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2.3 Lungimea tevii

Teava se va livra la lungimi la 6,0m cu toleranta la lungime de +100/-0mm in afara de cazul in care se specifica atfel in comanda. In acest caz solicitarea clientului trebuie sa fie aprobata si confirmata de producator.

2.4 Calitatea otelului

P195TR1; P235TR1; P265TR1 – pentru toate dimensiunile.

P195TR2; P235TR2; P265TR2 - pentru 114.3; 133;139.7;159;168.3;219.1 mm

2.4 Acoperirea suprafetei pentru protectie

Suprafata exterioara a tevii este pulverizata cu vopsea pe baza de apa.

Pregatirea suprafetei : sablare cu alice metalice , Sa2÷2.5

Nr straturi vopsea: 1

Grosimea stratului de vopsea dupa uscare: 25µm

Culori disponibile

RAL 3011 Brown red	RGB color (121, 36, 35)
RAL 3009 Oxide red	RGB color (109, 52, 45)
RAL3000 Flame red	RGB color (167, 41, 32)
RAL5005 Signal blue	RGB color (0, 83, 135)
RAL 6005 Moss green	RGB color (17, 66, 50)
RAL 7001 Silver grey	RGB color (140, 150, 157)
RAL 7012 Basalt grey	RGB color (87, 93, 94)
RAL 9002 Grey white	RGB color (215, 213, 203)

La cerere se pot fabrica si alte culori.

2.5 Marcare

Marcarea tevii se face in conform cerintelor standardului EN 10217 -1.

Tube-marking is made in accordance to the requirements of EN 10217-1.

Marcarea tevii se face printat cu text alb;
Eticheta se ataseaza la fiecare balot.

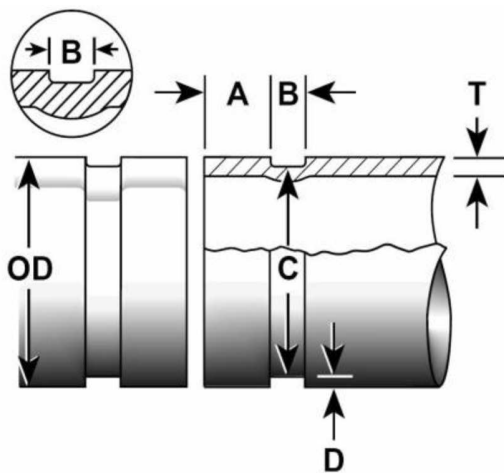
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3. Specificatii tehnice ale canelurilor

Capetele tevilor sunt canelate conform Caneluri circulare standard VICTAULIC (Spec. 25.01):

Table2 – Dimensiuni si tolerante pt Caneluri circulare standard VICTAULIC (Spec. 25.01):

Dimension [mm]								
OD	Pipe Outside Diameter OD		A Gasket Seat	B Groove Width	C Groove Diameter		D Groove Depth	Max. Allow. Flare Diameter F
	Tolerance				Basic	Tol. +0.00		
	+	-	A	B			ref.	
48.3	0.48	0.48	15.88	7.14	45.09	-0.38	1.6	51.1
60.3	0.61	0.61	15.88	8.74	57.15	-0.38	1.6	63
73	0.74	0.74	15.88	8.74	69.09	-0.46	1.98	75.7
76.1	0.76	0.76	15.88	8.74	72.26	-0.46	1.98	78.7
88.9	0.89	0.79	15.88	8.74	84.94	-0.46	1.98	91.4
102	1.02	0.79	15.88	8.74	97.38	-0.51	2.11	104.1
108	1.09	0.79	15.88	8.74	103.73	-0.51	2.11	110.5
114	1.14	0.79	15.88	8.74	110.08	-0.51	2.11	116.8
127	1.27	0.79	15.88	8.74	122.78	-0.51	2.11	129.5
133	1.35	0.79	15.88	8.74	129.13	-0.51	2.11	135.9
140	1.42	0.79	15.88	8.74	135.48	-0.51	2.11	142.2
141	1.42	0.79	15.88	8.74	137.03	-0.56	2.13	143.8
152	1.42	0.79	15.88	8.74	148.08	-0.56	2.16	154.9
159	1.6	0.79	15.88	8.74	153.21	-0.56	2.16	161.3
165	1.6	0.79	15.88	8.74	160.78	-0.56	2.16	167.6
168	1.6	0.79	15.88	8.74	163.96	-0.56	2.16	170.9
219	1.6	0.79	19.05	11.91	214.4	-0.64	2.34	223.5



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4. Testare si inspectie

Tevele vor fi inspectate si testate conform metodelor si cerintelor specificate in standardul EN 10217- 1 iar dimensiunile canelurilor vor fi conform cerintelor Victaulic.

5. Documente

Pentru tevele EN 10217-1 TR1 se va elibera Raport de inspectie 2.2 sau la cerere Raport de inspectie 3.1

Pentru tevele EN 10217-1 TR2 se va elibera Raport de inspectie 3.1 conform EN 10240.

