

## TOLERANCE ON OUTSIDE DIAMETER WALL THICKNESS, WEIGHT AND LENGTH OF PIPE

SPEC.	TYPE	OUTSIDE DIAMETER		WALL THICKNESS	WEIGHT	LENGTH							
		PIPE BODY	PIPE END (PLAIN END)			NOMINAL		AVG(min)		MINIMUM		MAXIMUM	
						ft.	Mtr	ft.	Mtr	ft.	Mtr	ft.	Mtr
API 5L	ERW	> 6 5/8" (168.3 mm) to ≤ 20" (508 mm) = ± 0.0075 D but max. ± 3.2 mm (0.125")	> 6 5/8" (168.3 mm) to ≤ 20" (508 mm) = ± 0.005 D but max. of ± 1.6 mm (0.063")	≤ 5.0 mm (0.197") WT = ± 0.5 mm (0.020") > 5.0 mm (0.197") WT to < 15.0 mm (0.591") WT = ± 0.1t	Single Length of Pipe = + 10%, - 3.5% Carloads ≥ 18000KG = - 1.75%	20	6	17.5	5.33	9	2.74	22.5	6.86
						40	12	35	10.67	14	4.27	45	13.72
IS:1978	ERW	60.3 and above ± 1%	≤273.1 mm OD = +1.60 MM-0.40MM 323.9 MM od & larger pipe =+2.40mm - 0.80 mm	101.6 mm to 457.2 mm OD= +15%, -12.5% 508 mm OD and above= + 17.5%, - 10.0%	Single length of pipe + 10.%, -3.5% Carloads:- for min. 18,000 kg = - 1.75%	-	6	-	5.3	-	2.7	-	-
						-	12	-	10.7	-	4.3	-	-
IS:1979	ERW	< 508.0 mm OD = ± 0.75% ≥ 508.0 mm OD PIPE=± 1.0%	≤273.1 mm OD pipe=+ 1.60 mm, -0.40 mm 323.9 MM OD & LARGER PIPE=+ 2.40 mm, - 0.80 mm	≤ 457.0 mm OD pipe= +15.0%, -12.5% ≥ 508.0 mm OD pipe= +19.5%, -8.0%	Single length of pipe =+ 10% - 3.5% Carloads:- for min. 18,144 kg.-1.75	-	6	-	5.3	-	2.7	-	-
						-	12	-	10.7	-	4.3	-	-
ASTM- A-53	ERW	Pipe 2" NPS and over= ± 1.0 %		At any point-12.5% ( Max) Tm= Tn × 0.875 Tn = Nominal w.t. Tm= Minimum w.t.	± 10 %	20	6	-	-	16	4.88	22	6.71
						40	12	35	10.67	22	6.71	-	-
IS: 3589	ERW	Upto 508 mm OD = ± 0.75%	-	± 10%	-	-	6	-	-	-	4	-	7
						-	12	-	-	-	7	-	14
IS:4270	ERW	± 1.0%	-	upto 406.4 mm OD= + 15%, - 12.5% over 406.4 mm OD= +15%,-10%	+ 10% - 8%	-	6	-	-	-	4	-	7
						-	12	-	-	-	7	-	14