

Electric Resistance Welded (ERW) steel pipe is welded from a curled steel plate a curled steel strip. It is available in transportation of oil, natural gas, and chemical materials. It is also used as structure and mechanical square or rectangular pipe of a building in a city and even in the sea.

Advantage: fast manufacture, steady quality, good shape.

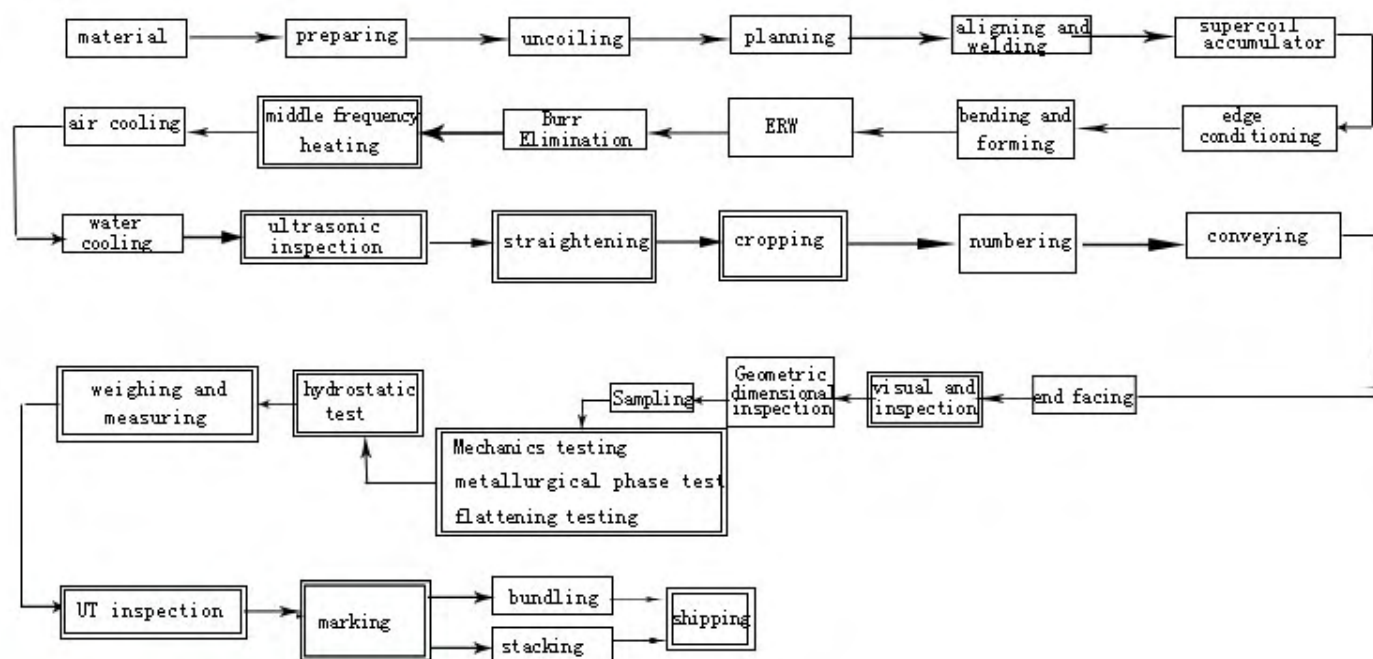
Standards: DIN 2448、BS1387、EN10255 、API Spec 5L SEAMLESS STEEL PIPES AND TUBES

Sizes: O.D.21.3mm - 339.7mm

ERW LONGITUDINAL SEAM WELDED STEEL PIPE

1. FLOW CHART:

FLOW CHART OF ERW LONGITUDINAL-SEAM WELDED STEEL PIPES



Note: For Quality control point

ERW GALVANIZED STEEL PIPE, FOR STRUCTURE

Description	Size and Wall Thickness	Material	Standard
ERW Hot Galvanized Steel Pipe for Liquid Service	Φ21.3~Φ219.1 X 2.0~8.0	——	BS1387-1985



Description	Size and Wall Thickness	Material	Standard
ERW Steel Pipe for Liquid Service	$\Phi 21.3 \sim \Phi 339.7 \times 2.0 \sim 14$	GRADE A、GRADE B	ASTM A53/A53M-99b
		——	BS1387-1985