Iasi, 02 May 2017

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2.3 Tube length

Unless otherwise specified in the order, the tubes will be delivered in lengths of **6,0 m** with **+100/-0 mm** length tolerance. If the customer asks for another length or length-tolerance, it should request in the order and approved.

2.4 Steel

P195TR1; P235TR1; P265TR1 - for all dimensions

P195TR2; P235TR2; P265TR2 - for 114.3; 133;139.7;159;168.3;219.1 mm

2.5 Surface protection

Outside tube-surface is sprayed by water-based paint.

Surface preparation: Shot-blasted, Sa2÷2.5

Number of coat-layers: 1

Nominal dry film thickness: 25µm

Color

RAL 3011 Brown red	RGB color (121, 36, 35)
RAL 3009 Oxide red	RGB color (109, 52, 45)
RAL3000 Flame red	RGB color (167, 41, 32)
RAL5005 Signal blue	RGB color (0, 83, 135)
RAL 6005 Moss green	RGB color (17, 66, 50)
RAL 7001 Silver grey	RGB color (140, 150, 157)
RAL 7012 Basalt grey	RGB color (87, 93, 94)
RAL 9002 Grey white	RGB color (215, 213, 203)

Other colors are possible only after previous agreement.

2.6 Tube marking

Tube-marking is made in accordance to the requirements of EN 10217-1.

Ink-Jet marking

Printed text is in white color;

Labels

Marking is applied on labels attached to the bundle;

Die stamping

Text length is limited to heat and lot number;

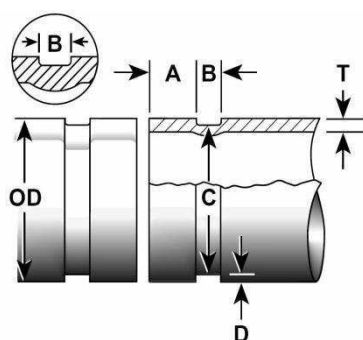
3. Technical specification for groove

Tube ends are grooved with VICTAULIC Standard Roll Groove (Spec. 25.01):

Table2 - Dimensions and tolerances for VICTAULIC Standard Roll Groove (Spec. 25.01):

Table 2

Dimension [mm]								
OD	Pipe Outside Diameter OD		A Gasket Seat	B Groove Width	C Groove Diameter		D Groove Depth	Max. Allow. Flare Diameter F
	Tolerance				Basic	Tol. +0.00		
	+	-	A	B			ref.	F
48.3	0.48	0.48	15.88	7.14	45.09	-0.38	1.6	51.1
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73	0.74	0.74	15.88	8.74	69.09	-0.46	1.98	75.7
76.1	0.76	0.76	15.88	8.74	72.26	-0.46	1.98	78.7
88.9	0.89	0.79	15.88	8.74	84.94	-0.46	1.98	91.4
102	1.02	0.79	15.88	8.74	97.38	-0.51	2.11	104.1
108	1.09	0.79	15.88	8.74	103.73	-0.51	2.11	110.5
114	1.14	0.79	15.88	8.74	110.08	-0.51	2.11	116.8
127	1.27	0.79	15.88	8.74	122.78	-0.51	2.11	129.5
133	1.35	0.79	15.88	8.74	129.13	-0.51	2.11	135.9
140	1.42	0.79	15.88	8.74	135.48	-0.51	2.11	142.2
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159	1.6	0.79	15.88	8.74	153.21	-0.56	2.16	161.3
165	1.6	0.79	15.88	8.74	160.78	-0.56	2.16	167.6
168	1.6	0.79	15.88	8.74	163.96	-0.56	2.16	170.9
219	1.6	0.79	19.05	11.91	214.4	-0.64	2.34	223.5



Note1:

Gasket seat A: The pipe outer surface between the pipe end and groove shall be free from indentations, roll marks and projections in order to provide a leak tight seal for the gasket. Any areas of loose paint, loose scale, loose rust and grease, dirt etc. must also be removed for this reason.

Groove width B: The bottom of the groove shall be free from loose dirt, chips, rust and scale that would otherwise interfere with proper coupling assembly.

Groove diameter C: The groove shall be of uniform depth around the entire pipe circumference and dimensions shall be maintained within the limits shown above.

Groove depth D: Details provided for reference purposes only.

Maximum allowable pipe end flare diameter: Measured at the extreme pipe end. It is recommended that only pipe with square cut ends be roll grooved as processing of pipe with beveled ends may result in unacceptable levels of pipe end flare.

Note 2:

- Groove diameter (C) should be measured using a 'Diameter Tape' (available from coupling manufacturers)
- The groove diameter (C) must be within the max and min tolerance shown in the table below, measured at the weld area and at 90 degrees to the weld

4. Inspection and testing

Pipes shall be inspected and tested using the methods and frequencies stated in the EN 10217-1 standard and the groove dimensions shall be in accordance with requirements of the VICTAULIC documentation.

5. Inspection documents

For pipes manufactured as per EN 10217-1 TR1, either a test report 2.2 is provided, or, upon request, an optional inspection certificate 3.1.

For pipes manufactured as per EN 10217-1 TR2, an inspection certificate 3.1 is mandatorily provided, in accordance with the EN 10204 standard.

Iasi, 02 May 2017

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