



SEAMLESS AND WELDED CYLINDERS TUBES

The manufacturing process and strict tests foreseen for the cold drawn **SEAMLESS** and **WELDED** tubes give as result a fine grain steel with high pureness degree together with a high dimensional precision.
These are tubes with dimensional features and tolerances on the ID suitable for skiving and roller burnishing.

APPLICATIONS

These tubes are intended to resist to internal pressure and are therefore used for the manufacture of cylinders. They are produced in all the sizes used for hydraulic and pneumatic applications, in different steelgrades and delivery conditions.

NORMS

COLD DRAWN SEAMLESS TUBES
COLD DRAWN WELDED TUBES

EN 10305-1
EN 10305-2

DIMENSIONAL TOLERANCES ACCORDING TO EN 10305-1/2

O.D.: see dimensional table on the next page.

W.T.: welded tubes: $\pm 7.5\%$ with a minimum ± 0.1 mm
seamless tubes : $\pm 10\%$ with a minimum ± 0.1 mm

ECCENTRICITY: welded tubes: $\leq 7.5\%$
seamless tubes: $\leq 10\%$
to be calculated with the following formula:

$$\frac{\text{Max. W.T.} - \text{min. W.T.}}{\text{Max. W.T.} + \text{min. W.T.}} \times 100$$

STRAIGHTNESS:

for OD ≤ 260 mm
if ReH ≤ 500 Mpa 0.0015 L;
if ReH > 500 Mpa 0.002 L;
for ID > 260 mm
if ReH ≤ 500 Mpa 0.0025 L;
if ReH > 500 Mpa 0.003 L;

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