

Tubes

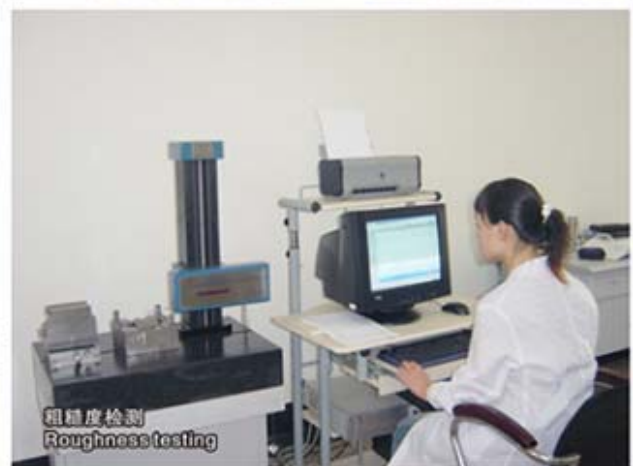
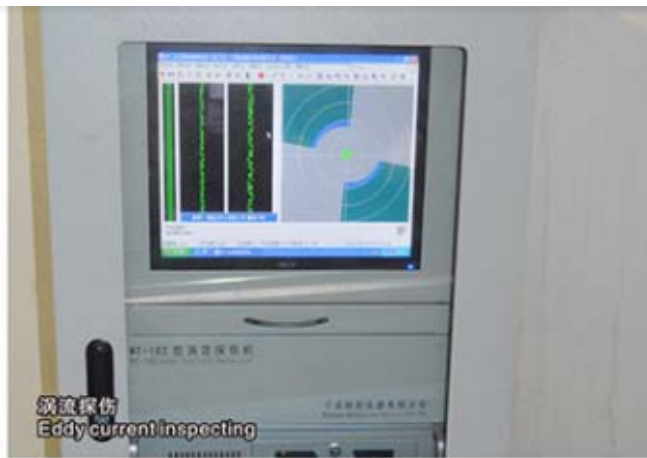


Hispeed Group Inc.

Main facilities used in production



Main facilities used in inspection and test



标准检验项目 Item of test

检验项目	标准	中国标准 China standards			美国标准 USA standards		
		HG20537.2	GB151-C	GB12771	ASTM A249	ASTM A270	ASTM A789
硬度检验 Hardness Test		▲			▲	△	▲
拉伸强度检验 Tensile Strength Test		▲	▲	▲	▲	△	▲
压扁检验 Flattening Test		▲	▲	▲	▲		
反向展平检验 Reverse Flattening Test		▲	▲	▲		▲	
反向弯曲检验 Reverse Bending Test			△		▲		▲
扩口检验 Flaring Test		▲					
翻边检验 Flange Test					▲		▲
水下气密性检验 Water Tightness Test		▲	▲	▲	▲	▲	▲
无损检测 Nondestructive Test		▲	▲		△	△	△
晶间腐蚀检验 Intergranular Corrosion Test		△			△		△

附注：▲ 必做项目 Required item △ 选做项目 Selective item



PIPES

Seamless Stainless Steel Pipe Supplying Range – ASME B36.10/B36.19

Materials	Size*	Wall Thickness**	Seamless	Welded
Stainless Steel 304,304L, 309S, 310S, 310H, 316/L, 316H, 316Ti, 317/L, 347/H, 904L, S31254(254SMO)	1/2"-24"	SCH10S-XXS	√	
	1/2"-104"	SCH5S-80S/XS		√
Duplex&Super Duplex S31803, S32205, S32750, S32760, etc.	1/2"-16"	SCH10S-XS	√	
	1/2"-104"	SCH5S-80S/XS		√
Nickel Alloy-Alloy20,28,31, Monel400, K500, Inconel 600, 601, 625, Incoloy800, 800H, 800HT, 825, Hastelloy C22,C276,B2 etc.	1/2"-16"	SCH10S-120	√	
	1/2"-104"	SCH5S-80S/XS		√
Other materials	Please make a specific enquiry to us, our team will make the best to you asap.			

Note:

*Dimension range is not available for duplex and some special grade(For example,super duplex S32750 ≤16"). Please make a specific enquiry.

