

MANUFACTURING PROCEDURES	TECHNICAL CONDITIONS	MATERIALS
Electric Resistance Weld	Stas 715 /1, 2	A25, GR. A; GR. B
Double Submerged Arc Weld	API 5 L	X 42; X 46; X 52, X60, X65
Hot Rolled	Gost 8732	ST 2; ST 4; ST 10; ST 20
Drawn	Din 1629 / 2448	ST 37.0; 44.0; 52.0

LINE PIPE SPECIFICATIONS							
OUTSIDE DIAMETER		PLAIN-END/BEVELLED END		WALL THICKNESS		INTERNAL WALL	
IN	MM	LB/FT	KG/M	IN	MM	IN	MM
2 3/8	60.30	3.36	5.03	0.141	3.6	2.093	53.1
2 3/8	60.30	3.65	5.42	0.154	3.9	2.067	52.5
2 3/8	60.30	4.05	6.07	0.172	4.4	2.031	51.5
2 3/8	60.30	4.39	6.57	0.188	4.8	1.999	50.7
2 3/8	60.30	5.02	7.43	0.218	5.5	1.939	49.3
2 3/8	60.30	5.67	8.51	0.25	6.4	1.875	47.5
2 3/8	60.30	6.28	9.31	0.281	7.1	1.813	46.1
2 7/8	73.00	4.12	6.16	0.141	3.6	2.593	65.8
2 7/8	73.00	5.63	6.81	0.156	4.0	2.563	65.0
2 7/8	73.00	4.97	7.44	0.172	4.4	2.531	64.2
2 7/8	73.00	5.40	8.07	0.188	4.8	2.499	63.4
2 7/8	73.00	5.79	8.69	0.203	5.2	2.469	62.6
2 7/8	73.00	6.13	9.16	0.216	5.5	2.433	62.0
2 7/8	73.00	7.01	10.51	0.25	6.4	2.375	60.2
2 7/8	73.00	7.66	11.39	0.276	7.0	2.323	59.0
3 1/2	88.90	5.06	7.57	0.141	3.6	3.218	81.7
3 1/2	88.90	5.57	8.37	0.156	4.0	3.188	80.9
3 1/2	88.90	6.11	9.17	0.172	4.4	3.156	80.1
3 1/2	88.90	6.65	9.95	0.188	4.8	3.124	79.3
3 1/2	88.90	7.58	11.31	0.216	5.5	3.068	77.9
3 1/2	88.90	8.68	13.02	0.25	6.4	3.000	76.1
3 1/2	88.90	9.66	14.32	0.218	7.1	2.938	74.7
3 1/2	88.90	10.25	15.24	0.3	7.6	2.900	73.7
3 1/2	88.90	18.59	27.63	0.6	15.2	2.300	58.5
4	101.60	5.81	8.70	0.141	3.6	3.718	94.4
4	101.60	6.40	9.63	0.156	4.0	3.688	93.6
4	101.60	7.03	10.55	0.172	4.4	3.656	92.8
4	101.60	7.65	11.46	0.188	4.8	3.624	92.0
4	101.60	9.11	13.48	0.266	5.7	3.548	90.2
4	101.60	10.01	15.02	0.25	6.4	3.500	88.8
4	101.60	11.16	16.55	0.281	7.1	3.438	87.4
4	101.60	12.50	18.68	0.318	8.1	3.364	85.4
4 1/2	114.30	6.56	9.83	0.141	3.6	4.218	107.1
4 1/2	114.30	7.24	10.88	0.156	4.0	4.188	106.3
4 1/2	114.30	7.95	11.92	0.172	4.4	4.156	105.5
4 1/2	114.30	8.66	12.96	0.188	4.8	4.124	104.7
4 1/2	114.30	9.32	13.99	0.203	5.2	4.094	103.9
4 1/2	114.30	10.01	15.01	0.219	5.6	4.062	103.1
4 1/2	114.30	10.79	16.02	0.237	6.0	4.026	102.3
4 1/2	114.30	11.35	17.03	0.25	6.4	4.000	101.5
4 1/2	114.30	12.66	18.77	0.281	7.1	3.938	100.1
4 1/2	114.30	13.96	20.73	0.312	7.9	3.876	98.5
4 1/2	114.30	14.98	22.42	0.337	8.6	3.826	97.1
4 1/2	114.30	19.00	28.25	0.438	11.1	3.624	92.1
4 1/2	114.30	22.51	33.56	0.531	13.5	3.438	87.3
4 1/2	114.30	27.54	40.99	0.674	17.1	3.152	80.1
5 9/16	141.30	12.50	18.74	0.219	5.6	5.125	130.1
5 9/16	141.30	14.62	31.92	0.25	6.6	5.047	128.0
5 9/16	141.30	15.85	23.50	0.281	7.1	5.001	127.1
5 9/16	141.30	17.50	25.99	0.312	7.9	4.939	125.5
5 9/16	141.30	19.17	28.45	0.344	8.7	4.875	123.9
5 9/16	141.30	20.78	30.88	0.375	9.5	4.813	122.3
5 9/16	141.30	27.04	40.28	0.5	12.7	4.563	115.9
5 9/16	141.30	32.96	49.17	0.625	15.9	4.313	109.5
5 9/16	141.30	38.55	57.56	0.75	19.1	4.063	103.1
6 5/8	168.30	17.02	25.55	0.25	6.4	6.125	155.5
6 5/8	168.30	18.97	28.22	0.28	7.1	60.65	154.1
6 5/8	168.30	21.04	31.25	0.312	7.9	6.001	152.5
