Singapore Standards Council

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SINGAPORE STANDARD

Non-alloy steel tubes suitable for welding and threading – Technical delivery conditions

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This Singapore Standard was approved by the Building and Construction Standards Committee on behalf of the Singapore Standards Council on 17 October 2013.

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The Working Group, appointed by the Technical Committee to assist in the preparation of this standard, comprises the following experts who contributed in their *individual capacity*:

		Name
Convenor	:	Mr Tan Ann Kiong
Members	:	Er. Anthony Cheng
		Mr Bernard Cheng Kwang Meng
		Er. Michael Lim Swee Leng
		Mr Sharuddin Md Shah
		Mr Teh Chwoon Young

The organisations in which the experts of the Working Group are involved are:

Association of Consulting Engineers Singapore
Housing & Development Board
Institution of Engineers Singapore
SETSCO Services Pte Ltd
Singapore Contractors Association Ltd
TUV SUD PSB Pte Ltd

National Foreword

This Singapore Standard was prepared by a Working Group appointed by the Technical Committee on Building Maintenance and Management under the purview of the Building and Construction Standards Committee.

The development of SS EN 10255 resulted from the review of SS 17 on steel tubes suitable for screwing to BS 21 pipe threads. SS EN 10255 replaces SS 17.

This SS EN is the identical implementation of EN 10255 : 2004 'Non-alloy steel tubes suitable for welding and threading – Technical delivery conditions' and is adopted with permission of CEN, Avenue Marnix 17, 1000 Brussels.

Attention is drawn to the following:

– The comma has been used throughout as a decimal marker whereas in Singapore Standards, it is a practice to use a full point on the baseline as the decimal marker.

– Where the words 'European Standard' appear, they should be read as `Singapore Standard' when applicable.

Attention is drawn to the possibility that some of the elements of this Singapore Standard may be the subject of patent rights. Enterprise Singapore shall not be held responsible for identifying any or all of such patent rights.

NOTE

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3. *Compliance with a SS or TR does not exempt users from any legal obligations.*

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EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 10255:2004+A1

April 2007

ICS 23.040.10

Supersedes EN 10255:2004

English Version

Non-Alloy steel tubes suitable for welding and threading - Technical delivery conditions

Tubes en acier non allié soudables et filetables - Conditions techniques de livraison

Rohre aus unlegiertem Stahl mit Eignung zum Schweißen und Gewindeschneiden - Technische Lieferbedingungen

This European Standard was approved by CEN on 27 May 2004 and includes Amendment 1 approved by CEN on 05 March 2007

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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EUROPÄISCHES KOMITEE FÜR NORMUNG

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Ref. No. EN 10255:2004+A1:2007: E

Contents

Foreword

This document (EN 10255:2004+A1:2007) has been prepared by Technical Committee ECISS/TC 29 “Steel tubes and fittings for steel tubes”, the secretariat of which is held by UNI.

This document shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2007 and conflicting national standards shall be withdrawn at the latest by October 2007.

This document includes Amendment 1, approved by CEN on 2007-03-05.

This document supersedes EN 10255:2004.

The start and finish of text introduced or altered by amendment is indicated in the text by tags [A1] 〈A1〉.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive 89/106/EEC.

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this document.

This European Standard has been derived, with modifications, from ISO 65 “Carbon steel tube suitable for screwing in accordance with ISO 7/1”.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

1 Scope

This document specifies the requirements for circular non-alloy steel tubes suitable for welding and threading and provides a number of options for the finish of tube ends and coatings. This document covers tubes of specified outside diameter 10,2 mm to 165,1 mm (thread size 1/8 to 6) in two series, medium and heavy, and three types of designated thicknesses.

NOTE Tubes manufactured according to this document can be used for the conveyance of fluids as well as for other applications.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

The requirements of this European Standard rule when they differ from those in the standards and documents referred to below:

EN 10002-1, *Metallic materials - Tensile testing - Part 1: Method of test at ambient temperature*

EN 10020, *Definition and classification of grades of steel*

EN 10021, ▌A1⟩ *General technical delivery for steel products* ⟨A1▐

EN 10027-1, *Designation systems for steel -* ▌A1⟩ *Part 1: Steel names* ⟨A1▐

EN 10027-2, *Designation systems for steels - Part 2: Numerical system*

EN 10204, *Metallic products - Types of inspection documents*

▌A1⟩ *deleted text* ⟨A1▐

EN 10240, *Internal and/or external protective coatings for steel tubes - Specification for hot dip galvanized coatings applied in automatic plants*

EN 10241, *Steel threaded pipe fittings*

EN 10242, *Threaded pipe fittings in malleable cast iron*

EN 10246-1, *Non destructive testing of steel tubes - Part 1: Automatic electromagnetic testing of seamless and welded (except submerged arc welded) ferromagnetic steel tubes for verification of hydraulic leak-tightness*

EN 10226-1 *Pipe threads where pressure-tight joints are made on the threads - Part 1: Taper external threads and parallel internal threads - Dimensions, tolerances and designation*

▌A1⟩ EN 10226-2 ⟨A1▐, *Pipe threads where pressure-tight joints are made on the threads - Part 2: Taper external threads and taper internal threads - Dimensions, tolerances and designation*

EN 10266:2003, *Steel tubes, fittings and structural hollow sections - Symbols and definitions of terms for use in product standards*

EN ISO 1461, *Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods (ISO 1461:1999)*

EN ISO 2566-1, *Steel - Conversion of elongation values - Part 1: Carbon and low alloy steels (ISO 2566-1:1984)*

〈A1〉 EN ISO 8491, *Metallic materials - Tube (in full section) - Bend test (ISO 8491:1998)*

EN ISO 8492, *Metallic materials - Tube - Flattening test (ISO 8492:1998)*

EN ISO 9001, *Quality management systems - Requirements (ISO 9001:2000)* 〈A1〉