

# Stainless steel tubes — Dimensions, tolerances and conventional masses per unit length



The European Standard EN ISO 1127:1996 has the status of a  
British Standard

ICS 23.040.10

# Committees responsible for this British Standard

The preparation of this British Standard was entrusted to Technical Committee ISE/8, Steel pipes, upon which the following bodies were represented:

Adhesive Tape Manufacturers' Association  
 British Compressed Air Society  
 British Iron and Steel Producers' Association  
 British Malleable Tubes Fittings Association  
 British Stainless Steel Association  
 British Valve and Actuator Manufacturers' Association  
 British Welded Steel Tube Association  
 Engineering Equipment and Materials Users' Association  
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 Steel Construction Institute  
 Steel Tube Fittings Manufacturers' Technical Association  
 Society of Motor Manufacturers and Traders Ltd.  
 Water Companies Association  
 Water Services Association of England and Wales  
 Co-opted member



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## Contents

	Page
Committees responsible	Inside front cover
National foreword	ii
<hr/>	
Foreword	2
1 Scope	3
2 Normative references	3
3 Dimensions	3
4 Tolerances	3
5 Conventional masses per unit length	3
<hr/>	
Annex A (informative) Bibliography	8
<hr/>	
Table 1 — Tolerances on outside diameter	3
Table 2 — Tolerances on thickness	3
Table 3 — Conventional masses for austenitic stainless steel tubes	4
Table 4 — Conventional masses for ferritic and martensitic stainless steel tubes	6
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## National foreword

This British Standard has been prepared by Technical Committee ISE/8 *Stainless steel tubes — Dimensions, tolerances and conventional masses per unit length*, and is the English language version of EN ISO 1127:1996, published by the European Committee for Standardization (CEN). It is identical with ISO 1127:1992, prepared by ISO/TC 5, Ferrous metal pipes and metallic fittings, of the International Organization for Standardization (ISO) with the active participation of the UK.

It supersedes certain specifications in BS 3600:1976 which are deleted by amendment.

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### Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, the EN title page, pages 2 to 8 and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

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Descriptors: Piping, stainless steels, austenitic steels, ferritic steels, martensitic steels, steel tubes, dimensions, dimensional tolerances, linear density

English version

## Stainless steel tubes — Dimensions, tolerances and conventional masses per unit length

(ISO 1127:1992)

Tubes en acier inoxydable — Dimensions, tolérances et masses linéiques conventionnelles (ISO 1127:1992)

Nichtrostende Stahlrohre — Masse, Grenzabmasse und längenbezogene Masse (ISO 1127:1992)

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European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

**Central Secretariat: rue de Stassart 36, B-1050 Brussels**





## Foreword

The text of the International Standard from Technical Committee ISO/TC 5, Ferrous metal pipes and metallic fittings, of the International Organization for Standardization (ISO) has been taken over as an European Standard by Technical Committee ECISS/TC 29, Steel tubes and fittings for steel tubes, the secretariat of which is held by UNI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 1996, and conflicting standards shall be withdrawn at the latest by October 1996.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

## 1 Scope

This International Standard specifies the diameters, thicknesses, tolerances and conventional masses per unit length of stainless steel tubes.

## 2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards. ISO 5252:1991, *Steel tubes — Tolerance systems*.

## 3 Dimensions

The outside diameters and thicknesses of the tubes specified in this International Standard have been selected from ISO 4200. If thicknesses greater than 14,2 mm are needed, they should be chosen from ISO 4200.

## 4 Tolerances

The tolerances permitted on the outside diameter and thickness of the tubes result from the method of manufacture, the steel types and the heat treatment. The tolerances shall be selected from the values given in Table 1 and Table 2.

### 4.1 Tolerances on outside diameter

See Table 1.

**Table 1 — Tolerances on outside diameter**

Tolerance class	Tolerance on outside diameter
D <sub>1</sub>	± 1,5 % with ± 0,75 mm min.
D <sub>2</sub>	± 1 % with ± 0,5 mm min.
D <sub>3</sub>	± 0,75 % with ± 0,3 mm min.
D <sub>4</sub>	± 0,5 % with ± 0,1 mm min.

The tolerances on outside diameter include ovality.



### 4.2 Tolerances on thickness

See Table 2.

