

Sl. No.	Parameters		Description as per Specification			
1	Specification		ASTM A213 T22 / ASTM A 335 P22 / EN 10216-2/ DIN17175 /Gr.10CrMo9-10			
2	Size		OD 44.50 X WT 4.06 MM			
3	Application		ASTM A213 T22 – Standard Specification of Seamless Pipe for Boiler, Super Heater, Heat Exchanger			
			ASTM A 335 P22 – Standard Specification of Seamless Pipe for High Temperature Service			
			EN 10216-2, Gr.10CrMo9-10 – Seamless Tube for Specified Elevated Temperature Property			
4	Process of Manufacture		Cold drawn seamless			
5	Specification Grade		ASTM A213 T22	ASTM A 335 P22	EN 10216-2,Gr.10CrMo9-10	Lalbaba Offer
6	Mechanical Test	Yst in Mpa	220 min	220 min	275 min	300-350
		UTS in Mpa	415 min	415 min	410-560	500-550
		E%	30 min	30 min	22 min	40%
		Hardness	85 HRB max	-	-	75-82 HRB
		Bend test	Not Applicable	Not Applicable	Not Applicable	OK
		Flattening	Applicable	Applicable	Applicable	OK
		Flaring	Applicable	Applicable	Applicable	OK
		Impact	As per customer Requirement	As per customer Requirement	40J : 20 deg c	OK
7	Chemical Composition	%C	0.05-0.15	0.05-0.15	0.05-0.15	0.05-0.15
		%Mn	0.30-0.60	0.30-0.60	0.30-0.60	0.30-0.60
		%Si	0.50 max	0.50 max	0.50 max	0.50 max
		%p	0.025 max	0.025 max	0.025 max	0.025 max
		%S	0.025 max	0.025 max	0.025 max	0.020 max
		%Cr	1.90-2.60	1.90-2.60	1.90-2.60	1.90-2.60
		%Cu	-	-	-	-
		%Mo	0.87-1.13	0.87-1.13	0.87-1.13	0.90-1.00
		%Ni	-	-	-	0.010-0.011
		%V	-	-	-	0.001-0.003
		Others	-	-	-	-
8	NDT	ECT	Applicable as per specification ASME E309	Applicable as per specification ASME E309	Applicable as per specification EN10246-2	As per specification ASME E309 with minimum 0.8 mm drill hole
		UT	Applicable as per specification ASME E213	Applicable as per specification ASME E213	Applicable as per specification EN10246-7, level U2-C	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	70 bar pressure minimum 5Sec holding time	2500 PSI 5 sec holding time
10	Dimension Tolerance (mm)	OD	OD (+0.40/-0.80)	OD (+0.40/-0.80)	+/-1% or +/-0.5 whichever is greater	OD (+0.40/-0.80)
		WT / ID	WT (+20%/-0.00)	WT(+20%/-0.00)	WT+28%/0	WT (+20%/-0.00)
11	Heat Treatments Condition		Full/Isothermal annealing or Normalizing & tempering	Full/Isothermal annealing or Normalizing & tempering	Full/Isothermal annealing or Normalizing & tempering	Normalizing & tempering
12	Surface Condition		-	-	-	Scale & defect free black surface
13	End Condition		Plain end	Plain end	Plain end	Plain end
14	Straightness		Reasonably staright	Reasonably staright	3:1000	0.8 : 1000 MM
15	Ovality		-	-	-	0.3 mm Max
16	Eccentricity		-	-	-	5% Max
17	Stencil Marking		LALBABA/LOGO/ASTM A213 T22 / ASTM A 335 P22 / EN 10216-2/ DIN17175 /Gr.10CrMo9-10 / OD 44.50 X WT 4.06 MM / MADE IN INDIA			
18	Coating		Rust preventive coating/Black Varnish			Oiling/Varnish

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