

Sl. No.	Seamless Tubes Parameters		Description as per Specification				
1	Specification		ASTM A53 B/A106 Gr.B / CSAZ245 Gr. 290 CAT- I / API 5L Gr.B / X42 PSL-1/OD 88.90 X WT 5.49 MM / MADE IN INDIA				
2	Size		OD 88.90 X WT 5.49 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				
			CSAZ245 Gr. 290 CAT- I – Petroleum and Natural Gas Industry Pipeline Systems and Materials				
			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		ASTM A53 B	A106 Gr.B	CSAZ245 Gr. 290 CAT- I	API 5L Gr.B / X42 PSL-1	Lalbaba Offer
6	Mechanical Test	Yst in Mpa	240 Min	205 Min	290-495	290 Min	320 – 350
		UTS in Mpa	415 Min	380 Min	414-760	415 Min	440 – 470
		E%	30% Min	35% Min	22 min	As per given formula in spec	38 – 47
		Hardness	Not Applicable	Not Applicable	Not Applicable	Not Applicable	70 – 80
		Bend test	OD ≤ 60.30 mm	Not Applicable	Applicable	OD ≤ 60.30 mm	OK
		Flattening	OD ≥ 60.30mm	Applicable	Applicable	OD ≥ 60.30mm	OK
		Flarring	Not Applicable	Not Applicable	Not Applicable	Not Applicable	OK
		Impact	Not Applicable	Applicable as per Spec	Applicable as per Spec	Not Applicable	OK
7	Chemical composition	%C	0.30 Max	0.30 Max	0.26 Max	0.28 Max	0.17 – 0.22
		%Mn	0.29-1.06	0.40-1.06	2.00 Max	1.30 Max	1.10 – 1.25
		%Si	0.10 Min	-	0.50 Max	-	0.10 – 0.35
		%p	0.035 Max	0.025	0.030 Max	0.030 Max	0.025 Max
		%S	0.035 Min	0.025	0.035 Max	0.030 Max	0.025 Max
		%Cr	0.40 Max	-	-	-	0.40 Max
		%Cu	0.40 Max	-	-	-	0.40 Max
		%Mo	0.15 Max	-	-	-	0.15 Max
		%Ni	0.40 Max	-	-	-	0.40 Max
		%V	0.08 Max	-	0.11 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	1000 PSI pressure minimum 5Sec holding time.	20.7 Mpa pressure minimum 5Sec holding time.	2500 PSI pressure minimum 5Sec holding time.	2500 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/+0.80 Over OD 48.30 to 114.30 ±0.8	OD ±1.00%	< 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%	WT +18.0%, -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	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	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 / CSAZ245 Gr. 290 CAT- I / API 5L Gr.B / X42 PSL-1/OD 88.90 X WT 5.49 MM / MADE IN INDIA				
18	Coating		Bare/Rust preventive coating				Bare/Oiling

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