

ISO 3306-85 PLAIN END AS WELDED AND SIZED PRECISION STEEL TUBES

1. Chemical Composition

Grade	Mfg. Process	Chemical Composition (%)								
		C	Si	Mn	P	S	Ni	Cr	Mo	Others
R28	E	0.13Max	-	0.60Max	0.050Max	0.050Max	-	-	-	-
R33	E	0.16Max	-	0.70Max	0.050Max	0.050Max	-	-	-	-
R37	E	0.17Max	0.35Max	0.8Max	0.050Max	0.050Max	-	-	-	-
R44	E	0.21Max	0.35Max	1.2Max	0.050Max	0.050Max	-	-	-	-
R50	E	0.23Max	0.35Max	1.5Max	0.050Max	0.050Max	-	-	-	-

2. Mechanical Properties

Grade	Tensile Test MPa or N/mm ²		Remarks (Similar to JIS)
	Min Yield point	Tensile Strength	
R28	① -	300Min	(STKM11) (STAM290G)
	② -	270Min	
	③ 150	280Min	
R33	① -	330Min	(STKM12) (STAM340G)
	② -	320Min	
	③ 195	320Min	
R37	① -	400Min	(STKM12) (STAM340G) (STAM390G)
	② -	340Min	
	③ 215	360Min	
R44	① -	460Min	(STKM14)
	② -	400Min	
	③ 235	410Min	
R50	① -	520Min	(STKM19)
	② -	480Min	
	③ 285	490Min	

JIS			ASTM			BS			DIN			NF			ISO			Index Number
Standard Number	Grade	Type	Standard Number	Grade	Type	Standard Number	Grade	Type	Standard Number	Grade	Type	Standard Number	Grade	Type	Standard Number	Grade	Type	
G3445	STKM11A	C	A512	MT1010	C	1717	ERWC1	C	2391	St30Si	C				3304	R28	C	C017
			A513	MT1010	C					St30A1	C				3305	"	C	
									2393	St28	C				3306	"	C	
										RSt28	C							
									2394	St28	C							
										USt28	C							
										RSt28	C							
	STKM12A	C	A512	MT1015	C	1717	ERWC2	C	2391	St37-2					3304	R33	C	
			A513	MT1015	C	6323	HFS3	C		RSt37-2					3305	"	"	
	STKM12B	C	A512	MT1015	C				2394	St37-2					3306	"	"	
			A513	MT1015	C					Ust38-2								
			A519	MT1015	C					RSt-2								
	STKM12C	C				1717	CEWC2	C				A49-322	TU37b	C				
						"	CFSC3	C				A49-327	TU37b	C				
						6323	CFS3	C										
						"	CFS3A	C										
	STKM13A	C	A312	MT1020	C	1717	ERWC3	C	2391	St45	C	A49-324	TU37b	C	2937	TS4	C	
			A513	MT1020	C				2393	St44-2	C	A49-330	TU37b	C	3304	R37	"	
									2394	St44-2	C	A49-343	TU38b	C	3305	"	"	
	STKM13B	C	A513	MT1020	C										3306	"	"	
	STKM13C	C				1717	CEWC3	C										
						"	CFSC4	C										
						6323	CFS4	C										
	STKM14A	C	A513	MT1020	C	6323	HFS4	C							2937	TS9	C	
															3304	R42	"	