** Wall thickness range is not available for duplex and some special grade, please make a specific enquiry.

Our Strength:

- ★ Full grades of austenitic stainless steel,duplex stainless steel and nickel based alloy.
- ★ Small order quantity available from 200kgs.
- ★ Large bore seamless stainless steel pipe, up to 36".
- ★ Thin wall thickness seamless stainless steel pipe, like o.d.273×w.t.4mm
- ★ Double quality control system - first from our approved factory,second from our owned QA
- ★ Fast delivery of 20-40days for general grades
- ★ Flexible and professional service and operations

Complete Range of Dimensions for Seamless Stainless Steel Pipes

OD\ WT (mm)	0.5	0.8	1.0	1.5	2.0	2.5	3.0	4	5	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	44	48	52	56	60	64	68	72	80	90				
6																																									
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457																																									
508																																									
559																																									
610																																									
660																																									
711																																									
762																																									
813																																									
864																																									
914																																									

Comments:

For the blue parts, hot rolled may required.



尺寸公差表 (Dimension tolerance table)

标准 standard	外径 (mm) outside diameter		厚度 (mm) Thickness	长度 (mm) Length
ASTM A312	≤48.26	+0.40 -0.80	+未特别规定 (unspecified) -12.50%	指定长度 Definite cut length +6.40 -0
	>48.26~114.30	+0.80 -0.80		
	>114.30~219.08	+1.60 -0.80		
	>219.08~457.20	+2.40 -0.80		
	>457~660	+3.20/ -0.80		
	>660~864	+4.00/ -0.80		
	>864~1219	+4.48/ -0.80		
HG 20537.3/4	Dn≤150 150<DN<300 Dn≥300	±0.75%,min±0.3mm ±1% ±1%	± 10%S,min ± 0.3mm	+6.00 -0
GB/T 12771	<13.00 13.00~40.00 ≥40.00	±0.20 ±0.30 ±0.80%	≤4.00 +0.50 -0.60 >4.00 ± 10%	+20.00 -0
EN 10217-7	D1±1.50% with ±0.75mm(min) D2±1.00% with ±0.50mm(min) D3±1.75% with ±0.30mm(min) D4±0.50% with ±0.10mm(min) EN ISO 1127		T1±15.00% with ±0.60mm(min) T2±12.5% with ±0.40mm(min) T3±10.00% with ±0.20mm(min) T4±7.50% with ±0.15mm(min) T5±5.00% with ±0.10mm(min) EN ISO 1127	≤6000 +5.00 -0 6000~12000 +10.00 -0

ASTM A312/ASTM A778规格尺寸表 (Specification)

称呼外径 Nominal Diameter		外径 Outside Diameter	厚度 Nominal Wall Thickness		
			SCH 5S	SCH 10S	SCH 40S
N.B	NPS	mm	mm	mm	mm
8	1/4"	13.72			2.24
10	3/8"	17.15			2.31
15	1/2"	21.34	1.65	2.11	2.77
20	3/4"	26.67	1.65	2.11	2.87
25	1"	33.4	1.65	2.77	3.38
32	1-1/4"	42.16	1.65	2.77	3.56
40	1-1/2"	48.26	1.65	2.77	3.68
50	2"	60.33	1.65	2.77	3.91
65	2-1/2"	73.03	2.11	3.05	5.16
80	3"	88.90	2.11	3.05	5.49
90	3-1/2"	101.60	2.11	3.05	5.74
100	4"	114.30	2.11	3.05	6.05
125	5"	141.30	2.77	3.4	6.55
150	6"	168.28	2.77	3.4	7.11
200	8"	219.08	2.77	3.76	8.18
250	10"	273.05	3.40	4.19	9.27
300	12"	323.85	3.96	4.57	9.52

ASTM A269尺寸公差表 (Dimension tolerance table)

项目 Item 规格 Specification	外径 outside diameter	外径公差 Thickness of outer diameter	厚度公差 Tolerance of Thickness	长度 Length
ASTM A269	<38.1mm	±0.13mm	OD<12.7 ±15%	OD<38.1 +3.2 -0
	≥38.1~88.9mm	±0.25mm		
	≥88.9~139.7mm	±0.38mm		
	≥139.7~203.2mm	±0.76mm	OD≥12.7 ±10%	OD<38.1 +4.8 -0
	≥203.2~304.8mm	±1.01mm		
	≥304.8~355.6mm	±1.26mm		

GB12770尺寸公差表 (Dimension tolerance table)