**Table 2 — Tolerances on thickness**

Tolerance class	Tolerance on thickness
T <sub>1</sub>	± 15 % with ± 0,6 mm min.
T <sub>2</sub>	± 12,5 % with ± 0,4 mm min.
T <sub>3</sub>	± 10 % with ± 0,2 mm min.
T <sub>4</sub>	± 7,5 % with ± 0,15 mm min.
T <sub>5</sub>	± 5 % with ± 0,1 mm min.

The tolerances on thickness include eccentricity.

### 4.3 Other tolerances

For tolerances on dimensions other than outside diameter and thickness, reference shall be made to ISO 5252.

## 5 Conventional masses per unit length

The conventional masses per unit length given in Table 3 for austenitic stainless steel tubes are the masses given in ISO 4200 multiplied by a factor of 1,015. This factor assumes an average density for these tubes of 7,97 kg/dm<sup>3</sup>.

The conventional masses per unit length given in Table 4 for ferritic and martensitic stainless steel tubes are the masses given in ISO 4200 multiplied by a factor of 0,985. This factor assumes an average density for these tubes of 7,73 kg/dm<sup>3</sup>.

Table 3 — Conventional masses for austenitic stainless steel tubes

Outside diameter mm			Thickness, mm																			
			1,0	1,2	1,6	2,0	2,3	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8	10,0	11,0	12,5
Series			Conventional mass per unit length, kg/m																			
1	2	3																				
	6		0,125	0,144																		
	8		0,176	0,204																		
	10		0,225	0,264																		
10,2			0,230	0,270	0,344	0,410																
	12		0,275		0,416	0,500																
	12,7		0,293	0,345	0,445	0,536	0,599	0,658	0,711	0,761												
13,5			0,313	0,369	0,477	0,576	0,645		0,769													
		14	0,326		0,496	0,601																
	16		0,376	0,445	0,577	0,701																
17,2			0,406		0,625	0,761	0,858			1,12												
		18	0,425		0,657	0,801																
	19		0,451	0,535	0,697	0,851																
	20		0,476	0,564	0,737	0,901																
21,3			0,509		0,789	0,966		1,22		1,45		1,74										
		22	0,526			1,00																
	25		0,601	0,715	0,937	1,15		1,46														
		25,4		0,727	0,953	1,17		1,48														
26,9			0,649		1,01	1,25		1,58	1,75	1,90		2,29										
		30			1,14	1,40																
	31,8			0,920	1,21	1,49		1,90		2,29		2,78										
	32			0,925		1,50																
33,7			0,818	0,976	1,29	1,58	1,81	2,02		2,45		3,29										
		35		1,02		1,65																
	38			1,11	1,46	1,81		2,30		2,79												
	40			1,17	1,54			2,44														
42,4					1,63	2,02		2,59		3,14	3,49		4,68									
		44,5				2,13		2,73	3,02													

**Table 3 — Conventional masses for austenitic stainless steel tubes**

Outside diameter mm			Thickness, mm																					
			1,0	1,2	1,6	2,0	2,3	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8	10,0	11,0	12,5	14,2	
Series			Conventional mass per unit length, kg/m																					
1	2	3																						
48,3			1,25	1,49	1,87	2,31		2,97		3,61	4,03			5,42										
	51				1,98	2,46		3,15		3,83														
		54			2,10	2,60		3,35																
	57				2,22	2,75			3,93															
60,3					2,35	2,92	3,34	3,76	4,17	4,58	5,11	5,63			7,66									
	63,5				2,48	3,08		3,96		4,83														
	70				2,74	3,40			4,87															
76,1					2,98	3,70	4,25	4,78	5,32		6,54	7,22		8,90										
		82,5				4,03				6,35														
88,9					3,49	4,35	4,98	5,61	6,24	6,86	7,68	8,51			11,7						16,2			
	101,6				4,98				7,17			9,77			13,5						18,8			
114,3					4,52	5,62		7,27	8,09		9,98		12,4				17,1			23,2				
139,7					5,53	6,89		8,92		11,0		13,6		16,8		21,0	23,5				32,5			
168,3					6,68	8,32		10,8		13,2		16,4	18,5	20,4			28,6					43,3		
219,1						10,9		14,1		17,3	19,4	21,5				33,6			42,2			64,7		
273						13,6		17,6		21,6	24,3	26,9				42,0					65,9	81,5		
323,9								20,9		25,7		32,1	35,9	39,9		56,3					78,6	97,4		
355,6								22,9		28,2		35,2		43,8							86,5	94,9		
406,4								26,3		32,3		40,3		50,2							99,3	123		
457										36,3		45,4		56,5							112	139		
508										40,4	45,5			62,9	70,4						137	155		
610										48,6		60,7			84,8	95,2					187	212		
711																	125							
813																		161						
914																			199					
1016																				252				

