



TMK-ARTROM S.A.

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 E-mail: office.slatina@tmk-artrom.eu www.tmk-artrom.eu  
 EUID: ROONRC.J28/9/1991; J28/9/31.01.1991  
 VAT No. RO 1510210/1992  
 Subscribed and Paid Share Capital: 291.587.538,34 lei

## GAS AND WATER SEAMLESS, PLAIN ENDS, BLACK TUBES

### 1. Standards

- DIN 2440 (has been replaced with EN 10255);
- DIN 2441 (has been replaced with EN 10255);
- UNI 8863 (has been replaced with EN 10255);
- EN 10255.

### 2. Used for:

- Construction of long distance Pipe Lines for combustible liquids and gases;
- Conveying gas and oil; in oil and natural gas industries.

### 3. Dimensions

According Tab.1, Tab. 2 and Tab. 3.

### 4. Tolerances

Standard	Outside Diameter	Wall Thickness	Weight
DIN 2440	Acc Tab.2	-12.5%	+/-10% for single lengths +/-7.5% for carload lots
DIN 2441	Acc Tab.3	-12.5%	+/-10% for single lengths +/-7.5% for carload lots
EN 10255	Acc Tab.1,Tab.2, Tab.3	+/-12.5%	+/-7.5%

### 5. Chemical Composition (%)

Steel group	C max	Mn max	Si max	S max	P max
Fe 330	0.17	0.65		0.040	0.040
S195T	0.20	1.40		0.030	0.035

### 6. Mechanical Properties

Steel group	Tensile Strength	Yield Strength min.	Elongation
	MPa	MPa	%
Fe 330	330÷520	210	22
S195T	320÷520	195	20

### 7. Lengths

- Random lengths: 5÷12 m;
- Fixed lengths within the random lengths range; - Tolerances: +100/-0 mm.

### 8. Surface treatment

- Black laquer

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API:  
5CT-0440  
5L-0352

LR:  
ISO 9001  
ISO 14001  
ISO 45001

TUV:  
PED/AD-2000 W0/W4  
TRD 100/102  
Vd TUV

TUV CPR:  
EN 10210-1,2  
EN 10255

LR:  
DNV-GL Rules  
RINA

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### 9. Marking

According to standard or per customer request.

### 10. Delivery

In bundles up to 4000 kg (8800 lbs) tied in minimum six places with steel strip. Quantity tolerances:  $\pm 5\%$  per size or / and per total.

### 11. Mill test report

Mill test reports are issued to customer requirements.  
Usually they comply with DIN 50049, EN 10204.

### 12. Quality certified

LR, TUV, PED, CE, DNV, GL, MLPTL.

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**Tab.1 Thin-weight (type L1), EN 10255, UNI 8863, STAS 7656**

DN	Connecting nominal width of the fittings	OD			WT [mm]
		nom [mm]	min [mm]	max [mm]	
15	1/2	21.3	21.0	21.7	2.3
20	3/4	26.9	26.4	27.1	2.3
25	1	33.7	33.2	34.0	2.9
32	1 1/4	42.4	41.9	42.7	2.9
40	1 1/2	48.3	47.8	48.6	2.9
50	2	60.3	59.6	60.7	3.2
65	2 1/2	76.1	75.2	76.3	3.2
80	3	88.9	87.9	89.4	3.6
100	4	114.3	113.0	114.9	4.0

**Tab. 2 Medium-weight (type M), EN 10255, DIN 2440, STAS 7656**

DN	Connecting nominal width of the fittings	OD			WT [mm]
		nom [mm]	min [mm]	max [mm]	
15	1/2	21.3	21.0	21.8	2.6
20	3/4	26.9	26.5	27.3	2.6
25	1	33.7	33.3	34.2	3.2
32	1 1/4	42.4	42.0	42.9	3.2
40	1 1/2	48.3	47.9	48.8	3.2
50	2	60.3	59.7	60.8	3.6

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65	2 1/2	76.1	75.3	76.6	3.6
80	3	88.9	88.0	89.5	4.0
100	4	114.3	113.1	115.0	4.5

**Tab.3 Heavy-weight (type H), EN 10255, DIN 2441, STAS 7656**

DN	Connecting nominal width of the fittings	OD			WT [mm]
		nom [mm]	min [mm]	max [mm]	
15	1/2	21.3	21.0	21.8	3.2
20	3/4	26.9	26.5	27.3	3.2
25	1	33.7	33.3	34.2	4.0
32	1 1/4	42.4	42.0	42.9	4.0
40	1 1/2	48.3	47.9	48.8	4.0
50	2	60.3	59.7	60.8	4.5
65	2 1/2	76.1	75.3	76.6	4.5
80	3	88.9	88.0	89.5	5.0
100	4	114.3	113.1	115.0	5.4

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