



LINE PIPES FOR USE IN OIL, GAS & PETROLEUM INDUSTRIES CONFORMING TO IS : 1978

NB (mm)	OD (mm)	Wall Thickness (mm)	Plain End Weight (Kg/m)	Test Pressure (Min)	
				Grade Yst 210 STD 100 Kpa	Grade Yst 240 STD 100 Kpa
80	88.90	3.20	6.76	89	104
		3.60	7.57	101	117
		4.00	8.37	112	130
		4.40	9.17	123	143
		4.80	9.95	134	156
		5.50	11.31	154	172
90	101.60	3.60	8.70	88	102
		4.00	9.63	98	114
		4.40	10.55	108	125
		4.80	11.46	117	137
		5.70	13.48	139	162
		6.40	15.02	156	182
		7.10	16.55	174	193
100	114.30	3.60	9.83	78	91
		4.00	10.88	87	101
		4.80	12.96	104	121
		5.20	13.99	113	132
		5.60	15.01	122	142
		6.00	16.02	130	152
		6.40	17.03	139	162
		7.10	18.77	154	180
		125	141.30	3.20	10.90
4.00	13.94			70	82
4.80	16.16			84	98
5.60	18.74			98	115
6.60	21.92			116	135
7.10	23.50			125	145
150	168.30	3.60	14.62	53	62
		4.00	16.21	59	76
		4.80	19.35	71	81
		5.20	20.91	77	89
		5.60	22.47	83	96
		6.40	25.55	94	110
		7.10	28.22	105	122

NB (mm)	OD (mm)	Wall Thickness (mm)	Plain End Weight (Kg/m)	Test Pressure (Min)	
				Grade Yst 210 STD 100 Kpa	Grade Yst 240 STD 100 Kpa
200	219.10	4.80	25.37	54	63
		5.60	29.48	63	74
		6.40	33.57	73	84
		7.00	36.61	79	92
250	273.10	4.80	31.76	44	51
		5.60	36.94	51	59
		6.40	42.09	56	68
		7.10	46.57	65	75
		7.80	51.03	71	83
		8.70	56.72	79	92
		9.30	60.50	85	98
300	323.90	4.80	37.77	37	43
		5.60	43.96	43	50
		6.40	50.11	49	57
		7.10	55.47	54	63
		7.90	61.56	61	71
		8.40	65.35	64	75
		8.70	67.62	67	78
		9.50	73.65	73	85
350	355.60	4.80	41.52	34	39
		5.20	44.93	36	42
		6.40	55.11	45	52
		7.10	61.02	50	58
		7.90	67.74	55	64
		8.70	74.42	61	71
400	406.40	4.80	47.54	29	34
		5.20	51.45	32	37
		5.60	55.35	34	40
		6.40	63.13	39	46
		7.10	69.91	43	51
		7.90	77.63	48	56
		8.70	85.32	53	62
9.50	92.98	58	68		

A. Outside Diameter - The Outside Diameter Tolerances

Shall be as follow,

Pipe Body

For size

48.3 mm and less

Tolerance

+0.04mm

-0.08mm

60.3 mm and above

+/-1%

B. Wall Thickness - The Tolrences on the wall thickness of line pipes shall be as follow :

Type	For	Tolerance
Welded Pipes	73.0 mm and smaller	+20.0%
		-12.5%
	88.9 mm Outer Dia & Higher Dia	+18.0%
		-12.5%

C. Weight

Single Lengths

Standard Weight, regular weight, extra strong and double extra strong pipe

Grade Yst - 210 and Yst - 240 +10.0%
-3.5%

Special plain end pipes - All Grades +10.0%
-5.0%

Car loads lots for min 18000 Kg : -1.75%
Grade Yst 210 & Yst 240 - 2.5%