Table 4 — Conventional masses for ferritic and martensitic stainless steel tubes

Outside diameter mm			Thickness, mm																				
			1,0	1,2	1,6	2,0	2,3	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8	10,0	11,0	12,5	14,2
Series			Conventional mass per unit length, kg/m																				
1	2	3																					
	6		0,121	0,140																			
	8		0,170	0,198																			
	10		0,219	0,256																			
	10,2		0,224	0,262	0,334	0,398																	
	12		0,267		0,404	0,486																	
	12,7		0,285	0,335	0,431	0,520	0,581	0,638	0,690	0,739													
	13,5		0,303	0,359	0,463	0,558	0,625		0,747														
		14	0,316		0,482	0,583																	
	16		0,364	0,431	0,559	0,681																	
	17,2		0,394		0,607	0,739	0,832			1,08													
		18	0,413		0,637	0,777																	
	19		0,437	0,519	0,677	0,825																	
	20		0,462	0,548	0,715	0,875																	
	21,3		0,493		0,765	0,938		1,18		1,41		1,68											
		22	0,510			0,971																	
	25		0,583	0,693	0,909	1,11		1,42															
		25,4		0,705	0,925	1,13		1,44															
	26,9		0,629		0,983	1,21		1,54	1,69	1,84		2,23											
		30			1,10	1,36																	
	31,8			0,892	1,17	1,45		1,84		2,23		2,70											
	32			0,897		1,46																	
	33,7		0,794	0,948	1,25	1,54	1,75	1,96		2,37		3,19											
		35		0,985		1,61																	
	38			1,07	1,42	1,75		2,24		2,71													
	40			1,13	1,50			2,36															
	42,4			1,59	1,96			2,51		3,04	3,39		4,54										

**Table 4 — Conventional masses for ferritic and martensitic stainless steel tubes**

Outside diameter mm			Thickness, mm																				
			1,0	1,2	1,6	2,0	2,3	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8	10,0	11,0	12,5	14,2
Series			Conventional mass per unit length, kg/m																				
1	2	3																					
		44,5																					
48,3			1,21	1,45	1,81	2,25		2,89		3,51	3,91			5,26									
	51				1,92	2,38		3,05		3,71													
		54			2,04	2,52		3,25															
	57				2,16	2,67			3,81														
60,3					2,29	2,84	3,24	3,64	4,05	4,44	4,95	5,47			7,44								
	63,5				2,40	2,98		3,84		4,69													
	70				2,66	3,30			4,73														
76,1					2,90	3,60	4,13	4,64	5,16		6,34	7,00		8,64			11,9						
		82,5			3,91					6,17													
88,9					3,39	4,23	4,84	5,45	6,06	6,66	7,46	8,25			11,3			15,8					
	101,6				4,84				6,95		9,49				13,1			18,2					
114,3					4,38	5,46		7,05	7,85		9,68		12,0			16,5			22,6				
139,7					5,37	6,69		8,66		10,6		13,2		16,4		20,4	22,9			31,5			
168,3					6,48	8,08		10,4		12,8		16,0	17,9	19,8			27,8			42,1			
219,1					10,5			13,7		16,7	18,8	20,9				32,6		41,0				62,7	
273					13,2			17,0		21,0	23,5	26,1				40,8				63,9		79,1	89,2
323,9								20,3		24,9		31,1	34,9	38,7			54,7				76,2		94,6
355,6								22,3		27,4		34,2		42,6						83,9	92,1	104	
406,4								25,5		31,3		39,1		48,8						96,3		119	
457										35,3		44,0		54,9						108		135	153
508										39,2	44,1			61,1	68,4						133	151	170
610										47,2		58,9			82,2	92,4					181	206	
711																	121						
813																		157					
914																			193				
1 016																				244			

## Annex A (informative) Bibliography

[1] ISO 4200:1991, *Plain end steel tubes, welded and seamless — General tables of dimensions and masses per unit length.*





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