

UNCOATED PIPE | PLAIN ENDED

Carbon steel welded pipes are formed by rolling plate or continuous coil or strips. This is a cold forming process where the plate or coil is rolled in the circular section with the help of a plate bending machine, or by a roller in the case of the continuous process.

There are various welding processes such as ERW (electric resistance welding); HFW (high frequency welding); LSAW (longitudinal submerged arc welding); SSAW (spiral submerged arc welding) and DSAW (double submerged arc welding).

The most common specifications for the uncoated pipe are SANS 62 (small bore), SANS 719 (large bore), ASTM A53 and API 5L.

SANS 719 Grade A sizes available

Thickness (mm)	3.5	4.5	6	10
Nominal bore (mm)			80	
			100	
	200	200	200	400

SANS 62 Grade sizes available

Heavy class (mm)	Medium class (mm)
15	15
20	20
25	25
32	32
40	40
50	50
65	65
80	80
100	100
125	125
150	150

SANS 719 Grade B sizes available

Thickness (mm)	4.5	6	8	10	12	12.7
Nominal bore (mm)	200	200		200		
	250	250	250	250		
	300	300	300			
	350	350	350	350		
		400	400	400		
	450	450	450	450		
	500	500	500	500		
		550				
	600	600	600	600		
		700	700		700	
			750			
		800		800	800	
		900	900	900	900	
						1050