



LIBERTY

Liberty Tubular Products
Ostrava a.s.
SPIRAL WELDED PIPES

Dimensional standards

ASME B36.10M	“Welded and hot-rolled seamless steel pipes”
ČSN 42 5738	“Spiral weld steel pipes”
DIN 2458	“Welded steel tubes”
EN 10220	“Seamless and welded steel tubes - General tables of dimensions and masses per unit length”
ISO 4200	“Plain-end steel tubes, welded and seamless”

Technical supply regulations

ČSN 42 0144	“Spiral welded steel”
DIN 1615	“Welded circular tubes of non-alloy steels without special quality requirements”
DIN 1626	“Welded circular tubes of non-alloy steels with special quality requirements”
EN 10208-1	“Steel tubes for pipeline for combustible liquids” – part 1: Requirements according to class A
EN 10208-2	“Steel tubes for pipeline for combustible liquids” – part 2: Requirements according to class B
EN 10217-1	“Welded steel pipes for pressure purposes”
EN 10217-3	“Welded steel pipes for pressure vessel”
EN 10217-5	“Welded steel tubes for pressure purposes. Submerged arc welded non-alloy and alloy steel tubes with specified elevated temperature properties”
EN 10219-1	“Cold formed welded structural hollow sections of non-alloy and fine grain steels”
EN 10224	“Non-alloy steel tubes and fittings for the conveyance of water and other aqueous liquids”
API Spec 5L	“Specification for Line Pipe”
ISO 3183	“Steel pipe for pipeline transportation systems”
PN 79/H-74244	“Welded steel pipes for transportation of media”

Steel grades

ČSN 42 5738:	11 375, 11 378, 11 425, 11 523
DIN 1615: (DIN 1626)	St 33 (St 37.0, St 44.0, St 52.0)
EN 10208-1:	L210GA, L235GA, L245GA, L290GA, L360GA
EN 10208-2:	L245NB, L245MB, L290NB, L360NB, L290MB, L360MB, L415MB, L450MB, L485MB
EN 10217-1:	P195TR1, P235TR1, P265TR1, P195TR2, P235TR2, P265TR2
EN 10217-3:	P355NH TC1/TC2, P355N TC1/TC2
EN 10217-5:	P235GH TC1/TC2, P265GH TC1/TC2
EN 10219-1:	S235JRH, S275J0H, S275J2H, S355J0H, S355J2H
EN 10224:	L235, L275, L355
API Spec 5L:	PSL1: L210/A, L245/B, L290/X42, L320/X46, L360/X52, L390/X56, L415/X60, L450/X65, L485/X70, PSL2: L245N/BN, L290N/X42N, L320N/X46N, L360N/X52N, L360M/X52M, L390M/X56M, L415M/X60M, L450M/X65M, L485M/X70M
ISO 3183:	PSL1: L210/A, L245/B, L290/X42, L320/X46, L360/X52, L390/X56, L415/X60, L450/X65, L485/X70, PSL2: L245N/BN, L290N/X42N, L320N/X46N, L360N/X52N, L360M/X52M, L390M/X56M, L415M/X60M, L450M/X65M, L485M/X70M
ISO 3183 Annex M:	PSL2: L245NE/BNE, L290NE/X42NE, L360NE/X52NE, L360ME/X52ME, L415ME/X60ME, L450ME/X65ME, L485ME/X70ME

Lengths

Tubes are supplied in lengths **from 8m to 18m for rail or truck transport:**

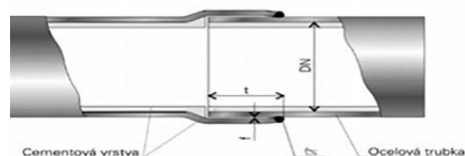
Set length	– nominal length selected by the customer from the range of production lengths with a tolerance of ± 500 mm
Exact length	– nominal length selected by the customer following agreement with the producer with a tolerance of $+50/-0$ mm. more strict tolerances only after agreement

Socket pipes

The tubes are delivered according to DIN 2460 T1 or EN 10224 with outside polyethylene coating according to DIN 30 670-N-n and internal protection (cement mortar lining) according to DIN 2614 or EN 10298. At the point of connection it is possible to carry out surface coating for pipe ends finishing – for example by thermally shrinking collar on the outside surface, the connection does not require additional tube internal surface treatment.

Steel Grade

Outside diameter [mm]	Max. wall thickness [mm]		
	Grade L235	Grade L275	Grade L355
323,9	6,3	6,3	5,6
355,6	8,0	8,0	5,6
406,4	8,0	8,0	7,1
508	6,3	6,3	5,6
610	8,0	8,0	7,1
711	8,0	8,0	7,1
813	8,0	8,0	7,1



Dimensional range, weight according to EN 10220 (ISO 4200)

