

ΟΒΘΑΥ ΝΟΑΕΥΙ ΟΑ ΑΑΝΘΙ ΑΙ ΟΑ ΑΕΒ Γ ΑΟΘΑΙ ΑΒΑΒΑΑΑΟΟΥΑΑΡΟΑΕ Ε Γ ΑΟΘΑΟΕΙ ΕΧΑΝΕΙ Ε ΙΘΙ Ι ΟΘΕΑΙ Ι Ι ΝΘΕ Ι Ι ΑΙ ΝΘ 550-75
 Seamless steel pipes for petroleum processing and petrochemical industry made to GOST 550-75

Αί θυ-άααοί θι εδί ααί ί ύα οδθαύ
 Hot-worked pipes

Νί θθαί άί ο άθόί ί ύ "Α", "Α".
 Γ άθεε νθαεε 1505, 1505Ι, 1505ΑΟ, 102Ι .
 Assortment of group "A", "B".
 Steel grades 15H5, 15H5M, 15H5VF, 1H2M

Γ άθθαί ύε άεαί άοθ, ί ί External diameter, mm	Οί εύεíα νθαί έε, ί ί Wall thickness, mm	Άεεία οθθα, ί Length of tubes, m
76	8	4-10
89	6-8	4-10
89	9-10	4-10
102	6-9	4-10
102	10	4-10
102	11-12	4-10
108	9-10	4-10
108	11-12	4-9
108	13-14	4-7,5
114	6-8	4-11
114	9-10	4-10
114	11-12	4-8
114	13-14	4-8
127	6-10	4-11
127	11-12	4-10
127	13-14	4-8,5
133	6-8	4-11
133	9-10	4-10
133	11-12	4-9
133	13-14	4-8
152	8	4-11
152	10	4-10

Αθθαεά άεεί ύ οθθα εçαί οάεεάαβονύ ί ί νί έεανί ααί έεβ.
 The pipes of other length are manufactured by agreement.

Γ άθαί έ-άñέεά νάί έñθαά
 Mechanical properties

Γ άθεα νθαεε Steel grade	Άθαί άί ί ί ά νί ί θί οεάεάί έα θαçθύαο, ί ί ά Tensile strength, MPa	Γ θααε οάεο-άñε, ί ί ά Yield strength, MPa	Γ ί νί οεάεύ ί ί ά οάεεί άί έα, % Elongation, pct	Γ ί νί οεάεύ ί ί ά νθαί έα, % Contraction, pct	Οάαθί άγ άγçεί νου, Αε/ñι ² Impact strength, J/ñm ²	×έñεί οαάθαι ñεε ί ί Άδεί άεεβ Γ Α, ί ά άί έαά Brinell hardness, HB, not more	Άεαύ οθθα Tube types
10	353	216	25	50	80	137	άί θυ-ά- άαοί θι έ- οί άαί ί ύά hot-worked
20	431	255	22	50	80	156	
10Α2	421	265	21	50	120	197	
1505	392	216	21	50	100	170	
1505Ι	392	216	24	50	120	170	
1505ΑΟ	392	216	22	50	120	170	
1208ΑΟ	392	167	22	50	100	170	
10	333	206	26	-	-	137	οί έί άί ί άαοί θ- ί έθί άαί ί ύά cold-worked
20	412	245	23	-	-	156	
1505Ι	392	216	22	-	-	170	

Νί θθαί άί ο άθόί ί ύ "Α", "Α".
 Γ άθεε νθαεε 10, 20, 10Α2.
 Assortment of group "A", "B".
 Steel grades 10, 20, 10G2.

Γ άθθαί ύε άεαί άοθ, ί ί External diameter, mm	Οί εύεíα νθαί έε, ί ί Wall thickness, mm	Άεεία οθθα, ί Length of tubes, m
76	6-12	ί άί άθί άγ 4,0-9,0;
83	6-12	άί έαά 9,0 ί ί νί έεανί ααί έεβ;
89	5-14	ί άθί άγ 5,0-9,0;
95	5-18	εθθαοί άγ ά ί θααάεαο ί άθί έε;
102	5-20	άεγ S=4,5-5,0 ί ί - άί 9,5;
108	4,5-22	άεγ S>22 ί ί - άί 7,0.
114	4,5-24	Random length from 4,0 to 9,0; more than 9,0 - if agreed; a specified length from 5,0 to 9,0 multiple within specified length; for S=4,5-5,0 mm - άί 9,5; for S>22 mm - up to 7,0.
121	4,5-26	
127	4,5-26	
133	4,5-26	
140	4,5-32	
152	4,5-25	
159	4,5-25	
168	6,0-12	

S - οί εύεíα νθαί έε
 S - wall thickness

Γ θεεί ί άί έγ ί ί άεαί άοθ ο οί εύεíα νθαί έε
 ί ί ΑΙ ΝΘ 8732-78.
 Permissible deviations in diameter and wall thickness according to GOST 8732-78

Οί έί άί ί άαοί θι εδί άαί ί ύά οδθαύ
 Cold-worked pipes

Νί θθαί άί ο άθόί ί ύ "Α".
 Γ άθεε νθαεε 10, 20, 10Α2, 150Ι .
 Assortment of group "A".
 Steel grades 10, 20, 10G2, 15HM.

