

Welded pipes DIN EN 10217-6

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

Area of applications	Pressure vessel and apparatus engineering, refrigeration system, pipeline construction with a focus on the chemical industry
Order text example	Pipe, submerged arc welded with longitudinal seam (SAWL), DIN EN 10220/10217-6, P265NL1 TC1/1.0425, inspection certificate acc. to DIN EN 10204/3.1 406,4 × 8,8 mm

Materials

Material number	Designation acc. to EN
1.0451	P215NL1 (only for t < 10,0 mm)
1.0425	P265NL1

Scope of testing	TC1 Test class 1 (without US testing) TC2 Test class 2 (with US testing for longitudinal errors)
Welding process	SAWL^a Submerged arc welded with longitudinal seam SAWH^a Submerged arc welded with helical seam ^a 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 25,0 mm
Dimensions and weights	According to DIN EN 10220

Tolerances of outside diameter and wall thickness

Outside diameter D	Tolerances on	
	Wall thickness T ^b	
	≤ 5	5 < T ≤ 40
± 0,75 % or ± 6 mm, the smaller value applies in each case	± 10 % or ± 0,3 mm, the larger value applies in each case	± 8 % or ± 2,0 mm, the smaller value applies in each case

^b The upper tolerance does not apply for 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, mark of the inspection representative, identification number