

# Galvanized and Black Pipes for Water, Gas and Air

Conforming to IS-1239 (Part-1) 2004/BS-1387/IS-1161 (Structural Tubes)

N.B.	Series	Mean Outside Diameter (MM)	Wall Thickness		Nominal Weight Galvanized & Black Tubs				Sockets	
					Plain End		Screwed & Socketed			
			MM	SWG	Kg/m	Mtrs/Tone	Kg/m	Mtrs/Tone	OD in MM	Length MM
15	Light	21.20	2.00	14	0.95	1056	0.95	1046	27.00	37.00
	Medium	21.40	2.60	12	1.21	826	1.22	820		
	Heavy	21.40	3.20	10	1.44	694	1.45	690		
20	Light	26.65	2.30	13	1.38	725	1.39	719	32.50	39.00
	Medium	26.90	2.60	12	1.56	641	1.57	637		
	Heavy	26.90	3.20	10	1.87	535	1.88	532		
25	Light	33.50	2.60	12	1.98	505	2.00	500	39.50	46.00
	Medium	33.75	3.20	10	2.41	415	2.43	412		
	Heavy	33.75	4.00	8	2.93	341	2.95	339		
32	Light	42.20	2.60	12	2.54	394	2.57	389	49.00	51.00
	Medium	42.45	3.20	10	3.10	323	3.13	319		
	Heavy	42.45	4.00	8	3.79	264	3.82	262		
40	Light	48.10	2.90	11	3.23	310	3.27	306	56.00	51.00
	Medium	48.35	3.20	10	3.56	281	3.60	278		
	Heavy	48.35	4.00	8	4.37	229	4.41	227		
50	Light	59.90	2.90	11	4.08	245	4.15	241	68.00	60.00
	Medium	60.25	3.60	9	5.03	199	5.10	196		
	Heavy	60.25	4.50	7	6.19	162	6.26	160		
65	Light	75.60	3.20	10	5.71	175	5.83	172	84.00	69.00
	Medium	75.95	3.60	9	6.42	156	6.54	153		
	Heavy	75.95	4.50	7	7.93	126	8.05	124		
80	Light	88.30	3.20	10	6.72	149	6.89	145	98.00	75.00
	Medium	88.75	4.00	8	8.36	120	8.53	117		
	Heavy	88.75	4.80	6	9.90	101	10.10	99		
100	Light	113.45	3.60	9	9.75	103	10.00	100	124.00	87.00
	Medium	114.05	4.50	7	12.20	82	12.50	80		
	Heavy	114.05	5.40	5	14.50	69	14.80	68		
125	Medium	139.65	4.80	6	15.90	63	16.40	61	151.00	96.00
	Heavy	139.65	5.40	5	17.90	56	18.40	54		
150	Medium	165.20	4.80	6	18.90	53	19.50	51	178.00	96.00
	Heavy	165.20	5.40	5	21.30	47	21.90	46		

## Tolerances

### a) Thickness

1. Galvanized ±5%
  2. Black ±8%
- \* Better than ISI

### b) Weight

1. Single Tube (Light Series)+ 10%-8%
2. Single Tube(Med.&Heavy Tube)±10%
3. For quantities per load of 10 tonnes minimum(Light Series) + 7.5% -5%
4. For quantities per load of 10 tonnes minimum(Medium & Heavy) ± 7.5%

### c) Length

1. Normal-6m ±0.02/0.03 Meter
  2. Random length- 4 to 7 Meters or as specified by the customer
1. Each Pipe is tested for leak proof test
  2. End Condition:
    - a) Screwed & Socketed
    - b) Screwed without Socket
    - c) Plain End