Γ άθθαί ύε άεαί άοθ, ί ί External diameter, mm	Οί εύεíα νθαί έε, ί ί Wall thickness, mm	Άεεία οθθα, ί Length of tubes, m
19	1,5; 2,5	ί άί άθί άγ 1,5-9,0 ί άθί άγ 5,0-9,0 Έθθαοί άγ ά ί θααάεαο ί άί άθί έε Random length from 1,5 to 9,0 a specified length from 5,0 to 9,0 multiple within random length
20	2,0; 2,5	
25	2,0; 2,5; 3,0	
38	2,0-3,0; 3,5	
48	4,0; 5,0	
57	4,5	

Νί θθαί άί ο άθόί ί ύ "Α" ά νί ί θααθñθαεε ñ ΑΙ ΝΘ 8733-74/8734-75
 Assortment of group "B" according to GOST 8733-74/8734-75

Άί ί οñεαάι ύά ί θεεί ί άί έγ ί ί ί άθθαί ί ί ο άεαί άοθ ο. Άθόί ί ά "Α"
 Permissible deviations in external diameter. Group "A"

Γ άθεα νθαεε Steel grade	Γ άθθαί ύε άεαί άοθ, ί ί External diameter, mm	Άί ί οñεαάι ύά ί θεεί ί άί έγ, ί ί Permissible deviations, mm	
10, 20	άί 30 άεεβ=εθάεύ ί ί up to 30 inclusive	±0,10	
	ί θ 32 άί 40 άεεβ=εθάεύ ί ί from 32 to 40 inclusive	±0,15	
	ί θ 42 άί 50 άεεβ=εθάεύ ί ί from 42 to 50 inclusive	±0,20	
	ί θ 51 άί 60 άεεβ=εθάεύ ί ί from 51 to 60 inclusive	±0,25	
	ί θ 63 άί 70 άεεβ=εθάεύ ί ί from 63 to 70 inclusive	±0,30	
	ί θ 73 άί 80 άεεβ=εθάεύ ί ί from 73 to 80 inclusive	±0,35	
	ί θ 83 άί 90 άεεβ=εθάεύ ί ί from 83 to 90 inclusive	±0,40	
	άί θυ-άααοί θι εδί άαί ί ύά οδθαύ hot-worked pipes	+0,5%; -1,25%	
	οδθαύ εç εάεθί άαί ί ί έ νθαεε pipes of alloyed steel	άί 30 άεεβ=εθάεύ ί ί up to 30 inclusive	±0,2
		ñáúøá 30 / over 30	±0,3
άί θυ-άααοί θι εδί άαί ί ύά οδθαύ hot-worked pipes		+0,5; -1,25%	

Άί ί οñεαάι ύά ί θεεί ί άί έγ ί ί οί εύεíα νθαί έε. Άθόί ί ά "Α"
 Permissible deviations in wall thickness. Group "A"

Γ άθεα νθαεε Steel grade	Οί εύεíα νθαί έε, ί ί Wall thickness, mm	Άί ί οñεαάι ύά ί θεεί ί άί έγ Permissible deviations
άñά ί άθεε νθαεε all the steel grades	άεγ οί έί άί ί άαοί θι εδί άαί ί ύο οθθα / for cold-worked pipes	±8,0%
	άñά οί εύεíα / all thickness	
	άεγ άί θυ-άααοί θι εδί άαί ί ύο οθθα / for hot-worked pipes	±12,5%
	άί 15,0 / to 15,0	
ñáúøá 15,0 ί ί / over 15,0 mm	±10%	

Άί ί οñεαάι ύά ί θεεί ί άί έγ ί ί ί άθθαί ί ί ο άεαί άοθ ο οί εύεíα νθαί έε οθθα
 άθόί ί ύ "Α" άί έεά ύ ñ ί θααθñθαί άαθ οεαçάί ί ύί ά ΑΙ ΝΘ 8732-78/8734-75.
 The permissible deviations of the external diameter and pipe wall thickness
 of "B" group should correspond to GOST 8732-78/8734-75.