



## SPECIFICATION FOR MILD STEEL TUBES AND TUBULARS CONFORMING TO IS - 1239 (PART I) : 1990



Nominal Bore (NB)		Class	Outside Diameter		Thickness	SWG	Mass of Black Tube		Black Plain End			Calculated Wt. of Galvanised Tube		Galvanised S & S		
			MAX	MIN			P/E	S/S	Mtrs/Ton	Ft/Ton	Pcs/Bdle	P/E	S/S	Mtrs/Ton	Ft/Ton	Pcs/Bdle
mm	Inches		mm	mm	mm		Kg/m	Kg/m	Mtrs/Ton	Ft/Ton	Pcs/Bdle	Kg/m	Kg/m	Mtrs/Ton	Ft/Ton	Pcs/Bdle
15	(1/2")	L	21.40	21.00	2.00	14	0.947	0.956	1056	3465	176	0.999	1.008	992	3255	165
		M	21.80	21.00	2.60	12	1.21	1.22	826	2710	138	1.264	1.274	785	2575	131
		H	21.80	21.00	3.20	10	1.44	1.45	694	2277	116	1.494	1.504	665	2182	111
20	(3/4")	L	26.90	26.40	2.30	13	1.38	1.39	725	2379	121	1.441	1.451	689	2260	115
		M	27.30	26.50	2.60	12	1.56	1.57	641	2103	107	1.622	1.632	613	2011	102
		H	27.30	26.50	3.20	10	1.87	1.88	535	1755	89	1.923	1.933	517	1696	86
25	(1")	L	33.80	33.20	2.60	12	1.98	2.00	505	1657	84	2.062	2.082	480	1575	80
		M	34.20	33.30	3.20	10	2.41	2.43	415	1362	69	2.495	2.515	398	1306	66
		H	34.20	33.30	4.00	8	2.93	2.95	341	1119	57	3.028	3.048	328	1076	55
32	(1 1/4")	L	42.50	41.90	2.60	12	2.54	2.57	394	1293	66	2.641	2.671	374	1227	62
		M	42.90	42.00	3.20	10	3.10	3.13	323	1060	54	3.207	3.237	309	1014	52
		H	42.90	42.00	4.00	8	3.79	3.82	264	866	44	3.887	3.917	255	837	43
40	(1 1/2")	L	48.40	47.80	2.90	11	3.23	3.27	310	1017	52	3.358	3.398	294	965	49
		M	48.80	47.90	3.20	10	3.56	3.60	281	922	47	3.681	3.721	269	883	45
		H	48.80	47.90	4.00	8	4.37	4.41	229	751	38	4.485	4.525	221	725	37
50	(2")	L	60.20	59.60	2.90	11	4.08	4.15	245	804	41	4.225	4.295	233	764	39
		M	60.80	59.70	3.60	9	5.03	5.10	199	653	33	5.166	5.236	191	627	32
		H	60.80	59.70	4.50	7	6.19	6.26	162	531	27	6.349	6.419	156	512	26
65	(2 1/2")	L	76.00	75.20	3.20	10	5.71	5.83	175	574	29	5.898	6.018	166	545	28
		M	76.60	75.30	3.60	9	6.42	6.54	156	512	26	6.621	6.741	144	486	25
		H	76.60	75.30	4.50	7	7.93	8.05	126	413	21	8.095	8.215	122	400	20
80	(3")	L	88.70	87.90	3.20	10	6.72	6.89	149	489	25	6.925	7.122	140	459	23
		M	89.50	88.00	4.00	8	8.36	8.53	120	394	20	8.586	8.756	114	374	19
		H	89.50	88.00	4.80	6	9.90	10.40	101	331	17	10.109	10.609	97	318	16
100	(4")	L	113.90	113.00	3.60	9	9.75	10.00	103	338	17	10.276	10.586	94	308	16
		M	115.00	113.10	4.50	7	12.20	12.50	82	269	14	12.758	13.258	75	246	13
		H	115.00	113.10	5.40	5	14.50	14.80	69	226	12	15.252	15.552	64	210	11
125	(5")	M	140.80	138.50	4.80	6	15.90	16.40	63	207	11	16.649	17.149	58	190	10
		H	140.80	138.50	5.40	5	17.90	18.40	56	184	9	18.619	19.119	52	171	9
150	(6")	M	166.50	163.90	4.80	6	18.90	19.50	53	174	9	19.700	20.300	49	161	8
		H	166.50	163.90	5.40	5	21.30	21.90	47	154	8	22.322	22.922	44	144	7

**TOLERANCE** : Thickness : Light : + Unlimited Medium / Heavy : + Unlimited Weight : Light : ± 5%, Medium / Heavy : ± 7.5%  
 - 8% - 10% (For quantities per load of 10 Tonnes Minimum)

**HYDRO TEST PRESSURE : 5 MPa**

**IS : 1239 (Part I) - 1979 Mild Steel Tubes  
 MAXIMUM PERMISSIBLE PRESSURE AND TEMPERATURE  
 FOR TUBES FOR CONVEYING STEAM**

The maximum permissible pressure and temperature for tubes with screwed and socketed joints shall be as follows.

**MAXIMUM PERMISSIBLE PRESSURE AND TEMPERATURE FOR TUBES  
 WITH STEEL COUPLINGS OR SCREWED AND SOCKETED JOINTS**

Nominal Bore	Maximum Permissible Pressure		Maximum Permissible Temperature
mm	N/mm <sup>2</sup>	Kg/cm <sup>2</sup>	°C
Up to and including 25 mm	1.20	12.24	260
Over 25 mm upto and including 40 mm	1.03	10.50	260
Over 40 mm upto and including 80 mm	0.86	8.77	260
Over 80 mm upto and including 100 mm	0.69	7.04	260
	0.83	8.47	177
Over 100 mm up to and including 125	0.69	7.04	171
Over 125 mm up to and including 150 mm	0.50	5.10	160