

Sl. No.	Parameters	Description as per Specification						
1	Specification	ASTM A53 B / A106 Gr.B / A333 Gr. 1 & 6 / API 5L Gr.B / X42 PSL-1 / OD 33.40 X WT 3.38 MM / MADE IN INDIA						
2	Size	OD 33.40 X WT 3.38 MM						
3	Application	ASTM A53 B - Standard Specification for seamless Pipe						
		A106 Gr.B - Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service						
		A333 Gr. 1 & 6 - Standard Specification for Seamless Pipe for Low-Temperature Service						
		API 5L Gr.B / X42 PSL-1 - Products for the Petroleum and Natural Gas Industry						
4	Process of Manufacture	Cold drawn seamless						
5	Specification Grade	A53 Gr.B	A106	A333 Gr. 1	A333 Gr. 6	API 5L Gr.B / X42 PSL-1	Lalbaba Offer	
6	Mechanical Test	Yst in Mpa	240 Min	240 Min	205 Min	240 Min	290 Min	310 - 350
		UTS in Mpa	415 Min	415 Min	380 Min	415 Min	415 Min	440 - 470
		E%	30% Min	30% Min	35% Min	30% Min	As per given formula in spec	38 - 47
		Hardness	Not Applicable	Not Applicable	Not Applicable	Not Applicable	Not Applicable	70 - 80
		Bend test	OD ≤ 60.30 mm	OD ≤ 60.30 mm	Not Applicable	Not Applicable	OD ≤ 60.30 mm	OK
		Flattening	OD ≥ 60.30mm	OD ≥ 60.30mm	Applicable	Applicable	OD ≥ 60.30mm	OK
		Flaring	Not Applicable	Not Applicable	Not Applicable	Not Applicable	Not Applicable	OK
Impact	Not Applicable	Not Applicable	Applicable as per Spec	Applicable as per Spec	Not Applicable	OK		
7	Chemical composition	%C	0.30 Max	0.30 Max	0.30 Max	0.30 Max	0.28 Max	0.17 - 0.22
		%Mn	0.29-1.06	0.29-1.06	0.40-1.06	0.40-1.06	1.30 Max	1.10 - 1.25
		%Si	0.10 Min	0.10 Min	-	-	-	0.10 - 0.35
		%p	0.035 Max	0.035 Max	0.025	0.025	0.030 Max	0.025 Max
		%S	0.035 Min	0.035 Min	0.025	0.025	0.030 Max	0.025 Max
		%Cr	0.40 Max	0.40 Max	-	-	-	0.40 Max
		%Cu	0.40 Max	0.40 Max	-	-	-	0.40 Max
		%Mo	0.15 Max	0.15 Max	-	-	-	0.15 Max
		%Ni	0.40 Max	0.40 Max	-	-	-	0.40 Max
		%V	0.08 Max	0.08 Max	-	-	-	0.08 Max
Others	-	-	-	-	-	Nb + V + Ti ≤ 0.15	Nb + V + Ti ≤ 0.15	
8	NDT	ECT	Applicable as per specification ASME E390				As per specification ASME E390 with minimum 0.8 mm drill hole	
		UT	Applicable as per specification ASME E213				As per specification ASME E213 with minimum 0.3 mm notch depth	
9	Hydrostatic Test	2500 PSI pressure minimum 5Sec holding time	2500 PSI pressure minimum 5Sec holding time	1000 PSI pressure minimum 5Sec holding time	1000 PSI pressure minimum 5Sec holding time	2500 PSI pressure minimum 5Sec holding time	2800 PSI 5 Sec holding time	
10	Dimension Tolerance (mm)	OD	10.30 to 48.30 ±0.40 Over OD 48.30 to 114.30 ±0.80	10.30 to 48.30 ±0.40 Over OD 48.30 to 114.30 ±0.80	10.30 to 48.30 -0.40/+0.80 Over OD 48.30 to 114.30 ±0.8	10.30 to 48.30 -0.40/+0.80 Over OD 48.30 to 114.30 ±0.8	< 60.3 : -0.80/+0.40 ≥ 60.30 to 168.30 : ±0.0075D	OD +/-0.20 MM
		WT/ID	OD 10.30 to 73 +20%,-12.5%. OD 88.90 to 450 +22.5%,-12.5%	OD 10.30 to 73 +20%,-12.5%. OD 88.90 to 450 +22.5%,-12.5%	OD 10.30 to 73 +20%,-12.5%. OD 88.90 to 450 +22.5%,-12.5%	OD 10.30 to 73 +20%,-12.5%. OD 88.90 to 450 +22.5%,-12.5%	≤ 4.0 : -0.50/+0.60 > 4.0 : +0.150T-0.125T	WT +/-0.30 MM
11	Heat Treatments Condition	Heat treated Above 650°C	Heat treated Above 650°C	Normalized	Normalized	Normalized	Normalized above 870°C	
12	Surface condition	-	-	-	-	-	Scale & defect free black surface	
13	End Condition	Plain end / Bevel end					OK	
14	Straightness	Reasonably staright	Reasonably staright	Reasonably staright	Reasonably staright	Over the entire pipe length ≤ 0.2 % of the pipe length 1.5 mtr portion at each pipe end ≤ 3.2 mm	0.8 : 1000 MM	
15	Ovality	-	-	-	-	-	0.3 mm Max	
16	Eccentricity	-	-	-	-	-	5% Max	
17	Stencil Marking	LALBABA/LOGO /ASTM A53 B/A106 Gr.B / A333 Gr. 1 & 6 / API 5L Gr.B / X42 PSL-1/OD 114.00 X WT 6.20 MM / MADE IN INDIA						
18	Coating	Bare/Rust preventive coating/Black Varnish Clear Varnish					Clear Varnish	

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