

# Welded Steel Pipes

MS 863  
BS 1387 - 1985

CLASS	Nominal Size		Outside Diameter		Wall Thickness	Calculated Weight						Number Of Threads per inch	Socket		Test Pressure	
			Maximum	Minimum		Plain Ends			Threads and Coupling				Outer Diameter	Min. Length		
	mm	in	mm	mm	mm	kg/m	kg/ft	lb/ft	kg/m	kg/ft	lb/ft	mm			mm	Bar
	LIGHT (A)	15	1/2	21.4	21.0	2.0	0.947	0.291	0.642	0.956	0.956	0.291	14	27.8	38.1	50
20		3/4	26.9	26.4	2.3	1.38	0.421	0.928	1.39	0.424	0.935	14	34.1	41.3	50	725
25		1	33.8	33.2	2.6	1.98	0.604	1.33	2.00	0.61	1.34	11	42.1	47.6	50	725
32		1 1/4	42.5	41.9	2.6	2.54	0.774	1.71	2.57	0.78	1.73	11	51.6	54.0	50	725
40		1 1/2	48.4	47.8	2.9	3.23	0.985	2.17	3.27	1.00	2.20	11	57.9	57.2	50	725
50		2	60.2	59.6	2.9	4.08	1.24	2.73	4.15	1.26	2.78	11	70.6	63.5	50	725
65		2 1/2	76.0	75.2	3.2	5.71	1.74	3.83	5.83	1.78	3.92	11	87.3	69.9	50	725
80		3	88.7	87.9	3.2	6.72	2.05	4.52	6.89	2.10	4.63	11	101.6	76.2	50	725
MEDIUM (B)	100	4	113.9	113.0	3.6	9.75	2.97	6.55	10.00	3.05	6.72	11	128.6	88.9	50	725
	15	1/2	21.7	21.1	2.6	1.21	0.369	0.814	1.22	0.372	0.82	14	27.8	38.1	50	725
	20	3/4	27.2	26.6	2.6	1.56	0.475	1.05	1.57	0.479	1.06	14	34.1	41.3	50	725
	25	1	34.2	33.4	3.2	2.41	0.735	1.62	2.43	0.741	1.63	11	42.1	47.6	50	725
	32	1 1/4	42.9	42.1	3.2	3.1	0.945	2.08	3.13	0.954	2.10	11	51.6	54	50	725
	40	1 1/2	48.8	48	3.2	3.57	1.09	2.40	3.61	1.10	2.43	11	57.9	57.2	50	725
	50	2	60.8	59.8	3.6	5.03	1.53	3.37	5.10	1.55	3.42	11	70.6	63.5	50	725
	65	2 1/2	76.6	75.4	3.6	6.43	1.96	4.32	6.55	2.00	4.41	11	87.3	69.9	50	725
	80	3	89.5	88.1	4.0	8.37	2.55	5.62	8.54	2.60	5.73	11	101.6	76.2	50	725
	100	4	114.9	113.3	4.5	12.2	3.72	8.2	12.5	3.81	8.40	11	128.6	88.9	50	725
HEAVY (C)	125	5	140.6	138.7	5.0	16.6	5.06	11.2	17.1	5.21	11.5	11	155.6	95.3	50	725
	150	6	166.1	164.1	5.0	19.7	6.00	13.2	20.3	6.19	13.6	11	184.2	95.3	50	725
	15	1/2	21.7	21.1	3.2	1.44	0.439	0.968	1.45	0.442	0.974	14	27.8	38.1	50	725
	20	3/4	27.2	26.6	3.2	1.87	0.57	1.257	1.88	0.573	1.263	14	34.1	41.3	50	725
	25	1	34.2	33.4	4.0	2.94	0.896	1.98	2.96	0.902	1.99	11	42.1	47.6	50	725
	32	1 1/4	42.9	42.1	4.0	3.80	1.16	2.56	3.83	1.17	2.58	11	51.6	54	50	725
	40	1 1/2	48.8	48.0	4.0	4.38	1.34	2.95	4.42	1.35	2.98	11	57.9	57.2	50	725
	50	2	60.8	59.8	4.5	6.19	1.89	4.17	6.26	1.91	4.21	11	70.6	63.5	50	725
	65	2 1/2	76.6	75.4	4.5	7.93	2.42	5.34	8.05	2.45	5.40	11	87.3	69.9	50	725
	80	3	89.5	88.1	5.0	10.3	3.14	6.92	10.5	3.20	7.05	11	101.6	76.2	50	725
100	4	114.9	113.3	5.4	14.5	4.42	9.71	14.8	4.51	9.94	11	128.6	88.9	50	725	
125	5	140.6	138.7	5.4	17.9	5.46	12.0	18.4	5.61	12.4	11	155.6	95.3	50	725	
150	6	166.1	164.1	5.4	21.3	6.49	14.3	21.9	6.68	14.7	11	184.2	95.3	50	725	

Tolerance: Wall thickness: Light (A) - 8%  
Medium (B) and heavy (C) - 10%

Length: Plus 50mm or minus zero (Manufacturer Standard)

Mass: The mean consignment mass for quantities of 150mm and cover of one size shall not deviate by more than  $\pm 4\%$  from the mass of consignment calculated from the mass given in the above Table as appropriate. No single tube shall deviate by more than +10%, -8% from the mass given in the above Table as appropriate.

