HDG Seamless Welded Pipes Hot Dipped Galvanized With PE BE BSPT NPT

Our Product Introduction

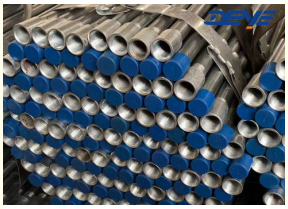
Basic Information

- Place of Origin: CHINA
- Brand Name: DEYE
- Certification: ISO9001:2015 CE
- Model Number: DY-SP-C07
- Minimum Order Quantity: 5 TONS
- Price: USD600/ each ton
- Packaging Details: wooden case, pallet , bundles or as customers' requirement
- Delivery Time: 30 days for usual order, 7 days for stock sizes
- Payment Terms: T/T, D/P, L/C
- Supply Ability: 1000 tons for each month

Product Specification

- Standard: ASME B36.19M, DIN, GOST
- Material: SS316/SS316L, SS304/304L, SAF2507, SAF2205, UNS31803, UNS32750, 904L, INCONEL625
- Size: 1/2"(DN15)-24"(DN600) For SMLS 12" (DN200)-88"(DN2200) For Welded
- Types: Seamless Pipe, Welded Pipe, ERW Pipe, SAW Pipe, FAW Pipe
- Highlight: **Cold Zinc Seamless Welded Pipes**, **Seamless Welded Pipes ASME B36.19M**, **GOST Galvanized Steel Pipes**

More Images



Product Description

Hot Dipped Galvanized HDG Seamless Or Welded Pipes With PE BE BSPT NPT

Hot-dip galvanizing (HDG) pipes , as referenced is the process of dipping fabricated steel into a kettle or vat of molten zinc. Hot-dip galvanizing (HDG) is the process of coating on steel materials with a layer of zinc.
Typical galvanized coatings range from 3-8 mils (75-200 mi- crons) thick. When designing and detailing tapped holes, the increased thickness is important. Best practice suggests that the hole be tapped after galvanizing, removing the coating on the interior mating surface.

Advantage of Hot .Dipped Galvanzied.

1. Lower first cost. Hot dip galvanizing generally has the lowest first cost when compared to other commonly specified comparable protective
coatings for steel. The application cost of labour intensive coatings such as painting has risen far more than the cost of factory applied hot dip galvanizing.
2. Lower maintenance / lower long term cost. Even in cases where the initial cost of hot dip galvanizing is higher than alternative coatings, galvanizing is
invariably more cost effective, due to lower maintenance costs during a longer service life. Maintenance is even more costly when structures are located in
remote areas. Maintenance programmes also invariably have a negative impact on productivity.
3. Long life. The life expectancy of hot dip galvanized coatings on structural members is in excess of 50 years in most rural environments, and between
10 to 30 years in most corrosive urban and coastal environments.
4. Surface preparation. Immersion in acid ensures uniform cleaning of the steel surfaces, in contrast organic coatings must be applied on abrasive blast cleaned
surfaces (generally to ISO 8501 - 1 to SA 2) and verified by third party inspection. Additionally, the application of organic coatings is limited in terms of prevailing
ambient temperature and relative humidity. This adds to the cost of applying a heavy duty paint system.
5. Adhesion. The hot dip galvanized coating is metallurgically bonded to the steel surface.
6. Environmentally friendly. The coating is not toxic, arid it does not contain volatile substances.
7. Speed of coating application. A full protective coating can be applied in minutes, a comparable multicoat paint system, may require up to a week.
The effective application of a hot dip galvanized coating is not influenced by weather conditions.

