

**DIMENSIONS AND NOMINAL WEIGHTS OF BLACK STEEL PIPES  
CONFORMING TO IS: 1239 (PART-1) 2004 EQUIVALENT TO BS: 1387**

Nominal Bore & Series		Outside Diameter		Wall thickness		Weight of Black Tube					Socket	
						Plain end		Screwed & Socketed		No. of pipes / approx ton bundle		
mm	Type	Min. (mm)	Max. (mm)	mm	SWG	Kg/Mtr.	Mtr./Ton	Kg/Mtr.	Mtr./Ton			Min. Outer dia (MM)
6	L	9.7	10.1	1.8	15	0.361	----	0.364	----	----	15	19
	M	9.8	10.6	2	14	0.407		0.41				
	H	9.8	10.6	2.65	12	0.493		0.496				
8	L	13.6	13.2	1.8	15	0.517	----	0.521	----	----	18.5	27
	M	13.2	14	2.35	13	0.65		0.654				
	H	13.2	14	2.9	11	0.769		0.773				
10	L	17.1	16.7	1.8	15	0.674	----	0.68	----	----	22	28
	M	16.7	17.5	2.35	13	0.852		0.858				
	H	16.7	17.5	2.9	11	1.02		1.03				
15	L	21	21.4	2	14	0.947	1056	0.956	1046	165	27	37
	M	21	21.8	2.6	12	1.21	826	1.22	820	132		
	H	21	21.8	3.2	10	1.44	694	1.45	690	110		
20	L	26.4	26.9	2.3	13	1.38	725	1.39	719	112	32.5	39
	M	26.5	27.3	2.6	12	1.56	641	1.57	637	98		
	H	26.5	27.3	3.2	10	1.87	535	1.88	532	84		
25	L	33.2	33.8	2.6	12	1.98	505	2	500	80	39.5	46
	M	33.3	34.2	3.2	10	2.41	415	2.43	412	65		
	H	33.3	34.2	4	8	2.93	341	2.95	339	55		
32	L	41.9	42.5	2.6	12	2.54	394	2.57	389	60	49.5	51
	M	42	42.9	3.2	10	3.1	323	3.13	319	51		
	H	42	42.9	4	8	3.79	264	3.82	262	42		
40	L	47.8	48.4	2.9	11	3.23	310	3.27	306	48	56	51
	M	47.9	48.8	3.2	10	3.56	281	3.6	278	45		
	H	47.9	48.8	4	8	4.37	229	4.41	227	36		
50	L	59.6	60.2	2.9	11	4.08	245	4.15	241	39	68	60
	M	59.7	60.8	3.6	9	3.03	199	5.1	196	30		
	H	59.7	60.8	4.5	7	6.19	162	6.26	160	27		
65	L	75.2	76	3.2	10	5.71	175	5.83	172	27	84	69
	M	75.3	76.6	3.6	9	6.42	156	6.54	153	24		
	H	75.3	76.6	4.5	7	7.93	126	8.05	124	20		
80	L	87.9	88.7	3.2	10	6.72	149	6.89	145	23	98	75
	M	88	89.5	4	8	8.36	120	8.53	117	19		
	H	88	89.5	4.8	6	9.9	101	10.1	96	16		
100	L	113	113.9	3.6	9	9.75	103	10	100	16	124	87
	M	113.1	115	4.5	7	12.2	82	12.5	80	13		
	H	113.1	115	5.4	5	14.5	69	14.8	68	11		
125	M	138.5	140.8	4.8	6	15.9	63	16.4	61	10	151	96
	H	138.5	140.8	5.4	5	17.9	56	18.4	54	9		
150	M	163.9	166.5	4.8	6	18.9	53	19.5	51	8	178	96
	H	163.9	166.5	5.4	5	21.3	47	21.9	46	7		
175	M	--	193.7	5.4	5	25.1	--	--	--	--	--	--
	H	--	193.7	5.9	4	27.3	--	--	--	--	--	--
200	M	--	219.1	5.6	5	29.5	--	--	--	--	--	--
	H	--	219.1	5.9	4	31	--	--	--	--	--	--

**TOLERANCES ON THICKNESS & WEIGHT**

(The Following manufacturing tolerances shall be permitted on the tubes and sockets)

(A) Thickness	Tolerance	(B) Weight	Tolerance	(C) Length Tolerance
Light Tubes	+ not ilimited -8%	Single Tube (Light Series)	10% -8%	Unless otherwise Specified 4 to 7 mtrs. Can also be supplied in Fix Lengths ±5cm.
Medium & Heavy Tubes	+ not limited -10%	Single Tube (Medium & Heavy)	10%	

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