

GOST 8732-78 SEAMLESS HOT-FINISHED STEEL TUBES SIZE RANGE

Tubes to this standard shall be delivered with diameters 25 to 820 mm, wall thickness 2.5 to 75 mm and length 4.0 to 12.5 meters (see Table 1).

At present tube manufacturers supply tubes with diameters 42 to 550 mm and wall thickness 3.0 to 75 mm.

Tube length is subject to agreement between the supplier and the customer; tube length can be random (4.0 to 12.5 m), specified (within random length) and multiple (within random length plus 5 mm tolerance per cut). For tubes with wall thickness 16 mm and over the specified and the multiple length is subject to agreement with regard to maximum billet weight and the tube making process and equipment.

Maximum deviations of the outside diameter and wall thickness shall be dependent on tube size range; they are calculated in millimeters and percent of the specified size (see Table 1).

Tolerances for specified and multiple tube lengths are given below:

- for total tube length below 6 m: +10 mm;
- for total tube length over 6m or outside tube diameter of 152 mm: +15 mm.

Tolerances for curvature for any tube part shall not be higher per meter length than the values given below:

- for wall thickness below 20 mm: 1.5 mm;
- for wall thickness 20 to 30 mm: 2.0 mm;
- for wall thickness over 30 mm: 4.0 mm.

Table 1 Size range and maximum size deviations for seamless hot-finished tubes of carbon and low alloy steel (mm)

Outside diameter, mm	Wall thickness, mm	Maximum deviations, percent			
		of outside diameter, accuracy		of wall thickness, accuracy	
		Ordinary	Improved	Ordinary	Improved
1	2	3	4	5	6
25; 28; 32; 38	2.5; 2.8; 3.0; 3.5; 4.0; 4.5; 5.0; 5.5; 6.0; 6.5; 7.0; 7.7; 8.0	±0.5 mm	±0.5 %		
42	3.0; 3.5; 4.0; 4.5; 5.0; 5.5; 6.0				
45	3.0-6.0; 6.5; 7.0				
50	3.0-7.0; 7.5; 8.0				

54	3.0-8.0; 8.5; 9.0; 9.5; 10.0; 11.0	±1.0 %	±0.8 %	для S ≤ 15.0 мм	
57	3.0-11.0; 12.0; 13.0				
60; 63.5	3.0-13.0; 14.0			+ 12.5 %	+ 12.5 %
68; 70	3.0-14.0; 15.0; 16.0			- 15.0 %	
73; 76;	3.0-16.0; 17.0; 18.0; 19.0				
83	3.5-19.0				
95; 102	3.5-19.0; 20.0; 22.0; 24.0			для S = 15.0 ÷ 30.0 мм	
108; 114;					
121	4.0-24.0; 25.0; 26.0; 28.0			+ 12.5 %	+ 10.0 %
					- 12.5 %
127	4.0-28.0; 30.0				
133	4.0-30.0; 32.0			для S ≤ 30.0 мм	
140; 146;					
152; 159	4.5-32.0; 34.0; 35.0; 36.0			+ 10.0 %	±10.0 %
				- 12.5 %	
168; 180;					
194	5.5-36.0; 38.0; 40.0; 42.0; 45.0				
203	6.0-45.0; 48.0; 50.0				
219	6.5-50.0				
245; 273	7.0-50.0	±1.25 %	±1.0 %	для S ≤ 15.0 мм	
299; 325;					+ 12.5 %
351	8.0-50.0; 56.0; 60.0; 63.0; 65.0; 70.0; 75.0			- 15.0 %	
				для S = 15.0 ÷ 30.0 мм	
377	9.0-75.0				±12.5 %
402; 426	10.0-75.0				
450; 465;				для S ≤ 30.0 мм	
480; 500;					+ 10.0 %
530; 550	10.0-75.0				- 12.5 %

TubeSolution

Tube size control shall ensure tube dimensions according to the requirement of this standard. Each tube length shall be checked for diameter and wall thickness accuracy.

Marking on tubes shall include reference to this and other applicable national standards.

Materials and properties of tubes to this standard are given in GOST 8731-74. Tubes to GOST 8732-78 are furnished to outside diameter, wall thickness and length. If required, steel grade and delivery conditions to GOST 8731-74 are indicated.