Outside diameter mm	Wall thickness (mm)										
	5	5,6	6,3	7,1	8	8,8	10	11 ¹	12,5 ¹	14,2 ¹	16 ¹
	Weight (kg/m)										
323,9	39,3 ¹	44,0	49,3	55,5	62,3						
355,6	43,2 ¹	48,3	54,3	61,0	68,6						
406,4	49,5 ¹	55,4	62,2	69,9	78,6	86,3	97,8	107	121		
457	55,7 ¹	62,3	70,0	78,8	88,6	97,3	110	121	137	155	
508	62,0 ¹	69,4	77,9	87,7	98,6	108	123	135	153	173	
(559)	68,3 ¹	76,4	85,9	94,6	109	119	135	149	169	191	214
610	74,6 ¹	83,5 ¹	93,8	106	119	130	148	162	184	209	234
(660)	90,4 ¹	102 ¹	114	129	141	160	176	200	226	254	
711	97,4 ¹	109 ¹	123	139	152	173	190	215	244	274	
762	104 ¹	117 ¹	132 ¹	149	163	185	204	231	262	294	
813		125 ¹	141 ¹	159 ¹	175	198	218	247	280	314	
(864)			150 ¹	169 ¹	186	211	231	262	298	335	
914				179 ¹	196 ¹	223	245	278	315	354	
1016				199 ¹	219 ¹	248	273	309	351	395	

¹Supplied by prior agreement.

Dimensional range, weight according to ASME B36.10M






Outside diameter	Wall thickness (in / mm)										
	0,219/5,56	0,250/6,35	0,281/7,14	0,312/7,92	0,344/8,74	0,375/9,53	0,406/10,31	0,438/11,13 ¹	0,469/11,91 ¹	0,469/12,7 ^{1,2}	
in	mm	Weight (lb.ft ⁻¹ / kg.m ⁻¹)									
12 3/4	323,9	29,34/43,64	33,41/49,71	37,46/55,76	41,48/61,70						
14	355,6	32,26/48,00	36,75/54,69	41,21/61,36	45,65/67,91						
16	406,4	36,95/54,96	42,09/62,65	47,22/70,30	52,32/77,83	57,57/85,71	62,64/93,27	67,68/100,71	72,86/108,49		
18	457	41,63/61,90	47,44/70,57	53,23/79,21	58,99/87,71	64,93/96,62	70,65/105,17	76,36/113,58	82,23/122,38	87,89/130,73	93,54/139,16
20	508	46,31/68,89	52,78/78,56	59,23/88,19	65,66/97,68	72,28/107,61	78,67/117,15	85,04/126,54	91,59/136,38	97,92/145,71	104,23/155,13
22	559	50,99/75,89	58,13/86,55	65,24/97,17	72,34/107,64	79,64/118,60	86,69/129,14	93,72/139,51	100,96/150,38	107,95/160,69	114,92/171,10
24	610	55,42/82,58 ¹	63,47/94,53	71,25/106,15	79,01/117,60	86,99/129,60	94,71/141,12	102,40/152,48	110,32/164,38	117,98/175,67	125,61/187,07
26	660		68,82/102,36 ¹	77,26/114,96	85,68/127,36	94,35/140,37	102,72/152,88	111,08/165,19	119,69/178,10	128,00/190,36	136,30/202,74
28	711		74,16/110,35 ¹	83,26/123,94	92,35/137,32	101,70/151,37	110,74/164,86	119,76/178,16	128,05/192,10	138,03/205,34	146,99/218,71
30	762		79,51/118,34 ¹	89,27/132,92 ¹	99,02/147,29	109,06/162,36	118,76/176,85	128,44/191,12	138,42/206,10	148,06/220,32	157,68/234,68
32	813		84,85/126,32 ¹	95,28/141,90 ¹	105,69/157,25 ¹	116,41/173,35	126,78/188,83	137,12/204,09	147,78/220,10	158,08/235,29	168,37/250,65
34	864			101,29/150,88 ¹	112,36/167,21 ¹	123,77/184,34	134,79/200,82	145,80/217,06	157,14/234,10	168,11/250,27	179,06/266,63
36	914				119,03/176,97 ¹	131,12/195,12 ¹	142,81/212,57	154,48/229,77	166,51/247,82	178,14/264,96	189,75/282,29
38	965				125,7/186,94 ¹	138,47/206,11 ¹	150,83/224,56	163,16/242,74	175,87/261,82	188,17/279,94	200,44/298,26
40	1016				132,37/196,90 ¹	145,83/217,11 ¹	158,85/236,54 ¹	171,84/255,71	185,24/275,82	198,19/294,92	211,13/314,23

¹ Supplied by prior agreement.

² Thicker WT than 12,7mm supplied by prior agreement.

Wall thickness limitation depending on tube outside diameter and grade:

Diameter		Wallthickness										
[mm]	[inch]	5	5,6	6,3	7,1	8	8,8	10	11	12,5	14,2	16
323,9	12											
355,6	14											
377	-											
406,4	16											
426	-											
457	18											
508	20											
530	-											
559	22											
610	24											
630	-											
660	26											
711	28											
720	-											
762	30											
813	32											
820	-											
864	34											
914	36											
920	-											
965	38											
1016	40											
1020	-											

- API 5L
ISO 3183
-  Grade X70 L485
 -  Grade X65 L450
 -  Grade X60 L415
 -  Grade X52 L360
 -  Grade X42/B L245

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