Size and Dimension Standard of grooved steel pipe

1		2		3	4	5	6	7	8
SIZE	DN	DN Tolerance		A	B	C	t min	d reference	max. diam.of mouth
3/4"	26.7	+ 0.25	-0.25	15.88	7.14	23.83-0.38	1.65	1.42	29.2
1"	33.4	+ 0.33	-0.33	15.88	7.14	30.23-0.38	1.65	1.6	36.3
1-1/4"	42.2	+ 0.41	-0.41	15.88	7.14	38.99-0.38	1.65	1.6	45.0
1-1/2"	48.3	+ 0.48	-0.48	15.88	7.14	45.09-0.38	1.65	1.6	51.1
2"	60.3	+ 0.61	-0.61	15.88	8.74	57.15-0.38	1.65	1.6	63.0
2-1/2"	73	+ 0.74	-0.74	15.88	8.74	69.09-0.46	2.11	1.98	78.7
3"	88.9	+ 0.89	-0.79	15.88	8.74	84.94-0.38	2.11	1.98	91.4
4"	114.3	+ 1.14	-0.79	15.88	8.74	110.08-0.38	2.11	2.11	116.8
5"	141.3	+ 1.42	-0.79	15.88	8.74	137.03-0.38	2.77	2.11	143.8
6"	168.3	+ 1.60	-0.79	15.88	8.74	163.96-0.38	2.77	2.16	170.9
8"	219.1	+ 1.60	-0.79	19.05	11.91	214.40-0.51	2.77	2.34	223.5
10"	273	+ 1.60	-0.79	19.05	11.91	268.27-0.64	3.4	2.39	277.4
12"	323.9	+ 1.60	-0.79	19.05	11.91	318.29-0.64	3.96	2.77	328.2



PIPE THREAD--BRITISH STANDARD PIPE TAPER--BSPT

MARYLAND METRICS--THREAD DATA CHART:										
British Pipe Thread (Whitworth Form) --Taper (BSPT)										
Thread Designation BSPT	Nominal Size BSPT	Thread Form Type	Major Diameter r mm d=D	Pitch mm p	Threads per inch tpi	Pitch Diameter r mm d2=D2	Minor Diameter r Male Thd. d3	Thread Height H1	Rounding r	Tap Drill Diameter r mm
R 1/16	1/16"	BSPT	7.723	0.907	28	7.142	6.561	0.581	0.125	6.4
R 1/8	1/8"	BSPT	9.728	0.907	28	9.147	8.566	0.581	0.125	8.4
R 1/4	1/4"	BSPT	13.157	1.337	19	12.301	11.445	0.856	0.184	11.2
R 3/8	3/8"	BSPT	16.662	1.337	19	15.806	14.95	0.856	0.184	14.75
R 1/2	1/2"	BSPT	20.955	1.814	14	19.793	18.631	1.162	0.249	18.25
R 3/4	3/4"	BSPT	26.441	1.814	14	25.279	24.117	1.162	0.249	23.75
R 1	1"	BSPT	33.249	2.309	11	31.77	30.291	1.479	0.317	30
R 1-1/4	1-1/4"	BSPT	41.91	2.309	11	40.431	38.952	1.479	0.317	38.5
R 1-1/2	1-1/2"	BSPT	47.803	2.309	11	46.324	44.845	1.479	0.317	44.5
R 2	2"	BSPT	59.614	2.309	11	58.135	56.656	1.479	0.317	56
R 2-1/2	2-1/2"	BSPT	75.184	2.309	11	73.705	72.226	1.479	0.317	71
R 3	3"	BSPT	87.884	2.309	11	86.405	84.926	1.479	0.317	85.5
R 4	4"	BSPT	113.03	2.309	11	111.551	110.072	1.479	0.317	110.5
R 5	5"	BSPT	138.43	2.309	11	136.951	135.472	1.479	0.317	136
R 6	6"	BSPT	163.83	2.309	11	162.351	160.872	1.479	0.317	161

Non-alloy steel tubes suitable for welding and threading EN 10255

mm

Specification Outside diameter	Wall Thickness				
	H	M	L	L1	L2
21.3	3.2	2.6	2.3	2.3	2
26.9	3.2	2.6	2.3	2.3	2.3
33.7	4	3.2	2.9	2.9	2.6
42.4	4	3.2	2.9	2.9	2.6
48.3	4	3.2	2.9	2.9	2.9
60.3	4.5	3.6	3.2	3.2	2.9
76.1	4.5	3.6	3.2	3.2	3.2
88.9	5	4	3.2	3.6	3.2
101.6	—	—	3.6	—	—
114.3	5.4	4.5	3.6	4	3.6
139.7	5.4	5	4.5	—	—
165.1	5.4	5	4.5	—	—

