

# Welded pipes DIN EN 10217-1 (DIN 1626/1628)

Non-alloy steel tubes with specified room temperature properties

<b>Area of applications</b>	Acc. to rules DVGW, PED and AD 2000 Merkblatt W4 (only TR2)
	To 300 °C and working pressure to 160 bar (DIN 1626)
	To 300 °C and unlimited working pressure (DIN 1628)
<b>Order text example</b>	Pipe, welded, DIN EN 10220/10217-1, P235TR1/1.0254, inspection certificate acc. to EN 10204/3.1 219.1 × 6.3 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

<b>Scope of testing</b>	<b>TR1</b> without impact test <b>TR2</b> with impact test at 0 °C (optional -10 °C) Only TR2 approved under PED
<b>Welding process</b>	<b>EW</b> Electric welded <b>SAWL<sup>a</sup></b> Submerged arc welded with longitudinal seam <b>SAWH<sup>a</sup></b> Submerged arc welded with helical seam <b>BW</b> Continuous welded (only applicable to TR1) <sup>a</sup> SAW Submerged Arc Welding
<b>Range of sizes</b>	10.2 to 2,540 mm
<b>Wall thicknesses</b>	1.4 to 40.0 mm
<b>Dimensions and weights</b>	According to DIN EN 10220

## Tolerances of outside diameter and wall thickness

Outside diameter D	Tolerances on		
	Outside diameter D	Wall thickness T <sup>b</sup>	
		≤ 5	5 < T ≤ 40
≤ 219.1 mm	± 1.0 % or ± 0.5 mm, whichever is the greater	± 10 % or ± 0.3 mm, whichever is the greater	± 8 % or ± 2.0 mm, whichever is the smaller
> 219.1 mm	± 0.75 % or ± 5 mm, whichever is the greater		

<sup>b</sup> The upper tolerance does not apply to the weld seam area (see DIN EN 10217-1 / section 8.7.4.2).

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