6 5/8	168.30	23.08	34.24	0.344	8.7	5.937	150.9
6 5/8	168.30	25.03	37.20	0.375	9.5	5.875	149.3
6 5/8	168.30	28.57	42.67	0.432	11.0	5.761	146.3
6 5/8	168.30	32.71	48.73	0.5	12.7	5.625	142.9
6 5/8	168.30	36.39	54.31	0.562	14.3	5.501	139.7
6 5/8	168.30	40.05	59.76	0.625	15.9	5.375	136.5
6 5/8	168.30	45.35	67.69	0.719	18.3	5.187	131.7
6 5/8	168.30	47.06	70.27	0.75	19.1	5.125	130.1
6 5/8	168.30	53.73	79.98	0.875	22.2	4.875	123.9
8 5/8	219.10	22.36	33.57	0.25	6.4	8.125	206.3
8 5/8	219.10	24.70	36.61	0.277	7.0	8.071	205.1
8 5/8	219.10	27.70	41.14	0.312	7.9	8.001	203.3
8 5/8	219.10	28.55	42.65	0.322	8.2	7.981	202.7
8 5/8	219.10	30.42	45.14	0.344	8.7	7.937	201.7
8 5/8	219.10	33.04	49.10	0.375	9.5	7.875	200.1

OUTSIDE DIAMETER		PLAIN-END/BEVELLED END		WALL THICKNESS		INTERNAL WALL	
IN	MM	LB/FT	KG/M	IN	MM	IN	MM
8 5/8	219.10	38.30	56.94	0.438	11.1	7.749	196.9
8 5/8	219.10	43.39	64.64	0.5	12.7	7.625	193.7
8 5/8	219.10	48.40	72.22	0.562	14.3	7.501	190.5
8 5/8	219.10	53.40	79.67	0.625	15.9	7.375	187.3
8 5/8	219.10	60.71	90.62	0.719	18.3	7.187	182.5
8 5/8	219.10	63.08	94.20	0.75	19.1	7.125	180.9
8 5/8	219.10	67.76	100.84	0.812	20.6	7.001	177.9
8 5/8	219.10	72.42	107.79	0.875	22.2	6.875	174.7
8 5/8	219.10	81.44	121.32	1.000	25.4	6.625	168.3
10 3/4	273.10	34.24	51.03	0.307	7.8	10.136	257.5
10 3/4	273.10	38.23	56.72	0.344	8.7	10.062	255.7
10 3/4	273.10	40.48	60.50	0.365	9.3	10.020	254.5
10 3/4	273.10	48.24	71.72	0.438	11.1	9.874	250.9
10 3/4	273.10	54.74	81.55	0.5	12.7	9.752	247.7
10 3/4	273.10	61.15	91.26	0.562	14.3	9.626	244.5
10 3/4	273.10	67.58	100.85	0.625	15.9	9.500	241.3
10 3/4	273.10	77.03	114.99	0.719	18.3	9.312	236.5
10 3/4	273.10	86.18	128.27	0.812	20.6	9.126	231.9
10 3/4	273.10	92.28	137.36	0.875	22.2	9.000	228.7
10 3/4	273.10	98.30	146.30	0.938	23.8	8.874	225.5
10 3/4	273.10	104.13	155.15	1.000	25.4	8.750	222.3
10 3/4	273.10	126.83	188.75	1.250	31.8	8.250	209.5
12 3/4	323.90	43.77	65.35	0.330	8.4	12.090	307.1
12 3/4	323.90	45.58	67.62	0.334	8.7	12.062	306.5
12 3/4	323.90	49.56	73.65	0.375	9.5	12.000	304.9
12 3/4	323.90	53.52	79.65	0.406	10.3	11.938	303.3
12 3/4	323.90	57.59	85.62	0.438	11.1	11.874	301.7
12 3/4	323.90	65.42	97.46	0.500	12.7	11.750	298.5
12 3/4	323.90	73.15	109.18	0.562	14.3	11.626	295.3
12 3/4	323.90	80.93	120.76	0.625	15.9	11.500	292.1
12 3/4	323.90	88.63	132.23	0.688	17.5	11.374	288.9
12 3/4	323.90	96.12	143.56	0.750	19.1	11.250	285.7
12 3/4	323.90	103.53	154.08	0.812	20.6	11.126	282.7
12 3/4	323.90	110.97	165.17	0.875	22.2	11.000	279.5
12 3/4	323.90	118.33	176.13	0.938	23.8	10.874	276.3
12 3/4	323.90	125.49	186.97	1.000	25.4	10.750	273.1
12 3/4	323.90	132.57	197.68	1.062	27.0	10.626	269.9
12 3/4	323.90	139.67	208.27	1.125	28.6	10.500	266.7
12 3/4	323.90	153.53	229.06	1.250	31.8	10.250	260.3
14	355.60	50.17	74.42	0.344	8.7	13.312	338.2
14	355.60	54.57	81.08	0.375	9.5	13.250	336.6
14	355.60	58.94	87.71	0.406	10.3	13.188	335.0
14	355.60	63.44	94.30	0.438	11.1	13.124	333.4
14	355.60	67.78	100.86	0.469	11.9	13.062	331.8