Welded steel tubes for pressure purposes-Technical delivery conditions

–Non-alloy steel tubes with specified room temperature properties EN10217-1

Outside diameter	Wall Thickness	Max Length	Outside diameter	Wall Thickness	Max Length
21.3	2.0~4.0	12.192	133	2.0~11.0	12.802
22	2.0~4.0	12.192	139.7	2.0~11.0	12.802
26.9	2.0~4.5	12.192	141.3	2.0~11.0	12.802
33.7	2.0~4.5	12.192	159	2.0~11.0	12.802
42.4	2.0~5.0	12.802	168.3	3.0~11.0	12.802
48.3	2.0~5.0	12.802	177.8	3.0~11.0	12.802
60.3	2.0~5.5	12.802	193.7	3.0~11.0	12.802
73	2.0~7.0	12.802	219.1	3.0~12.5	12.802
76.1	2.0~7.0	12.802	244.5	3.0~12.5	12.802
88.9	2.0~10.0	12.802	273	3.0~14.0	12.802
101.6	2.0~10.0	12.802	323.9	4.0~14.0	12.802
108	2.0~11.0	12.802	355.6	4.0~14.0	12.802
114.3	2.0~11.0	12.802			

Specification for Casing and Tubing (API SPECIFICATION 5CT)

Labels		Outside diameter		Wall Thickness		Max Length	
1	2	mm	in	mm	in	m	feet
4-1/2"	9.50~15.10	114.3	4.5	5.21~8.56	0.205~0.337	12.802	42
5"	11.50~24.10	127	5	5.59~12.7	0.220~0.500	12.802	42
5-1/2"	14.00~26.80	139.7	5.5	6.20~12.70	0.244~0.500	12.802	42
6-5/8"	20.00~32.00	168.28	6.625	7.32~12.06	0.288~0.475	12.802	42
7"	17.00~35.00	177.8	7	5.87~12.65	0.231~0.498	12.802	42
7-5/8"	24.00~39.00	193.68	7.625	7.62~12.70	0.300~0.500	12.802	42
8-5/8"	24.00~44.00	219.08	8.625	6.71~12.70	0.264~0.500	12.802	42
9-5/8"	32.30~47.00	244.48	9.625	7.92~11.99	0.312~0.472	12.802	42
10-3/4"	32.75~55.50	273.05	10.75	7.09~12.57	0.279~0.495	12.802	42
11-3/4"	42.00~60.00	298.45	11.75	8.46~12.42	0.333~0.489	12.802	42
13-3/8"	48.00~72.00	339.72	13.375	8.38~13.06	0.330~0.514	12.802	42

GRADE: H40, J55, K55

Cold formed welded structural hollow sections of non-alloy and fine grain steels EN10219

Outside diameter	Wall Thickness	Outside diameter	Wall Thickness
mm	mm	mm	mm
21.3	2.0~4.0	139.7	3.0~10.0
26.9	2.0~4.0	168.3	3.0~12.0
33.7	2.0~5.0	177.8	4.0~12.5
42.4	2.0~5.0	193.7	4.0~12.5
48.3	2.0~5.0	219.1	4.0~12.5
60.3	2.0~6.3	244.5	5.0~12.5
76.1	2.0~7.0	273	5.0~14.0
88.9	2.0~10.0	323.9	5.0~14.0
101.6	2.0~10.0	355.6	5.0~14.0
114.3	2.5~10.0	-	-
B*B	Wall Thickness	H*B	Wall Thickness
mm	mm	mm	mm
20*20	1.5~2.75	40*20	2.0~3.0
25*25	1.5~3.0	50*30	2.0~4.0
30*30	1.5~3.0	60*40 (70*50, 80*40)	2.0~5.0
40*40	1.5~4.0	80*60 (90*50, 100*40)	2.0~5.0
50*50	2.0~5.0	100*50	2.5~6.3
60*60	2.0~6.3	100*60	2.5~6.3
70*70	2.5~6.3	100*80	2.5~6.3
80*80	2.5~7.0	120*60	2.5~6.3
90*90	2.5~8.0	120*80	3.0~6.3
100*100	2.5~8.0	140*80	4.0~6.3
120*120	2.5~8.0	150*100	4.0~8.0
140*140	3.0~8.0	160*80	4.0~8.0
150*150	3.0~8.0	180*100	4.0~8.0
160*160	3.0~8.0	200*100	4.0~8.0
180*180	3.0~8.0	200*120	4.0~8.0
200*200	5.0~12.0	250*150	5.0~10.0
220*220	5.0~12.0	260*180	5.6~10.0
250*250	5.0~14.0	300*100	6.0~10.0
260*260	6.0~14.0	300*150	6.0~12.0
300*300	6.0~14.0	300*200	6.0~14.0
350*350	6.0~14.0	350*250	6.0~14.0
400*400	6.0~14.0	400*200	6.0~14.0
-	-	400*300	6.0~14.0