Product Information/Basis Information/Specification

Name	**Hot Dipped Galvanized HDG Seamless Or Welded Pipes With PE BE BSPT NPT**
Types	HDG smls Boiler Tube Pipe,smls Industry Pipes, welded pipe industry, Zinc Steel pipes
Size	DN: Seamless/ Welded :10-914mm 3/8"-36"
Thickness	Wall Thickness: SCH5S, SCH10S SCH10 SCH20 SCH30 STD SCH40S , SCH40, SCH80S, SCH80, SCH60 XS SCH100 SCH120S SCH120 SCH140 SCH160 XXS 2mm-120mm Accept customization
Length	Single random length/Double random length/Fixed Length 5m-14m,5.8m,6m,10m-12m,12m Accept customization
Surface Treatment	Carbon steel with surface of Bare, painting black, varnished, galvanized, anti-corrosion 3PE PP/EP/FBE coating Stainless Steel with Surface of acid pickling or polished.
Material	Carbon steel: 10#, 20#, 45#, ASTM A105 etc. * ASTM A53, A106, A210, A252, A333 etc; * API5L X42, API 5L X46, API 5L X52, API5L X60, API5L X65, API5L X70 etc; * JIS STPG42, G3454, G3456 etc; * German St37, St42, St45, St52, DIN1626, DIN17175 * Chinese 20#, Q345, 16Mn etc Alloy steel: ASTM A234 GR.WPB,ASTM A182 GR.F22/F11 CL2/CL3, ASTM A234 GR.WP11/WP22 CL.2/CL.1 P1,P2,P5,P9,P11,P12,P22, P91,P92,15CrMO,Cr5Mo,10CrMo910,12CrMo,13CrMo44,30CrMo,A333 GR.1,GR.3,GR.6,GR.7, etc Stainless steel: SS304, SS304L, SS304H, SS321, SS316, SS316L, SS310S, 904L, 254SMO , 253MA etc. Duplex: 2205, 2507, F55 etc. Nickle Alloy: Hastelloy C276, Inconel 601,Inconel 625, Inconel 718, Monel 400, Monel K500 etc. Copper Nickel: CuNi 90/10, CuNi 70/30

Standard	AASME, ASTM, MSS, JIS, DIN, EN * American ASME B36.10M, ASTM, API 5L, API 5CT * Japanese JIS * German DIN * Chinese GB * BS standard
End Connection	Plain end/Beveled, protected by plastic caps on both ends, cut square, grooved, threaded BSPT NPT and coupling.
Applications	Petroleum, chemical, power, gas, metallurgy, shipbuilding, construction, etc
Shipment	By 20GP/ 40GP containers, by loose Containers LCL; bulk vessels, top open containers

Technology/ Technical Data Sheets

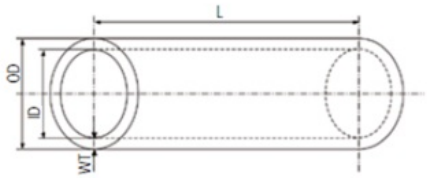
Regular Sizes of Galvanized Steel Pipe					
DN	NB	OD (mm)	WT (mm)	Pcs/Bundle	
15	1/2"	19mm-21.3mm	1.5mm-3.0mm	217	
20	3/4"	25mm-26.9mm	1.5mm-3.0mm	169	
25	1"	32mm-33.7mm	1.5mm-3.0mm	127	
32	1.1/4"	40mm-42.4mm	1.5mm-4.0mm	91	
40	1.1/2"	47mm-48.3mm	1.5mm-4.0mm	91	
50	2"	58mm-60.3mm	1.5mm-4.0mm	61	
65	2.1/2"	73mm-76.1mm	1.5mm-4.0mm	37	
80	3"	87mm-88.9mm	1.5mm-9.5mm	37	
100	4"	113mm-114.3mm	2.0mm-9.5mm	19	Regular Length: 5.7m, 5.8m, 6.0m, 6.4. Besides, we can make to order for you according to your requested length.
125	5"	140mm-141.3mm	3.0mm-9.5mm	19	
150	6"	165mm-168.3mm	3.0mm-12.0mm	19	
200	8"	219.1	3.2mm-12.0mm	7	
250	10"	273	3.2mm-12.0mm	5 or 1	
300	12"	323.9mm-325mm	6.0mm-15mm	3 or 1	
350	14"	355mm-355.6mm	8.0mm-15mm	1	
400	16"	406.4mm	8.0mm-20mm	1	
450	18"	457mm	9.0mm-23mm	1	
500	20"	508mm	9.0mm-23mm	1	
550	22"	558.8mm	9.0mm-23mm	1	
600	24"	609.6mm	9.0mm-23mm	1	

