Welded pipes DIN EN 10217-2 (DIN 17177)

Electric welded non-alloy and alloy steel tubes with specified elevated temperature properties

Area of applications

Pressure vessel and apparatus engineering, pipeline construction, shipbuilding

Order text example

Pipe, high frequency welded with longitudial seam (HFW), DIN EN 10220/10217-2, P235GH TC1/1.0345, inspection certificate acc. to EN 10204/3.1 60.3 × 2.9 mm

Materials

Material number	Designation acc. to EN	Designation acc. to DIN
1.0345	P235GH	St 37.8
1.0425	P265GH	St 42.8
1.5415	16Mo3[a]	15 Mo 3

[a] alloyed steels generally with US testing (TC2).

Scope of testing

TC1 Test class 1 (without US testing)
TC2 Test class 2 (with US testing for longitudinal errors)

Welding process

Gas press welding, high frequency welding

Delivery lengths

6 m, 12 m, partly to 18 m

Range of sizes

10.2 to 610.0 mm

Wall thicknesses

1.4 to 40.0 mm

Dimensions and weights

According to DIN EN 10220

Tolerances of outside diameter and wall thickness

Outside diameter D	Tolerances on		
	Outside diameter D	Wall thickness T[c]	
		≤ 5	5 < T ≤ 16
≤ 219.1 mm	± 1.0 % or ± 0.5 mm, whichever is the greater	± 10 % or ± 0.3 mm, whichever ist the greater	± 8 %
> 219.1 mm	± 0.75 %		

[c] The upper tolerance does not apply to the weld seam area (see DIN EN 10217-2/ section 8.7.4.2).

Inspection certificate

According to DIN EN 10204/3.1 or 3.2

Marking

Manufacturer´s mark, EN standard, material grade, heat number, test class (only for non-alloyed steels), mark of the inspection representative, identification number