



DIMENSIONAL TOLERANCES

OD: see dimensional tables of smooth bore cylinder tubes inside H9 or H10.

ID:
For steelgrade E235, tolerance H10 with roughness(Ra) below 1 micron (μm)
For steelgrade E355, tolerance H9 with roughness (Ra) below 0.8 micron (μm).
(see dimensional table for welded smooth bore cylinder tubes inside H9 or H10).

WT: $\pm 7.5\%$ with a minimum of $\pm 0.1\text{ mm}$

ECCENTRICITY: $\frac{\text{Max. W.T.} - \text{Min. W.T.}}{\text{Max. W.T.} + \text{min. W.T.}} \times 100 \leq 7.5\%$

STRAIGHTNESS:

For OD $\leq 260\text{ mm}$
se ReH $\leq 500\text{ Mpa } 0.0015\text{ L}$;
se ReH $> 500\text{ Mpa } 0.002\text{ L}$;
For OD $> 260\text{ mm}$
se ReH $\leq 500\text{ Mpa } 0.0025\text{ L}$;
se ReH $> 500\text{ Mpa } 0.003\text{ L}$;

L = total length of the tube, the max values are to be checked on the total tube length.

