

BS 1387-67 STEEL TUBES AND TUBULARS SUITABLE FOR SERCWING TO BS 21 PIPE TRHEADS

1. Scope

Specification for screwed and socketed steel tubes and tubulars and for plain end steel tubes suitable for welding or for screwing to BS 21 PIPE threads, applicable to tubes of nominal size DN 8 to DN 150 in light, medium and heavy thickness.

2. Chemical Composition

Grade	Mfg. Process	Chemical Composition (%)								
		C	Si	Mn	P	S	Ni	Cr	Mo	Others
-	S,W	0.20	-	1.2	0.045Max	0.045Max	-	-	-	-

3. Mechanical Properties

Grade	Tensile Test MPa or N/mm ²		Elongation (%)	Remarks (Similar to JIS)
	Min Yield point	Tensile Strength		
-	195 min	325-460	20 min	(SGP)

4. Dimensions, Mass and Dimensional Tolerance

Nominal diameter	(LIGHT) (BSL)					
	Tolerances on outside diameter OD (mm)		Tolerances on wall thickness		BPE	
					Weight (kg/m)	
DN	Standard	Tolerances	Tolerances-8%		Tolerances - 8%	
			Standard	Minimum	Standard	Minimum
15	21.2	±0.2	2.0	1.84	0.947	0.88
20	26.65	±0.25	2.3	2.12	1.38	1.27
25	33.5	±0.3	2.6	2.40	1.98	1.83
32	42.2	±0.3	2.6	2.40	2.54	2.34
40	48.1	±0.3	2.9	2.67	3.23	2.98
50	59.9	±0.3	2.9	2.67	4.08	3.76
65	75.6	±0.4	3.2	2.95	5.71	5.26
80	88.3	±0.4	3.2	2.95	6.72	6.19
100	113.45	±0.4	3.6	3.32	9.75	8.97

125		±0.4				
150		±0.4				

Nominal diameter	(MEDIUM) (BSM)					
	Tolerances on outside diameter OD (mm)		Tolerances on wall thickness		BPE	
					Weight (kg/m)	
DN	Standard	Tolerances	-10%		Tolerances -8% +10%	
			Standard	minimum	Standard	minimum
15	21.4	±0.3	2.6	2.34	1.21	1.12
20	26.9	±0.3	2.6	2.34	1.56	1.44
25	33.8	±0.4	3.2	2.88	2.41	2.22
32	42.5	±0.4	3.2	2.88	3.10	2.86
40	48.4	±0.4	3.2	2.88	3.57	3.29
50	60.3	±0.5	3.6	3.24	5.03	4.63
65	76.0	±0.6	3.6	3.24	6.43	5.92
80	88.8	±0.7	4.0	3.60	8.37	7.70
100	114.1	±0.8	4.5	4.05	12.2	11.23
125	139.65	±0.95	5.0	4.50	16.6	15.28
150	165.1	±1.0	5.0	4.50	19.7	18.13

Nominal diameter	(HEAVY) (BSH)					
	Tolerances on outside diameter OD (mm)		Tolerances on wall thickness		BPE	
					Weight (kg/m)	
DN	Standard	Tolerances	Tolerances -10%		Tolerances -8% +10%	
			Standard	minimum	Standard	minimum
15	21.4	±0.3	3.2	2.88	1.44	1.33
20	26.9	±0.3	3.2	2.88	1.87	1.73
25	33.8	±0.4	4.0	3.6	2.94	2.71
32	42.5	±0.4	4.0	3.6	3.8	3.50
40	48.4	±0.4	4.0	3.6	4.38	4.03

50	60.3	±0.5	4.5	4.05	6.19	5.7
65	76.0	±0.6	4.5	4.05	7.93	7.30
80	88.8	±0.7	5.0	4.5	10.3	9.48
100	114.1	±0.8	5.4	4.86	14.5	13.35
125	139.65	±0.95	5.4	4.86	17.9	16.47
150	165.1	±1.0	5.4	4.86	21.3	19.60