

GOST 3262-83 STEEL TUBES FOR WATER AND GAS SUPPLY SYSTEMS

Tubes to this standard shall be butt-welded, uncoated or galvanized with the nominal bore from 6 to 150 mm and wall thickness from 1.8 to 5.5 mm. Size range and dimensional tolerances are given in Table 1.

Table 1 Size range and dimensional tolerances

Nominal bore, mm	Outside diameter, mm	Wall thickness, mm			Limit tolerance for outside diameter	
		Light wall	Normal wall	Heavier wall	Normal accuracy	Improved accuracy
6	10.2	1.8	2.0	2.5	(+0.4) - (-0.5) mm	±0.4 mm
8	13.5	2.0	2.2	2.8		
10	17.0	2.0	2.2	2.8		
15	21.3	2.35; 2.5	2.8	3.2		
20	26.8	2.5	2.8	3.2		
25	33.5	2.8	3.2	4.0		
32	42.3	2.8	3.2	4.0		
40	48.0	3.0	3.5	4.0		
50	60.0	3.0	3.5	4.5	(+0.8) - (-1.0) %	±0.8 %
65	75.5	3.2	4.0	4.5		
80	88.5	3.6	4.0	4.5		
90	101.3	3.5	4.0	4.5		
100	114.0	4.0	4.5	5.0		
125	140.0	4.0	4.5	5.5		
150	165.0	4.0	4.5	5.5		

Note.

Limit deviation for mass is ±8%, with the positive size deviation for wall thickness being limited by mass tolerance.

On the buyer's request special lighter-wall, plain-end tubes shall be delivered; tube dimensions are given in Table 2.

Table 2 Dimensions of light-wall plain-end tubes, mm

Nominal bore	Outside diameter	Wall thickness
10	16	2.0
15	20	2.5
20	26	2.5
25	32	2.8
32	41	2.8
40	47	3.0
50	59	3.0
65	74	3.2

Random tube lengths shall be within 4 to 12 meters. A lot may have not more than 5 % of tubes with lengths from 1.5 to 4 meters; greater percentage is only permissible with the buyer's consent. Specified or multiple tube lengths shall be 4 to 8 meters. On agreement, tube length shall be 8 to 12 meters with 5mm allowance per cut and total length allowance +10 mm.

Tube curvature per meter length shall be under 2 mm for nominal bore equal or lower than 20 mm and under 1.5 mm for nominal bore over 20 mm.

Requirements to thread are given in Table 3.

Table 3 Tube thread parameters

Nominal bore, mm	Number of threads per inch	Thread length, mm	
		Long	Short
15	14	14	9.0
20	14	16	10.5
25	11	18	11.0
32	11	20	13.0
40	11	22	15.0
50	11	24	17.0
65	11	27	19.5
80	11	30	22.0
90	11	33	26.0
100	11	36	30.0
125	11	38	33.0
150	11	42	36.0

Technical requirements.

Tubes shall be produced of steel grades to GOST 380-88 and GOST 1050-88.

Tube may be plain-end and without couplings or plain-end with coupling. Coupling material shall be steel or cast iron.

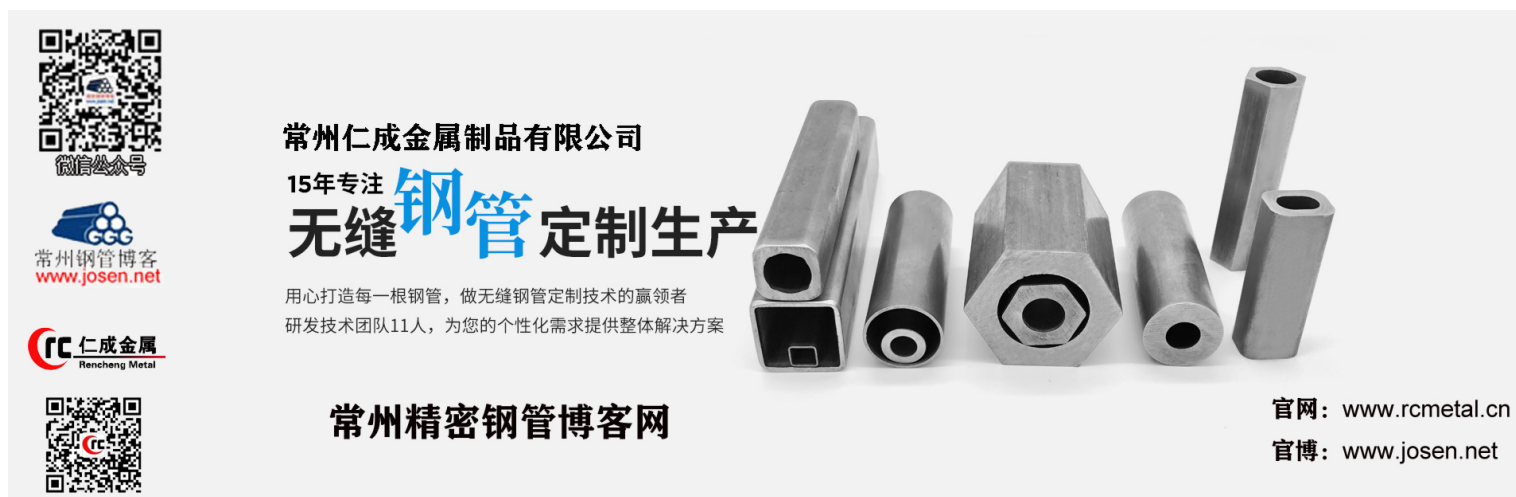
Weld bead of maximum 0.5 mm height is permissible on tube inside surface; on the buyer's request it can be lower.

Tube ends shall be cut square.

When galvanized, tubes shall have continuous inside and outside zinc coating with the thickness over 30 micrometers. Coating thickness for couplings shall be over 2 micrometers.

Normal and light wall tubes shall withstand hydraulic test pressure of 2.5 MPa; heavier wall tubes shall be tested by 3.2 MPa pressure. When required by the customer, tubes shall be tested by 5 MPa pressure.

On agreement a bend test shall be performed. Mechanical properties of tubes shall conform to the requirements of GOST 1050-88.



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