

Sl. No.	Parameters		Description as per Specification				
1	Specification		ASTM A312 / A213 TP304 / TP304L / DIN 17456 / EN 10216-5, Gr. X5CrNi18-10 // SN 1.4301				
2	Size		OD 12.70 X WT 1.24MM				
3	Application		ASTM A312 TP 304 : Seamless Heavily Cold Worked Austenitic Stainless Steel Pipes				
			ASTM A213 TP304 / TP304L : Specification for Seamless Ferritic and Austenitic Alloy-Steel Boiler, Superheater, and Heat-Exchanger Tubes				
			DIN 17456, Gr. X5CrNi18-10 – General purpose seamless circular stainless steel tube.				
			EN 10216-5, Gr. X5CrNi18-10 / SN 1.4301 – Seamless steel tubes for pressure purpose.				
4	Process of Manufacture		Cold drawn seamless				
5	Specification Grade		ASTM A312 TP 304 / TP 304L	ASTM A213, TP304 / TP 304L	DIN 17456, Gr. X5CrNi18-10	EN 10216-5, Gr. X5CrNi18-10 // SN 1.4301	Lalbaba Offer
6	Mechanical Test	Yst in Mpa	205 Min / 170 Min	205 Min / 170 Min	195 Min	195 Min	325-375
		UTS in Mpa	515 Min / 485 Min	515 Min / 485 Min	500-700	500-700	585-650
		E%	35% Min	35% Min	40 min	40 min	45-55
		Hardness	Not Applicable	90 HRB Max	Not Applicable	Not Applicable	75-80
		Bend test	Applicable	Applicable	Not Applicable	Not Applicable	OK
		Flattening	Applicable	Applicable	Applicable	Applicable	OK
		Flaring	Not Applicable	Not Applicable	Applicable	Applicable	OK
		Impact	Not Applicable	Not Applicable	100J at RT	100J at RT	OK
7	Chemical Composition	%C	0.08 max / 0.035 Max	0.08 max / 0.035 Max	0.07 Max	0.07 Max	0.035 max
		%Mn	2.0 max	2.0 max	2.0 Max	2.0 Max	2.0 max
		%Si	1.0 max	1.0 max	1.0 Max	1.0 Max	1.0 max
		%P	0.045 Max	0.045 Max	0.040 Max	0.040 Max	0.035 Max
		%S	0.035 Max	0.035 Max	0.015 Max	0.015 Max	0.025 Max
		%Cr	18.0-20.0	18.0-20.0	17-19.50	17-19.50	18.0-19.0
		%Cu	-	-	-	-	-
		%Mo	-	-	-	-	-
		%Ni	8-11	8-11	8.0-10.5	8.0-10.5	8-8.50
		%V	-	-	-	-	-
		Others	-	-	N-0.11 Max	N-0.11 Max	-
8	NDT	ECT	ASTM E309	ASTM E309	EN10246-2	EN10246-2	As per specification with minimum 0.8 mm drill hole
		UT	ASTM E213	ASTM E213	EN10246-6	EN10246-6	As per specification with minimum 0.3 mm notch depth
9	Hydrostatic Test		2500 PSI pressure minimum 5Sec holding time	1000 PSI pressure minimum 5Sec holding time	-	-	2500 PSI pressure minimum 5Sec holding time
10	Dimension Tolerance (mm)	OD	+/- 0.40	+/- 0.40	+/-1.0% or +/-0.5 whichever is greater	+/-1.0% or +/-0.5 whichever is greater	OD +/-0.20 MM
		WT / ID	-12.5%/+20%	-12.5%/+20%	+/-12.50% or +/-0.4 whichever is greater	+/-12.50% or +/-0.4 whichever is greater	+/-5.0%
11	Heat Treatments Condition		Above 1040°C & quench in water	Above 1040°C & quench in water	Above 1040°C & quench in water	Above 1040°C & quench in water	Above 1040°C & quench in water
12	Surface Condition		Free of scale and contaminating exogenous iron particles by Pickling, blasting. Surface finishing is not mandatory when the pipe is bright annealed.				Pickling & Passivated surface
13	End Condition		Plain end	Plain end	Plain end	Plain end	Plain end
14	Straightness		Reasonably staright	Reasonably staright	Reasonably staright	Reasonably staright	0.8 : 1000 MM
15	Ovality		-	-	-	-	0.3 mm Max
16	Eccentricity		-	-	-	-	5% Max
17	Stencil Marking		LALBABA / ASTM A312 / A213 TP304 / TP304L / DIN 17456 / EN 10216-5, Gr. X5CrNi18-10 / SN 1.4301/OD 12.70 X WT 1.24 MM / MADE IN INDIA				
18	Coating		Passivated			-	Passivated

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