14	355.60	72.09	107.39	0.500	12.7	13.000	330.2
14	355.60	80.66	120.36	0.562	14.3	12.876	327.0
14	355.60	89.28	133.19	0.625	15.9	12.750	323.8
14	355.60	97.81	145.91	0.688	17.5	12.624	320.6
14	355.60	106.13	158.49	0.750	19.1	12.500	317.4
14	355.60	114.37	170.18	0.812	20.6	12.376	314.4
14	355.60	122.65	182.52	0.875	22.2	12.250	311.2
14	355.60	130.85	194.74	0.938	23.8	12.124	308.0
14	355.60	138.84	206.83	1.000	25.4	12.000	304.8
14	355.60	146.74	218.79	1.062	27	11.876	301.6
14	355.60	154.69	230.63	1.125	28.6	11.750	298.4
14	355.60	170.21	253.31	1.250	31.8	11.500	292.1
16	406.40	67.62	100.61	0.406	10.3	15.188	385.8
16	406.40	72.80	108.20	0.438	11.1	15.124	384.2
16	406.40	77.79	115.77	0.469	11.9	15.062	382.6
16	406.40	82.77	123.30	0.500	12.7	15.000	381.0
16	406.40	92.66	138.27	0.562	14.3	14.876	377.8
16	406.40	102.63	153.11	0.625	15.9	14.750	374.6
16	406.40	112.51	167.83	0.688	17.5	14.624	371.4
16	406.40	122.15	182.42	0.750	19.1	14.500	368.2
16	406.40	131.71	195.98	0.812	20.6	14.376	365.2
16	406.40	141.34	210.33	0.875	22.2	14.250	362.0
16	406.40	150.89	224.55	0.938	23.8	14.124	358.8
16	406.40	160.20	238.64	1.000	25.4	14.000	355.6
16	406.40	169.43	252.61	1.062	27.0	13.876	352.4
16	406.40	178.72	266.45	1.125	28.6	13.750	349.2
16	406.40	187.93	280.17	1.188	30.2	13.624	346.0
16	406.40	196.91	293.76	1.250	31.8	13.500	342.8
18	457.00	87.81	130.62	0.469	11.9	17.062	433.2
18	457.00	93.45	139.15	0.500	12.7	17.000	431.6
18	457.00	104.67	156.11	0.562	14.3	16.876	428.4
18	457.00	115.98	172.95	0.625	15.9	16.750	425.2
18	457.00	127.21	189.67	0.688	17.5	16.624	422.0
18	457.00	138.17	206.25	0.750	19.1	16.500	418.1
18	457.00	149.06	221.69	0.812	20.6	16.376	415.8
18	457.00	160.03	238.03	0.875	22.2	16.250	412.6

OUTSIDE DIAMETER		PLAIN-END/BEVELLED END		WALL THICKNESS		INTERNAL WALL	
IN	MM	LB/FT	KG/M	IN	MM	IN	MM
18	457.00	170.93	254.25	0.938	23.8	16.124	409.4
18	457.00	181.56	270.34	1.000	25.4	16.000	406.2
18	457.00	192.11	386.30	1.062	27.0	15.876	403.0
18	457.00	202.75	302.14	1.125	28.6	15.750	399.6
18	457.00	213.31	317.85	1.188	30.2	15.626	396.6
18	457.00	233.61	333.41	1.250	31.8	15.500	393.4
20	508.00	104.13	155.12	0.500	12.7	19.000	482.6
20	508.00	116.67	174.10	0.562	14.3	18.876	479.4
20	508.00	129.33	192.95	0.625	15.9	18.750	476.2
20	508.00	141.90	211.68	0.688	17.5	18.624	473.0
20	508.00	154.19	230.27	0.750	19.1	18.500	496.8
20	508.00	166.40	247.60	0.812	20.6	18.376	466.8
20	508.00	178.72	265.95	0.875	22.2	18.250	463.6
20	508.00	190.96	284.18	0.938	23.8	18.124	460.4
20	508.00	202.92	302.28	1.000	25.4	18.000	457.2
20	508.00	214.80	320.26	1.062	27.0	17.876	454.0
20	508.00	26.78	338.11	1.125	28.6	17.750	450.8
20	508.00	238.68	355.83	1.188	30.2	17.626	447.6
20	508.00	250.31	373.43	1.250	31.8	17.500	444.4
20	508.00	261.86	389.81	1.312	33.3	17.376	441.4
20	508.00	273.51	407.17	1.375	34.9	17.250	438.2
Sizes 22" (558.8mm) Thru 60" (1524mm) Available Upon Request							
When Ordering Specify Range (Length) And End Connection							