# Welded Steel Pipes For General Purposes

APM S 002

CLASS	Nominal Size		Outside Diameter				Wall Thickness		Calculated Weight Plain Ends		
			Maximum		Minimum						
	mm	in	mm	in	mm	in	mm	in	kg/m	kg/ft	lb/ft
LIGHT (A)	90	3 1/2	102.0	3.98	101.1	3.95	3.2	0.126	7.761	2.366	5.22
EXTRA LIGHT (AA)	15	1/2	21.4	0.84	21.0	0.83	1.6	0.063	0.773	0.236	0.520
	20	3/4	26.9	1.06	26.4	1.04	1.6	0.063	0.990	0.302	0.666
	25	1	33.8	1.33	33.2	1.31	1.9	0.075	1.48	0.451	0.994
	32	1 1/4	42.5	1.67	41.9	1.65	1.9	0.075	1.89	0.576	1.27
	40	1 1/2	48.4	1.90	47.8	1.88	1.9	0.075	2.16	0.658	1.45
	50	2	60.2	2.30	59.6	2.35	1.9	0.075	2.72	0.829	1.83
	65	2 1/2	76.0	2.99	75.2	2.96	1.9	0.075	3.45	1.05	2.31
	80	3	88.7	3.49	87.9	3.46	2.1	0.083	4.46	1.36	3.00
	90	3 1/2	102.0	3.98	101.1	3.95	2.1	0.083	5.15	1.57	3.46
	100	4	113.9	4.48	113.0	4.45	2.3	0.091	6.31	1.92	4.23
	125	5	140.6	5.53	138.7	5.46	4.0	0.157	13.4	4.08	8.99
(AAA)	150	6	166.1	6.54	164.1	6.46	4.0	0.157	15.9	4.85	10.7
	25	1	33.8	1.33	33.2	1.31	1.6	0.063	1.259	0.384	0.847
	32	1 1/4	42.5	1.67	41.9	1.65	1.6	0.063	1.602	0.488	1.076
	40	1 1/2	48.4	1.90	47.8	1.88	1.6	0.063	1.835	0.559	1.233
	50	2	60.2	2.30	59.6	2.35	1.6	0.063	2.300	0.701	1.546
	65	2 1/2	76.0	2.99	75.2	2.96	1.6	0.063	2.920	0.890	1.962
	80	3	88.7	3.49	87.9	3.46	1.6	0.063	3.421	1.043	2.300
	100	4	113.9	4.48	113.0	4.45	1.9	0.075	5.226	1.593	3.513
	125	5	140.6	5.53	138.7	5.46	3.0	0.118	10.11	3.082	6.796
150	6	166.1	6.54	164.1	6.46	3.0	0.118	11.99	3.655	8.059	

Thickness Tolerances: ± 10%

# Carbon Steel Pipes For Ordinary Piping

JIS G 3452 - SGP

Nominal Size		Outside Diameter			Wall Thickness	Calculated Weight Plain Ends		Test Pressure	
in	mm	mm	Max. (mm)	Min.(mm)	mm	kg/m	lb/ft	Kg/cm	PSI
1/2	15	21.7	22.2	21.2	2.8	1.31	0.880	25	360
3/4	20	27.2	27.7	26.7	2.8	1.68	1.13	25	360
1	25	34.0	34.5	33.5	3.2	2.43	1.63	25	360
1 1/4	32	42.7	43.2	42.2	3.5	3.38	2.27	25	360
1 1/2	40	48.6	49.1	48.1	3.5	3.89	2.61	25	360
2	50	60.5	61.1	59.9	3.8	5.31	3.57	25	360
2 1/2	65	76.3	77.1	75.5	4.2	7.47	5.02	25	360
3	80	89.1	90.0	88.2	4.2	8.79	5.91	25	360
3 1/2	90	101.6	102.6	100.6	4.2	10.1	6.79	25	360
4	100	114.3	115.4	113.2	4.5	12.2	8.20	25	360
5	125	139.8	141.2	138.4	4.5	15.0	10.1	25	360
6	150	165.2	166.8	163.6	5.0	19.8	13.3	25	360
7	175	190.7	192.3	189.1	5.3	24.2	16.3	25	360
8	200	216.3	218.0	214.6	5.8	30.1	20.2	25	360
10	250	267.4	269.5	265.3	6.6	42.4	28.5	25	360
12	300	318.5	321.0	316.0	6.9	53.0	35.6	25	360
14	350	355.6	358.4	352.8	7.9	67.7	45.5	25	360
16	400	406.4	409.7	403.1	7.9	77.6	52.2	25	360
18	450	457.2	460.9	453.5	7.9	87.5	58.8	25	360

Thickness Tolerances: -12.5%