Thickness List for seamless pipes as per ANSI B36.10
Unit: MM

NPS	Outside Dimeter	Different thickness with tolerance of +-12.5%							
		STD	**Sch40**	Sch60	**XS**	**Sch80**	Schl20	Sch160	**XXS**
1/8	10. 3	1. 73	1. 73	——	2. 41	2. 41	——	——	——
1/4	13. 7	2. 24	2. 24	—	3. 02	3. 02	—	—	—
3/8	17. 1	2. 31	2. 31	—	3. 20	3. 20	—	—	—
1/2	21. 3	2. 77	2. 77	——	3. 73	3. 73	——	4. 78	7. 47
3/4	26. 7	2. 87	2. 87	——	3. 91	3. 91	——	5. 56	7. 82
1	33.4	3. 38	3. 38	—	4. 55	4. 55	—	6. 35	9. 09
1 1/4	42. 2	3. 56	3. 56	—	4. 85	4. 85	—	6. 35	9. 70
1 1/2	48. 3	3. 68	3. 68	——	5. 08	5. 08	——	7. 14	10. 15
2	60. 3	3. 91	3. 91	——	5. 54	5. 54	——	8. 74	11. 07
2 1/2	73. 0	5. 16	5. 16	—	7. 01	7.01	—	9. 53	14. 02
3	88. 9	5. 49	5. 49	—	7. 62	7. 62	—	11. 13	15. 24
3 1/2	101. 6	5. 74	5. 74	——	8. 08	8. 08	——	——	——
4	114. 3	6.02	6. 02	——	8. 56	8. 56	11. 13	13. 49	17. 12
5	141. 3	6. 55	6. 55	—	9. 53	9. 53	12. 70	15. 88	19. 05
6	168. 3	7. 11	7. 11	—	10. 97	10. 97	14. 27	18. 26	21.95
8	219. 1	8. 18	8. 18	10. 31	12. 70	12. 70	18. 26	23. 01	22.23
10	273. 1	9. 27	9.27	12. 70	12. 70	15. 09	21. 44	28. 58	25. 40
12	323.9	9. 53	10. 31	14. 27	12. 70	17. 48	25. 40	33. 32	25. 40
14	355. 6	9. 53	11. 13	15. 09	12. 70	19. 05	27. 79	35. 71	—
16	406. 4	9. 53	12. 70	16. 66	12. 70	21. 44	30. 96	40. 49	——
18	457. 2	9. 53	14. 27	19. 05	12. 70	23. 83	34. 96	45. 24	——
20	508. 0	9. 53	15. 09	20. 62	12. 70	26. 19	38. 10	50. 01	—
22	558. 8	9. 53	—	22. 23	12. 70	28. 58	41. 28	53. 98	—
24	609. 6	9. 53	17. 48	24. 61	12. 70	30. 96	46. 02	59. 54	——
26	660.4	9. 53	——	——	12. 70	——	——	——	——
28	711.2	9. 53	—	—	12. 70	—	—	—	—
30	762. 0	9. 53	—	—	12. 70	—	—	—	—

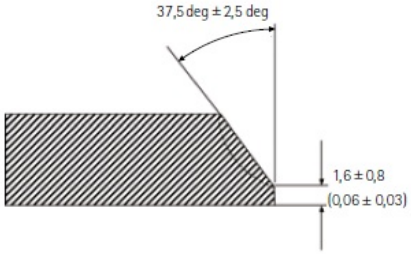
32	812. 8	9. 53	17. 48	——	12. 70	——	——	——	——
34	863. 6	9. 53	17. 48	——	12. 70	——	——	——	——
36	914. 4	9. 53	17. 48	—	12. 70	—	—	—	—
38	965.2	9. 53	—	—	12. 70	—	—	—	—
40	1016. 0	9. 53	——	——	12. 70	——	——	——	——
42	1066. 8	9. 53	——	——	12. 70	——	——	——	——
44	1117. 6	9. 53	—	—	12. 70	—	—	—	—
46	1168.4	9. 53	—	—	12. 70	—	—	—	—
48	1219. 2	9. 53	—	—	12. 70	—	—	—	—

Dimension Design



OD … Outside Diameter
ID … Inside Diameter
WT … Wall Thickness
L … Length
If minimum wall thickness is required variations are allowed on the plus side only

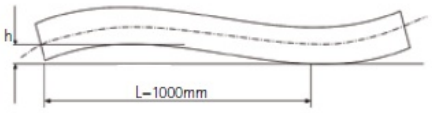
Butt Welding Ends



ANSI / ASME B16.25-2007
Fig. 4 Weld Bevel Details for GTAW Root Pass [WT > 3mm (0,12 in.) to 10mm (0,38 in.), Inclusive]

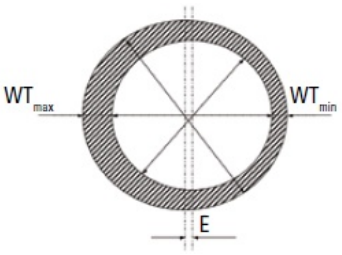
GENERAL NOTES:
a) This detail applies for gas tungsten arc welding (GTAW) of the root pass where nominal thickness is over 3mm
b) Linear dimensions are in millimeters with inch values in parentheses.

