



SPIRAWELD SPECIFICATIONS: TOLERANCES

DIAMETER: *Maximum \pm .75%.*

LENGTH: *+ 10mm – 0, Available in 6 metres up to 10 metres long.*

MATERIAL: *As specified – material certificates issued upon request.*

THE WELD: *Plasma arc weld, gas tungsten arc weld (low profile or wire filled).*

PROTECTION: *Each length inspected prior to complete immersion to chemically descale and passivate the internal and external surfaces of the pipe.*

PACKAGING: *Either loose or securely strapped on pallets – end bung protection available.*

TESTING: *When negotiated to BS3605 SW (i.e. Radiography Tensile test etc.).*

PIPE DIAMETER			WALL THICKNESS		WEIGHT	WORKING PRESSURE	
NOMINAL	TRUE DIAMETER		APPROX		<i>per metre approx kgs</i>	<i>mpa</i>	<i>psi</i>
<i>mm</i>	<i>mm</i>	<i>inches</i>	<i>mm</i>	<i>swg</i>			
80	76.2	3	1.5	16	2.9	3.4	493
			2.0	14	3.9	4.6	667
			3.0	11	5.9	6.9	1000
100	101.6	4	1.5	16	4.1	2.8	406
			2.0	14	5.2	3.6	522
			3.0	11	7.8	5.2	754
125	127.0	5	2.0	14	6.4	2.8	406
150	152.4	6	1.5	16	5.9	1.9	275
			2.0	14	7.5	2.4	348
			3.0	11	11.5	3.5	507
200	230.2	8	1.5	16	8.0	1.4	203
			2.0	14	10.0	1.7	246
			3.0	11	15.3	2.6	377
250	254.0	10	1.5	16	10.1	1.1	159
			2.0	14	12.7	1.4	203
			3.0	11	19.1	2.1	304
300	304.8	12	2.0	14	15.2	1.1	159
			3.0	11	22.8	1.7	246
			4.0	8	30.6	2.4	348
350	355.6	14	2.0	14	17.8	1.0	145
			3.0	11	26.7	1.5	217
			4.0	8	35.6	2.0	290
400	406.4	16	2.0	14	20.8	0.8	116
			3.0	11	31.2	1.3	188
			4.0	8	40.7	1.7	246
450	487.2	18	2.0	14	22.9	0.7	101
			3.0	11	34.4	1.2	174
			4.0	8	45.8	1.5	217
500	508.0	20	3.0	11	36.5	1.1	159
			4.0	8	50.5	1.4	203
600	609.6	24	3.0	11	45.5	0.9	130
			4.0	8	60.5	1.2	174

Sizes other than specified upon request.
Schedule pipe sizes up to 4mm thick available.