



Highlight of ASTM Specification Stainless Steel Tubes and Pipes

Specification	Allowable Outside Diameter Variation in mm			Allowable Wall Thickness Variation		Exact Length Tolerances in mm		Testing
	Diameter	Over	Under	Over%	Under%	Over	Under	
Specification ASTM-270 Seamless & Welded Sanitary Tubes	25.4 38.1 50.8 63.5 76.2 101.6	.05 .05 .05 .05 .08 .08	.20 .20 .28 .28 .30 .38	+12.5 +12.5 +12.5 +12.5 +12.5 +12.5	-12.5 -12.5 -12.5 -12.5 -12.5 -12.5	3.2 3.2 3.2 3.2 3.2 3.2	0 0 0 0 0 0	Testing Reverse Flattening Test 100% Hydrostatic Test Extrnal polish on all tubs Refer to ASTMA-270
ASTMA-249 Welded Boiler Superheater, Heat Exchanger and Condenser Tubs	Under 25.4 25.4 - 38.1 incl. 38.1 - 50.8 excl. 50.8 - 63.5 excl. 63.5 - 76.2 excl. 76.2 - 101.6 incl.	0.1016 0.1524 0.2032 0.254 0.3048 0.381	0.1016 0.1524 0.2032 0.254 0.3048 0.381	+10 +10 +10 +10 +10 +10	-10 -10 -10 -10 -10 -10	3.175 3.175 3.175 3.76 4.76 4.76	0 0 0 0 0 0	Tension Test FLATTENING Test Flare Test *Reverse Bend Test Hardness Test 100% Hydrostatic Test Reverse Flattening Test Refer to ASTM-450 whenever applicable
ASTMA-312 Seamless & Welded pipes	13.7 - 48.3 incl. 48.3 - 114.3 incl. 114.3 - 220 incl.	0.4 0.79 1.59	0.79 0.79 0.79	Minimum Wall tubes 12.5% under nominal wall specification		6.4 6.4 6.4	0 0 0	Tension Test FLATTENING Test 100% Hydrostatic Test <small>(Normally Random lengths ordered)</small>
ASTMA-269 Seamless & Welded Tubes	Upto 12.7 12.7 - 38.1 excl. 38.1 - 88.9 excl. 88.9 - 139.7 excl. 139.7 - 203.2 excl.	0.13 0.13 0.25 0.38 0.76	0.13 0.13 0.25 0.38 0.76	+15 +10 +10 +10 +10	-15 -10 -10 -10 -10	3.2 3.2 4.8 4.8 4.8	0 0 0 0 0	Tension Test Flange Test (Welded only) Hardness Test Reverse Flattening Test (Welded only) 100% Hydrostatic Test Refer to ASTM-269
ASTMA-213 Seamless Boiler Superheater & Heat exchanger Tubes	Upto 25.4 25.4 - 38.1 incl. 38.1 - 50.8 incl. 50.8 - 63.5 incl. 63.5 - 73.2 incl. 73.2 - 101.6 incl.	0.1016 0.1524 0.2032 0.254 0.3048 0.381	0.1016 0.1524 0.2032 0.254 0.3048 0.381	+20 +20 +22 +22 +22 +22	-0 -0 -0 -0 -0 -0	3.175 3.175 3.176 3.76 4.76 4.76	0 0 0 0 0 0	Tension Test Flattening Test Hardness Test 100% Hydrostatic Refer to ASTM-450
ASTMA-268 Seamless & Welded Femtic stainless steel tubes	Upto 12.7 12.7 - 38.1 excl. 38.1 - 88.9 excl. 88.9 - 168.9 excl.	0.13 0.13 0.25 0.38	0.13 0.13 0.25 0.38	+15 +10 +10 +10	-15 -10 -10 -10	3.2 3.2 4.8 4.8	0 0 0 0	Tension Test Flange Test CERW only Hardness Test Reverse Flattering Test 100% Hydrostate Test
ASTMA-358 for welded big Diameter pipes	For all sizes	+ 0.5 %	0.5 %	NO LIMIT	-0.3 mm	Customer's Specification		--



Fittings

Stainless Steel Forged Flanges

Standard	ANSI	DIN
Grades	304, 304L, 316, 316L, 316Ti, 321	304, 304L, 316, 316L, 316Ti, 321
Size	1/2" TO 8"	
Type	WNrf, sorf, blrf, Threaded	Slipon, Weldneck, Blind
Dimension	ANSI B 16.5	DIN2576, DIN2633, DIN2527 etc.
Pressure Rating	150, 300, 600, 900, 1500, 2500 Class	PN10, PN16, PN40, PN64



Prime Tube Impex