

**Keevitamiseks ja keermestamiseks
sobivad süsinikterasest torud.
Tehnilised tarnetingimused
KONSOLIDEERITUD TEKST**

Non-alloy steel tubes suitable for welding and
threading - Technical delivery conditions
CONSOLIDATED TEXT

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 10255:2004+A1:2007 sisaldab Euroopa standardi EN 10255:2004+A1:2007 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 31.05.2007 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 10255:2004+A1:2007 consists of the English text of the European standard EN 10255:2004+A1:2007.</p> <p>This document is endorsed on 31.05.2007 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p>Käsitlusala:</p> <p>This document specifies the requirements for circular non-alloy steel tubes suitable for welding and threading and provides a number of options for the finish of tube ends and coatings. This document covers tubes of specified outside diameter 10,2 mm to 165,1 mm (thread size 1/8 to 6) in two series, medium and heavy, and three types of designated thicknesses.</p>	<p>Scope:</p> <p>This document specifies the requirements for circular non-alloy steel tubes suitable for welding and threading and provides a number of options for the finish of tube ends and coatings. This document covers tubes of specified outside diameter 10,2 mm to 165,1 mm (thread size 1/8 to 6) in two series, medium and heavy, and three types of designated thicknesses.</p>
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Võtmesõnad: methods of manufacture, order indications, pipes, specification (approval), specifications, steel components, steel tubes, steels, tapping : threads, testing, thread-cutting, threads, tubes, unalloyed, unalloyed steels, welded, welding

English Version

**Non-Alloy steel tubes suitable for welding and threading -
Technical delivery conditions**

Tubes en acier non-allié filetables et soudables -
Conditions techniques de livraison

Rohre aus unlegiertem Stahl mit Eignung zum Schweißen
und Gewindeschneiden - Technische Lieferbedingungen

This European Standard was approved by CEN on 27 May 2004 and includes Amendment 1 approved by CEN on 5 March 2007.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
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Foreword

This document (EN 10255:2004+A1:2007) has been prepared by Technical Committee ECISS/TC 29 “Steel tubes and fittings for steel tubes”, the secretariat of which is held by UNI.

This document shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2007 and conflicting national standards shall be withdrawn at the latest by October 2007.

This document includes Amendment 1, approved by CEN on 2007-03-05.

This document supersedes EN 10255:2004.

The start and finish of text introduced or altered by amendment is indicated in the text by tags **A1** and **A1**.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive 89/106/EEC.

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this document.

This European Standard has been derived, with modifications, from ISO 65 “Carbon steel tube suitable for screwing in accordance with ISO 7/1”.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

1 Scope

This document specifies the requirements for circular non-alloy steel tubes suitable for welding and threading and provides a number of options for the finish of tube ends and coatings. This document covers tubes of specified outside diameter 10,2 mm to 165,1 mm (thread size 1/8 to 6) in two series, medium and heavy, and three types of designated thicknesses.

NOTE Tubes manufactured according to this document can be used for the conveyance of fluids as well as for other applications.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

The requirements of this European Standard rule when they differ from those in the standards and documents referred to below:

EN 10002-1, *Metallic materials - Tensile testing - Part 1: Method of test at ambient temperature*

EN 10020, *Definition and classification of grades of steel*

EN 10021, *General technical delivery for steel products*

EN 10027-1, *Designation systems for steel - Part 1: Steel names*

EN 10027-2, *Designation systems for steels - Part 2: Numerical system*

EN 10204, *Metallic products - Types of inspection documents*

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EN 10240, *Internal and/or external protective coatings for steel tubes - Specification for hot dip galvanized coatings applied in automatic plants*

EN 10241, *Steel threaded pipe fittings*

EN 10242, *Threaded pipe fittings in malleable cast iron*

EN 10246-1, *Non destructive testing of steel tubes - Part 1: Automatic electromagnetic testing of seamless and welded (except submerged arc welded) ferromagnetic steel tubes for verification of hydraulic leak-tightness*

EN 10226-1 *Pipe threads where pressure-tight joints are made on the threads - Part 1: Taper external threads and parallel internal threads - Dimensions, tolerances and designation*

EN 10226-2, *Pipe threads where pressure-tight joints are made on the threads - Part 2: Taper external threads and taper internal threads - Dimensions, tolerances and designation*

EN 10266:2003, *Steel tubes, fittings and structural hollow sections - Symbols and definitions of terms for use in product standards*

EN ISO 1461, *Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods (ISO 1461:1999)*

EN ISO 2566-1, *Steel - Conversion of elongation values - Part 1: Carbon and low alloy steels (ISO 2566-1:1984)*

EN ISO 8491, *Metallic materials - Tube (in full section) - Bend test (ISO 8491:1998)*

EN ISO 8492, *Metallic materials - Tube - Flattening test (ISO 8492:1998)*

EN ISO 9001, *Quality management systems - Requirements (ISO 9001:2000)*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 10020:2000, EN 10021:1993, EN 10266:2003 and the following apply.

3.1

Series and Types

designation used in conjunction with the diameter to define the thickness and the mass per unit length of the tube

3.2

Bare tube

tube whose surface is as manufactured without subsequent coating

4 Classification and designation

The steel specified in this document is classified as a non-alloy quality steel in accordance with EN 10020.

The steel name S195 T has been established in accordance with EN 10027-1.

The steel number 1.0026... has been established in accordance with EN 10027-2.

5 Information to be obtained from the purchaser

5.1 Mandatory information

The following information shall be obtained from the purchaser at the time of enquiry and order:

- a) Quantity (mass or total length or number of tubes);
- b) Seamless or Welded tube manufacturing process (S or W);
- c) The term "tube";
- d) The number of this European Standard (EN 10255);
- e) Specified outside diameter (D) in millimetres or thread size (R) (see Table 2 or Annex B);
- f) Wall thickness (T) in millimetres or series (M or H) (see Table 2) or type (L or L1 or L2) (see Annex B).

5.2 Options

A number of options are specified in this document and these are listed below. In the event that the purchaser does not indicate a wish to implement any of these options at the time of enquiry and order, the tubes shall be supplied in accordance with the basic specification (see 5.1).

- 1) Threaded ends (see 7.2);
- 2) Tube with socket (see 7.2);