Specification for Casing and Tubing (API SPECIFICATION 5CT)

Specification for Line Pipe (API SPECIFICATION 5L)

Size (in)	Outside diameter		Wall Thickness		Max Length	
	mm	in	mm	in	m	feet
0.84	21.3	0.84	2.1~3.7	0.083~0.147	12.192	40
1.05	26.7	1.05	2.1~3.9	0.083~0.154	12.192	40
1.315	33.4	1.315	2.1~4.5	0.083~0.179	12.192	40
1.66	42.2	1.66	2.1~4.9	0.083~0.191	12.802	42
1.9	48.3	1.9	2.1~5.1	0.083~0.200	12.802	42
2-3/8	60.3	2-3/8	2.1~7.1	0.083~0.281	12.802	42
2-7/8	73	2-7/8	2.5~7.0	0.100~0.276	12.802	42
3-1/2	88.9	3-1/2	2.5~7.1	0.100~0.281	12.802	42
4	101.6	4	2.5~8.1	0.100~0.318	12.802	42
4-1/2	114.3	4-1/2	2.5~8.6	0.100~0.337	12.802	42
5-9/16	141.3	5-9/16	2.5~9.5	0.100~0.375	12.802	42
6-5/8	168.3	6-5/8	2.5~11.0	0.100~0.432	12.802	42
8-5/8	219.1	8-5/8	3.2~12.7	0.125~0.500	12.802	42
10-3/4	273	10-3/4	4.5~15.1	0.177~0.594	12.802	42
12-3/4	323.9	12-3/4	5.0~15.1	0.197~0.594	12.802	42
14	355.6	14	5.0~15.1	0.197~0.594	12.802	42

GRADE: 0.84"~1.9 : A25, A, B

2-3/8" ~14" : A25, A, B, X42, X46, X52, X56, X60, X65

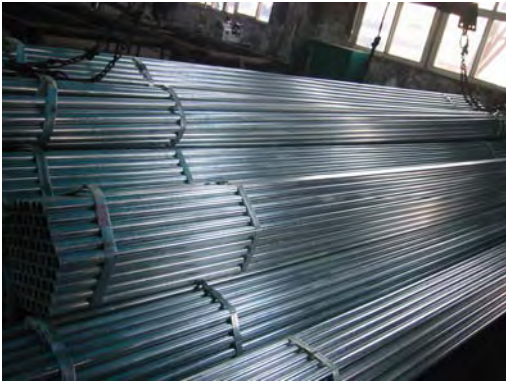
Pipe, Steel, Black and Hot-Dipped, Zinc-Coated and Welded ASTM A53/ A53M

Size		Outside diameter		Wall Thickness		Max Length	
NPS	DN	mm	in	mm	in	m	feet
1/2	15	21.7	0.840	2.77~3.73	0.109~1.147	12.192	40
3/4	20	26.7	1.050	2.87~3.91	0.113~0.154	12.192	40
1	25	33.4	1.315	3.38~4.55	0.133~0.179	12.192	40
1-1/4	32	42.2	1.660	3.56~4.85	0.140~0.191	12.802	42
1-1/2	40	48.3	1.900	3.68~5.08	0.145~0.200	12.802	42
2	50	60.3	2.375	3.91~5.54	0.154~0.218	12.802	42
2-1/2	65	73	2.875	5.16~7.01	0.203~0.276	12.802	42
3	80	88.9	3.500	3.18~7.14	0.125~0.281	12.802	42
3-1/2	90	101.6	4.000	3.18~8.08	0.125~0.318	12.802	42
4	100	114.3	4.500	3.18~8.56	0.125~0.337	12.802	42
5	125	141.3	5.563	3.96~9.52	0.156~0.375	12.802	42
6	150	168.3	6.625	4.78~10.97	0.188~0.432	12.802	42
8	200	219.1	8.625	4.78~12.70	0.188~0.500	12.802	42
10	250	273	10.750	4.78~15.09	0.188~0.594	12.802	42
12	300	323.8	12.750	5.16~15.09	0.203~0.594	12.802	42
14	350	355.6	14.000	5.33~15.09	0.210~0.594	12.802	42

GRADE : A, B

Bundling, storage and loading of steel pipes

1. Bundling



2. Storage



3. Loading

