

Welded pipes DIN EN 10217-5

Submerged arc welded non-alloy and alloy steel tubes with specified high temperature properties

Area of applications	According to rules DVGW, PED and AD 2000 Merkblatt W4
Order text example	Pipe, submerged arc welded with longitudinal seam (SAWL), DIN EN 10220/10217-5, P235GH TC1/1.0345, inspection certificate acc. to DIN EN 10204/3.1 406.4 × 8.8 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	SAWL^b Submerged arc welded with longitudinal seam SAWH^b Submerged arc welded with helical seam ^b SAW Submerged Arc Welding
Delivery lengths	6 m, 12 m, partly to 18 m
Range of sizes	406.4 to 2,540 mm
Wall thicknesses	4.0 to 40.0 mm
Dimensions and weights	According to DIN EN 10220

Tolerances of outside diameter and wall thickness

Outside diameter D	Tolerances on	
	Wall thickness T [°]	
	≤ 5	5 < T ≤ 40
± 0.75 % or ± 6 mm, whichever is the smaller	± 10 % or ± 0.3 mm, whichever is the smaller	± 8 % oder ± 2.0 mm, whichever is the smaller

[°] The upper tolerance does not apply to the weld seam area (see DIN EN 10217-5/ 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