

Welded pipes DIN EN 10217-3 (DIN 17178)

Alloy fine grain steel tubes with specified room temperature properties

Area of applications	According to rules DVGW, PED and AD 2000 Merkblatt W4 and W10 (only low temperature quality)
Order text example	Pipe, welded, DIN EN 10220/10217-3, TC1, P355N/1.0562, inspection certificate acc. to DIN EN 10204/3.2 TÜV, requirements acc. to AD 2000 Merkblatt 88.9 × 3.2 mm

Materials	Tolerances on		
	Material number	Designation acc. to EN	Designation acc. to DIN
Basis quality	1.0562	P355N	StE 355
	1.8905	P460N	StE 460
Elevated temperature quality	1.0565	P355NH	WStE 355
	1.8935	P460NH	WStE 460
Low temperature quality	1.0488	P275NL1	TStE 285
	1.0566	P355NL1	TStE 355
	1.8915	P460NL1	TStE 460

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, HF welded ^a , SAW welded ^b for longitudinal and helical seam ^a HF High frequency ^b SAW Submerged Arc Welding
Delivery lengths	6 m, 12 m, partly to 18 m
Range of sizes	Gas press welding, HF welding 10.2 to 508.0 mm SAW welding 406.4 to 2,540 mm
Wall thicknesses	1.6 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 ≤ 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 ± 6 mm, whichever is the greater			

^c The upper tolerance does not apply to the weld seam area (see DIN EN 10217-3/section 8.7.4.2).

Inspection certificate	According to DIN EN 10204/3.1 or 3.2
Marking	Manufacturer's mark, welding process, EN standard, material grade, test class, heat number, mark of the inspection representative, identification number