Exact lengths	≤ 6,000 mm +10 mm > 6,000 <12,000 mm +15 mm ≥ 12,000 mm to be agreed
Range of sizes	10.2 to 711.0 mm
Wall thicknesses	1.6 to 100.0 mm
Dimensions and weights	According to DIN EN 10220

Tolerances on outside diameter and wall thickness

Outside diameter D	Tolerance on outside diameter D	Tolerances on wall thickness T at a T/D ratio of			
		≤ 0.025	> 0.025 to 0.050	> 0.050 to 0.10	> 0.10
≤ 219.1 mm	± 1% or ± 0.5 mm, whichever is the greater	± 12.5% or ± 0.4 mm, whichever is the greater			
> 219.1 mm		± 20%	± 15%	± 12.5%	± 10% ^a

^a For outside diameter D > 355.6 mm is upper limit of the local wall thickness may be exceeded by a further 5% of the wall thickness T.

Inspection certificates	According to DIN EN 10204/2.2 (only for TR1) or DIN EN 10204/3.1
Marking	Manufacturer's mark, EN standard, material grade, identification number For 3.1: heat number, mark of the inspection representative