Straightness Requirement



tandard pipes and tubes are supplied straightened to the eye: for special applications the permissible deviation from the straight line may be agreed between purchaser and pipe manufacturer; the maximum permissible deviation from the straight line related to the length of measurement L is to be indicated, e.g. 1mm/1000mm.

Eccentricity



E is half of the difference between biggest and smallest wall thickness (WT) values in one cross section.

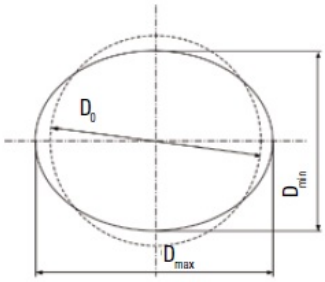
$$E(mm) = \frac{WT_{max} - WT_{min}}{2}$$

In terms of mm:

However, eccentricity is expressed as a percentage of the mean wall thickness of this cross section

$$E(\%)=\frac{WT_{max}-WT_{min}}{WT_{max}+WT_{min}}\cdot 100$$

Mean Diameter inside and outside



D0 is the arithmetic mean between the smallest and biggest tube diameter on any one pipes or tube circumference. If minimum wall thickness is required variations are allowed on the plus side only

Ovality

O is the difference between biggest and smallest diameter on any one tube circumference

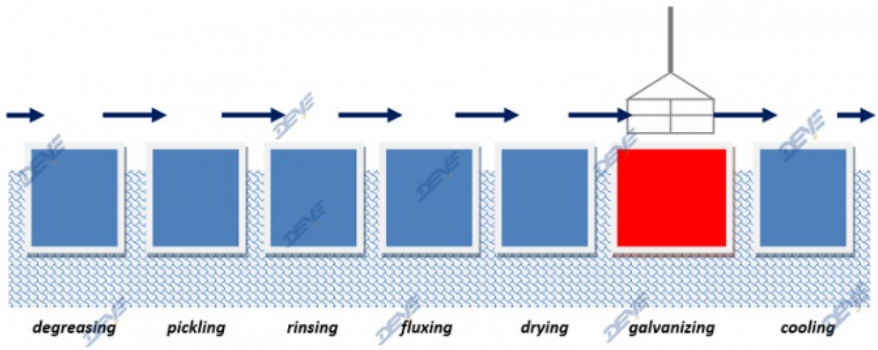
$$O(mm)=D_{max}-D_{min}$$

As a percentage of the mean diameter this is:

$$O(mm)=\frac{D_{max}-D_{min}}{D_{max}+D_{min}}\cdot 200$$

Ovality must not be confused with eccentricity.

Galvanzied PROCESS



FAQ: Question and Answers

Q: What is the different between seamless pipes and seamless Tubes?

A: Seamless steel pipes shall not be confused with seamless tubes. Indeed, there are a few important differences between pipes and tubes, which are not only semantic. In general, the word “pipe” applies to any tubular used to convey fluids, whereas the word “tube” applies to tubular sections (of various shapes, round, oval, squared) used for structural/mechanical applications, instrumentation systems, and the construction of pressure equipment like boilers, heat exchangers, and superheaters.

Q: What is the tolerance of the seamless pipes

A: Dimensions tolerance for API 5L /A106GR.B seamless pipe.

1. For outer diameters less than 2 3/8 in (60.3 mm), pipe body diameter tolerance +/-0.5 mm. Pipe end +/- 0.5 mm; Out of Roundness tolerance for pipe body is 0.9 mm (0.036 in), pipe end 0.6 mm (0.024 mm).
2. For OD equal or above 2 3/8 in (60.3) to 24 in (610 mm), (diameter tolerance) for pipe body is +/- 0.0075D,pipe end +/- 0.005D but max to +/-1.6 mm (0.063mm);
   Roundness tolerance for pipe body≤0.015D, pipe end≤0.01D.

(In case agreed with manufacturer and client, more strictly tolerances could be applied)

3. For wall thickness

Below than 4 mm (0 0157 in), tolerance +0.6 (0.024 mm), -0.5 mm (0.020 in);
For API 5L seamless steel pipe thickness in 4 mm to 10 mm (0.394 in), +0. 150t, -0.125t;
For API seamless pipe thickness 10 mm to 25mm (0.984 in), +/-0.125t;
Wall thickness≥25 mm, +3.7mm or +0.1t (if larger) and -3.0 mm (0.120 in) or -0.1t (if larger).
t for thickness,

4. For straightness, max for full length, tolerance maximum 0.15% of length.
5. Straightness, max deviation for pipe end, shall be≤0.3 mm /m.
6. Length +/- 200 mm for general, +/- 25.4 mm for special.

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