类别 Category	外径 outside diameter	允许偏差 Allowable deviation		
		高级 (PC)	较高级 (PR)	普通级 (PA)
热处理状态 T	<13	±0.10	±0.20	±0.25
	≥13~<25	±0.13	±0.20	±0.40
	≥25~<40	±0.25	±0.30	±0.60
	≥40~<63	±0.30	±0.50	±0.80
	≥63~<90	±0.51	±0.60	±1.0
	≥90~<159	±0.64	±0.80	±1.0
	≥159~<300	±0.7%D	±0.8%D	±1.0%D
	≥300~<500	±0.8%D	±1.0%D	±1.25%D
	≥500	按协议	按协议	按协议
冷拔 (轧) 状态 W 磨 (抛) 光状态 SP	<25	±0.10	±0.12	±0.15
	≥25~<40	±0.13	±0.15	±0.18
	≥40~<50	±0.15	±0.18	±0.20
	≥50~<60	±0.18	±0.20	±0.23
	≥60~<70	±0.25	±0.28	±0.30
	≥70~<80	±0.25	±0.28	±0.30
	≥80~<90	±0.25	±0.28	±0.30
	≥90~<100	±0.30	±0.35	±0.40
	≥100~<200	按协议	±0.4%D	±0.5%D
≥200	按协议	按协议	按协议	

GB12770壁厚公差要求 (Wall thickness tolerances)

类别 Category	壁厚 Wall thickness	壁厚公差 Wall thickness tolerance
冷轧钢板 (带) 或冷轧纵剪钢带 Cold-rolled steel plate (coil) cold rolled slitting strip	≤0.5mm	±0.05mm
	>0.5~1.0mm	±0.11mm
	>1.0~2.0mm	±0.17mm
	>2.0~3.0mm	±7%Smm
	≥3.0~4.0mm	±6%Smm
	>4.0~5.0mm	±5%Smm

JIS G3459规格表(Specification)

称呼外径 (Nomina Diameter)		外径 (Outside Diameter)	厚度 (Nominal Wall Thickness)			
			SCH 5S	SCH 10S	SCH 20S	SCH 40S
(A)	(B)	mm	mm	mm	mm	mm
8	1/4"	13.8	1.2	1.65	2.0	2.2
10	3/8"	17.3	1.2	1.65	2.0	2.3
15	1/2"	21.7	1.65	2.1	2.5	2.8
20	3/4"	27.2	1.65	2.1	2.5	2.9
25	1"	34.0	1.65	2.8	3.0	3.4
32	1-1/4"	42.7	1.65	2.8	3.0	3.6
40	1-1/2"	48.6	1.65	2.8	3.0	3.7
50	2"	60.5	1.65	2.8	3.5	3.9
65	2-1/2"	76.3	2.1	3.0	3.5	5.2
80	3"	89.1	2.1	3.0	4.0	5.5
90	3-1/2"	101.6	2.1	3.0	4.0	5.7
100	4"	114.3	2.1	3.0	4.0	6.0
125	5"	139.8	2.8	3.4	5.0	6.6
150	6"	165.2	2.8	3.4	5.0	7.1
200	8"	216.3	2.8	4.0	6.5	8.2
250	10"	267.4	3.4	4.0	6.5	9.3
300	12"	318.5	4.0	4.5	6.5	10.3

大口径配管用不锈钢管

Large diameter stainless steel pipe

ASTM A312/ASTM A778规格尺寸表(Specification)

称呼外径 (Nomina Diameter)		外径 (Outside Diameter)	厚度 (Nominal Wall Thickness)			
			SCH 5S	SCH 10S	SCH 20S	SCH 40S
(A)	(B)	mm	mm	mm	mm	mm
350	14"	355.6	3.96	4.78	7.92	11.13
400	16"	406.4	4.19	4.78	7.92	12.7
450	18"	457.2	4.19	4.78	7.92	14.27
500	20"	508.0	4.78	5.54	9.53	15.09
550	22"	558.8	4.78	5.54	9.53	15.09
600	24"	609.6	5.54	6.35	9.53	17.48
650	26"	660.4	5.54	7.92	12.7	17.48
700	28"	711.2	5.54	7.92	12.7	17.48
750	30"	762.0	6.35	7.92	12.7	17.48
800	32"	812.8		7.92	12.7	17.48
850	34"	863.6		7.92	12.7	17.48
900	36"	914.4		7.92	12.7	19.05
1000	40"	1016.0		9.53		



Hispeed Group Inc.

Address: Weifang City, Shandong Province, China

Tel/Whatsapp/Wechat: +86-18005365375

E-mail: sales@headsupplier.com

Web: www.headsupplier.com