

## DIN EN ISO 1127 Stainless Steel Pipes and OD Tube ASTM A269/270

### DIN EN ISO 1127 Stainless Steel Pipes

The dimensions of ISO pipes are described in the standard "DIN EN ISO 1127 Stainless steel pipes" (purchased BEUTH Verlag GmbH, 10722 Berlin). This standard was developed from standards DIN 2462 (dimensions of seamless pipes) and DIN 2463 (dimensions of welded pipes).

It defines dimensions, limit allowances and length dimensions. Compared to the old DIN 2462 and 2463 specifications for seamless and welded pipes are now combined in one standard. Thus the differences between the two standards no longer apply.

**The limit dimensions are defined as follows:**

**a. for the outer diameter in tolerance classes**

D1 ( $\pm 1.5\%$  with min.  $\pm 0.75$  mm)

D2 ( $\pm 1\%$  with min.  $\pm 0.5$  mm)

D3 ( $0.75\%$  with min.  $\pm 0.3$  mm)

D4 ( $\pm 0.5\%$  with min.  $\pm 0.1$  mm)

**b. for the wall thickness**

T1 ( $\pm 15\%$  with min.  $\pm 0.6$  mm)

T2 ( $\pm 12.5\%$  with min.  $\pm 0.4$  mm)

T3 ( $\pm 10\%$  with min.  $\pm 0.2$  mm)

T4 ( $\pm 7.5\%$  with min.  $\pm 0.15$  mm)

T5 ( $\pm 5\%$  with min.  $\pm 0.1$  mm)

ISO pipes are produced from hot-rolled sheet metal. Unlike qualities acc. to pipe standard DIN EN 10357 (cold strip raw material), the surface quality specific to the raw material, described as "orange peel", cannot be improved by polishing.

Further definitions of the quality of the surface (roughness etc.) and ferrite content are not included for ISO pipes.

Do you require DIN EN ISO 1127 type pipes? Send your enquiry to our staff and we will be happy to help.

### OD Tube ASTM A269/270

The standards ASTM A269/A270 describe seamless and welded pipes made from austenitic and ferritic/austenitic stainless steel for general and hygienic applications.

They describe the dimensions, limit allowances, type of heat treatment, permissible steel types and the tests which have to be carried out on the pipe.

#### OD Tube ASTM A269/270 (US standard) annealed

	1.4307 (304L) TC1	1.4404 (316L) TC1			
Dimensions	Article No.	Article No.			Weight [kg/m]
19.05 x 1.65	45098	55098			0.72
25.4 x 1.65	45099	55099			0.98
38.1 x 1.65	45100	55100			1.51
50.8 x 1.65	45101	55101			2.03
63.5 x 1.65	45102	55102			2.56
76.1 x 1.65	45103	55103			3.08
101.6 x 2.11	45104	55104			5.26

- annealed
- pickled inside
- pickled outside

#### OD Tube ASTM A269/270 (US standard) annealed/dull polish 240 grit

	1.4307 (304L) TC1	1.4404 (316L) TC1			
Dimensions	Article No.	Article No.			Weight [kg/m]
12.7 x 1.65	N/A	55084			0.46
19.05 x 1.65	N/A	55085			0.72
25.4 x 1.65	45107	55107			0.98
38.1 x 1.65	45108	55108			1.51
50.8 x 1.65	45109	55109			2.03
63.5 x 1.65	45110	55110			2.56
76.1 x 1.65	45111	55111			3.08
101.6 x 2.11	45112	55112			5.26

- annealed
- pickled inside
- satin polish outside