

Sl. No.	Parameters	Description as per Specification							
1	<b>Specification</b>	ASTM A53 B/A106 Gr.B / A333 Gr. 1 & 6 / API 5L Gr.B / X42 PSL-1							
2	<b>Size</b>	OD 114.0 X WT 6.20 MM							
3	<b>Application</b>	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	<b>Process of Manufacture</b>	Cold drawn seamless							
5	<b>Specification Grade</b>	<b>ASTM A53 B</b>	<b>A106 Gr.B</b>	<b>A333 Gr. 1</b>	<b>A333 Gr. 6</b>	<b>API 5L Gr.B / X42 PSL-1</b>	<b>Lalbaba Offer</b>		
6	<b>Mechanical Test</b>	<b>Yst in Mpa</b>	240 Min	240 Min	205 Min	240 Min	290 Min	310 - 350	
		<b>UTS in Mpa</b>	415 Min	415 Min	380 Min	415 Min	415 Min	440 - 470	
		<b>E%</b>	30% Min	30% Min	35% Min	30% Min	As per given formula in spec	38 - 47	
		<b>Hardness</b>	Not Applicable	Not Applicable	Not Applicable	Not Applicable	Not Applicable	70 - 80	
		<b>Bend test</b>	OD ≤ 60.30 mm	OD ≤ 60.30 mm	Not Applicable	Not Applicable	OD ≤ 60.30 mm	OK	
		<b>Flattening</b>	OD ≥ 60.30mm	OD ≥ 60.30mm	Applicable	Applicable	OD ≥ 60.30mm	OK	
		<b>Flarring</b>	Not Applicable	Not Applicable	Not Applicable	Not Applicable	Not Applicable	OK	
	<b>Impact</b>	Not Applicable	Not Applicable	Applicable as per Spec	Applicable as per Spec	Not Applicable	OK		
7	<b>Chemical composition</b>	<b>%C</b>	0.30 Max	0.30 Max	0.30 Max	0.30 Max	0.28 Max	0.17 - 0.22	
		<b>%Mn</b>	0.29-1.06	0.29-1.06	0.40-1.06	0.40-1.06	1.30 Max	1.10 - 1.25	
		<b>%Si</b>	0.10 Min	0.10 Min	-	-	-	0.10 - 0.35	
		<b>%p</b>	0.035 Max	0.035 Max	0.025	0.025	0.030 Max	0.025 Max	
		<b>%S</b>	0.035 Min	0.035 Min	0.025	0.025	0.030 Max	0.025 Max	
		<b>%Cr</b>	0.40 Max	0.40 Max	-	-	-	0.40 Max	
		<b>%Cu</b>	0.40 Max	0.40 Max	-	-	-	0.40 Max	
		<b>%Mo</b>	0.15 Max	0.15 Max	-	-	-	0.15 Max	
		<b>%Ni</b>	0.40 Max	0.40 Max	-	-	-	0.40 Max	
		<b>%V</b>	0.08 Max	0.08 Max	-	-	-	0.08 Max	
	<b>Others</b>	-	-	-	-	Nb + V + Ti ≤ 0.15	Nb + V + Ti ≤ 0.15		
8	<b>NDT</b>	<b>ECT</b>	Applicable as per specification ASME E309					As per specification ASME E309 with minimum 0.8 mm drill hole	
		<b>UT</b>	Applicable as per specification ASME E213					As per specification ASME E213 with minimum 0.3 mm notch depth	
9	<b>Hydrostatic Test</b>	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	1000 PSI pressure minimum 5Sec holding time	2500 PSI pressure minimum 5Sec holding time	2800 PSI 5 Sec holding time	
10	<b>Dimension Tolerance (mm)</b>	<b>OD</b>	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	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
		<b>WT / ID</b>	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%	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	<b>Heat treatments Condition</b>	Heat treated Above 650°C	Heat treated Above 650°C	Normalized	Normalized	Normalized	Normalized	Normalized above 870°C	
12	<b>Surface condition</b>	-	-	-	-	-	-	Scale & defect free black surface	
13	<b>End Condition</b>	Plain end / Bevel end						OK	
14	<b>Straightness</b>	Reasonably staright	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	<b>Ovality</b>	-	-	-	-	-	-	0.3 mm Max	
16	<b>Eccentricity</b>	-	-	-	-	-	-	5% Max	
17	<b>Stencil Marking</b>	LALBABA/LOGO / 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							
18	<b>Coating</b>	Bare/Rust preventive coating/Black Varnish						Black Varnish	

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