

Longitudinally welded

Steel pipes longitudinally welded

Pipes are manufactured in line with the following standards: PN-79/H-74244, DIN 17120 and DIN 1626.

Outer diameter of longitudinally welded steel pipes manufactured by Izostal S.A. ranges from 813 mm to 2020 mm; the pipes are delivered with straight or bevelled end faces. Pipes of diameter up to 1016 mm feature a single longitudinal weld, of diameter up to 1620 mm feature two longitudinal welds and other pipes feature three longitudinal welds. Tightness test is not carried out for pipes of dimensions indicated in the following chart.

Framework delivery program for pipes conforming to DIN 17120 standard

Steel grade Outer diameter mm	Steel grade		
	Rst 37-3, St 37-3	St 44-2, St 44-3	St 52-3
	Wall thickness mm		
813	8,6 – 16,0	8,0 – 14,2	8,0 – 12,5
914			
1016			
1220			8,0 – 14,2
1420	8,8 – 17,5	8,0 – 16,0	
1620	10,0 – 17,5	10,0 – 16,0	10,0 – 14,2
1820			10,0 – 16,0
2020			10,0 – 17,5

Framework delivery program for pipes conforming to PN-79/H-74244 standard

Outer diameter (mm)	Strength class	

	G235			G295			G355		
	Type of pipe								
	B1, B2	B3	B3M	B1, B2	B3	B3M	B1, B2	B3	B3M
	Wall thickness mm								
813	8,6 – 16,0			8,0 – 14,2			8,0 – 12,5		
914									
1016									
1220							8,0 – 14,2		
1420	8,8 – 17,5								
1620	10,0 – 17,5			10,0 – 16,0			10,0 – 14,2		
1820	10,0 – 17,5			10,0 – 16,0			10,0 – 16,0		
2020				10,0 – 17,0					

Carrier pipes of other dimensions are hydraulically tested for tightness at the pressure up to 4.9 MPa. Non-destructive weld tests for pipes of diameter within the range from 813 mm to 1620 mm, if required, are carried out continuously, using radiological method only.

Upon arranging technical specification we deliver pipes of diameter and wall thickness values outside of the range specified in the abovementioned chart, provided the desired diameter value is within the outer diameter range of 508 mm and 2020 mm. Minimum length: 6 metres; maximum length: 8,2 metres. The pipes are made of killed, unalloyed and low-alloy standard and quality steel. The pipes are delivered in black, without the protective coating, externally coated with extrusion moulded three layer polyethylene coating (up to the diameter of 1420 mm), internally coated with cement coating, in line with the customer's requirements.

Delivery of pipes with other anticorrosive protection requires earlier arrangements.