

Sl. No.	Parameters		Description as per Specification			
1	<b>Specification</b>		BS 4019 / JIS G 3465 / A519 Gr. SAE1541			
2	<b>Size</b>		OD 57.28 X WT 5.69 MM			
3	<b>Application</b>		BS 4019- Wireline diamond core drilling equipment			
			JIS G 3465- Standard specification of seamless Pipe for drilling equipment.			
			A519 Gr. SAE1541- Standard specification of seamless pipe for mechanical tubing.			
4	<b>Process of Manufacture</b>		Cold drawn seamless			
5	<b>Specification Grade</b>		<b>BS 4019</b>	<b>JIS G 3465</b>	<b>A519 Gr. SAE1541</b>	<b>Lalbaba Offer</b>
6	<b>Mechanical Test</b>	<b>Yst in Mpa</b>	As per customer requirement	As per customer requirement	As per customer requirement	500-550
		<b>UTS in Mpa</b>	As per customer requirement	As per customer requirement	As per customer requirement	600-650
		<b>E%</b>	As per customer requirement	As per customer requirement	As per customer requirement	10% min
		<b>Hardness</b>	As Observed	As Observed	As Observed	90-100 HRB
		<b>Bend test</b>	Not Applicable	Not Applicable	Not Applicable	Not Applicable
		<b>Flattening</b>	Not Applicable	Not Applicable	Not Applicable	Not Applicable
		<b>Flaring</b>	Not Applicable	Not Applicable	Not Applicable	NotApplicable
		<b>Impact</b>	As per customer requirement	As per customer requirement	As per customer requirement	As per customer requirement
7	<b>Chemical Composition</b>	<b>%C</b>	0.36-0.42	0.30-0.40	0.36-0.44	0.36-0.44
		<b>%Mn</b>	1.30-1.60	1.20-1.50	1.35-1.65	1.35-1.65
		<b>%Si</b>	-	-	-	0.15-0.50
		<b>%p</b>	0.035 max	0.045 max	0.040 max	0.040 max
		<b>%S</b>	0.030 max	0.035 max	0.050 max	0.050 max
		<b>%Cr</b>	-	-	-	0.09-0.11
		<b>%Cu</b>	-	-	-	0.002-0.006
		<b>%Mo</b>	-	-	-	0.0001-0.0004
		<b>%Ni</b>	-	-	-	0.0040-0.0046
		<b>%V</b>	-	-	-	0.0040-0.0046
		<b>Others</b>	-	-	-	-
8	<b>NDT</b>	<b>ECT</b>	Applicable as per specification ISO 10893-2	Applicable as per specification ISO 10893-2	Applicable as per specification ASME E309	As per standard specification with minimum 0.8 mm drill hole
		<b>UT</b>	Applicable as per specification ISO 10893-10	Applicable as per specification ISO 10893-10	Applicable as per specification ASME E213	As per standard specification with minimum 0.3 mm notch depth
9	<b>Hydrostatic Test</b>		As per customer requirement			2500 psi pressure minimum 5Sec holding time
10	<b>Dimension Tolerance (mm)</b>	<b>OD</b>	OD (+0.18/-0.00)	OD (+0.18/-0.00)	OD (+0.18/-0.00)	OK
		<b>WT / ID</b>	ID (-0.18/+0.00)	ID (-0.18/+0.00)	ID (-0.18/+0.00)	OK
11	<b>Heat Treatments Condition</b>		As Drawn / Annealing / Normalizing / SR / Q&T	As Drawn / Annealing / Normalizing / SR / Q&T	As Drawn / Annealing / Normalizing / SR / Q&T	Stress Relieved
12	<b>Surface Condition</b>		-	-	-	Smooth scale free black surface
13	<b>End Condition</b>		Plain end	-	Plain end	Plain end
14	<b>Straightness</b>		Reasonably staright	Reasonably staright	Reasonably staright	0.8 : 1000 MM
15	<b>Ovality</b>		-	-	-	0.3 mm Max
16	<b>Eccentricity</b>		-	-	-	5% Max
17	<b>Stencil Marking</b>		LALBABA/LOGO/BS 4019 / JIS G 3465 / A519 Gr. SAE1541 HQ/HW Plain End - Mining/OD 57.28 X WT 5.69 MM / MADE IN INDIA			
18	<b>Coating</b>		Bare / Rust preventive coating			Rust Preventive Oil

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