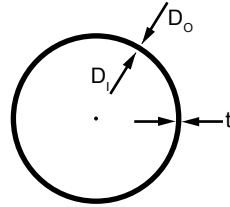


Rolled and Welded Pipe



APPROXIMATE VALUES	
Pipe Weight (lbs/ft) = 10.69*t*(D _o -t)	D _o (in) - outside diameter
	t (in) - thickness of pipe
Pipe Weight (kg/m) = 0.0247*t*(D _o -t)	D _o (mm) - outside diameter
	t (mm) - thickness of pipe

PIPE WEIGHT lbs/ft (kg/m)														
Outside Diameter (D _o) in mm	Wall Thickness (t) in (mm)													
	0.250 6.35	0.312 7.92	0.375 9.52	0.438 11.13	0.500 12.70	0.562 14.27	0.625 15.87	0.688 17.48	0.750 19.05	0.875 22.22	1.000 25.40	1.250 31.75	1.375 34.92	1.50 - 2.25 38.10 - 57.15
24 609.6	63.47 94.47	79.01 117.59	94.71 140.96	110.32 164.20	125.61 186.95	140.81 209.58	156.18 232.44	171.46 255.18	186.41 277.44					
30 762.0	79.51 118.34	99.02 147.37	118.76 176.76	138.42 206.01	157.68 234.68	176.86 263.23	196.26 292.11	215.58 320.86	234.51 349.04	272.43 405.47	310.01 461.41			
36 914.4	95.54 142.20	119.03 177.16	142.81 212.56	166.51 247.83	189.75 282.41	212.91 316.88	236.35 351.77	259.71 386.54	282.62 420.64	328.55 489.00	374.15 556.87	464.35 691.12		
42 1066.8	111.58 166.07	139.04 206.94	166.87 248.35	194.61 289.64	221.82 330.15	248.95 370.53	276.44 411.44	303.84 452.22	330.73 492.23	384.68 572.53	438.30 652.34	544.53 810.45	597.14 888.76	Max. wall thickness of 1.50" (38.1mm). Please call for weight.
48 1219.2	127.61 189.93	159.05 236.73	190.92 284.15	222.70 331.45	253.89 377.88	285.00 424.18	316.53 471.10	347.97 517.90	378.83 563.83	440.80 656.06	502.44 747.80	624.71 929.78	685.34 1020.02	
54 1371.6	143.65 213.80	179.07 266.51	214.97 319.95	250.79 375.61	285.96 425.61	321.05 477.83	356.62 530.77	392.10 583.58	426.94 635.43	496.92 739.59	566.58 843.26	704.88 1049.11	773.53 1151.28	Max. wall thickness of 1.625" (41.3mm). Please call for weight.
60 1524.0	159.68 237.66	199.08 296.30	239.02 355.75	278.89 415.08	318.03 473.34	357.10 531.48	396.70 590.43	436.23 649.26	475.04 707.03	553.05 823.13	630.72 938.73	785.06 1168.44	861.73 1282.54	
66 1676.4	175.72 261.53	219.09 326.08	263.08 391.55	306.98 456.89	350.10 521.07	393.14 585.13	436.79 650.10	480.35 714.94	523.15 778.63	609.17 906.66	694.86 1034.19	865.23 1287.77	949.92 1413.81	Max. wall thickness of 1.75" (44.4mm). Please call for weight.
72 1828.8	191.75 285.40	239.10 355.87	287.13 427.35	335.07 498.70	382.17 568.80	429.19 638.78	476.88 709.76	524.49 780.62	571.25 850.22	665.29 990.19	759.00 1129.65	945.41 1407.10	1038.11 1545.07	
78 1981.2	207.79 309.26	259.11 385.65	311.18 463.15	363.17 540.52	414.24 616.54	465.24 692.43	516.97 769.43	568.62 846.30	619.36 921.82	721.42 1073.72	823.14 1225.12	1025.59 1526.42	1126.31 1676.33	Max. wall thickness of 2.00" (50.8mm). Please call for weight.
84 2133.6	223.82 333.13	279.13 415.44	335.24 498.95	391.26 582.33	446.31 664.27	501.28 746.08	557.06 829.09	612.74 911.98	667.47 993.42	777.54 1157.25	887.28 1320.58	1105.76 1645.75	1214.50 1807.60	
90 2286.0	239.86 356.99	299.14 445.22	359.29 534.75	419.35 624.14	478.38 712.00	537.33 799.73	597.14 888.76	656.87 977.65	715.57 1065.02	833.66 1240.78	951.42 1416.04	1185.94 1765.08	1302.69 1938.86	Max. wall thickness of 2.25" (57.1mm). Please call for weight.
96 2438.4	255.90 380.86	319.15 475.01	383.34 570.54	447.45 665.96	510.45 759.73	573.38 853.38	637.23 948.42	701.00 1043.33	763.68 1136.61	889.79 1324.31	1015.56 1511.51	1266.11 1884.41	1390.89 2070.12	
102 2590.8	271.93 404.73	339.16 504.79	407.39 606.34	475.54 707.77	542.52 807.46	609.43 907.03	677.32 1008.09	745.13 1109.01	811.78 1208.21	945.91 1407.84	1079.70 1606.97	1346.29 2003.74	1479.08 2201.38	Max. wall thickness of 2.5" (63.5mm). Please call for weight.
108 2743.2	287.97 428.59	359.17 534.58	431.45 642.14	503.64 749.58	574.60 855.20	645.47 960.69	717.41 1067.75	789.26 1174.69	859.89 1279.81	1002.03 1491.37	1143.85 1702.44	1426.47 2123.07	1567.27 2332.65	
114 2895.6	304.00 452.46	379.19 564.36	455.50 677.94	531.73 791.40	606.67 902.93	681.52 1014.34	757.50 1127.42	833.39 1240.37	907.99 1351.41	1058.16 1574.90	1207.99 1797.90	1506.64 2242.40	1655.47 2463.91	Max. wall thickness of 2.75" (70.1mm). Please call for weight.
120 3048.0	320.04 476.32	399.20 594.14	479.55 713.74	559.82 833.21	638.74 950.66	717.57 1067.99	797.58 1187.08	877.52 1306.05	956.10 1423.01	1114.28 1658.43	1272.13 1893.36	1586.82 2361.73	1743.66 2595.17	
126 3200.4		419.21 623.93	503.61 749.54	587.92 875.02	670.81 998.39	753.61 1121.64	837.67 1246.75	921.65 1371.73	1004.21 1494.60	1170.40 1741.96	1336.27 1988.83	1666.99 2481.06	1831.86 2726.43	Max. wall thickness of 3.00" (76.2mm). Please call for weight.
132 3352.8		439.22 653.71	527.66 785.34	616.01 916.84	702.88 1046.12	789.66 1175.29	877.76 1306.41	965.78 1437.41	1052.31 1566.20	1226.53 1825.49	1400.41 2084.29	1747.17 2600.39	1920.05 2857.70	
138 3505			551.71 821.14	644.10 958.65	734.95 1093.85	825.71 1228.94	917.85 1366.08	1009.90 1503.09	1100.42 1637.80	1282.65 1909.03	1464.55 2179.75	1827.35 2719.75	2008.24 2988.96	Max. wall thickness of 3.25" (82.5mm). Please call for weight.
144 3657.6			575.76 856.94	672.20 1000.46	767.02 1141.59	861.76 1282.59	957.94 1425.74	1054.03 1568.77	1148.52 1709.40	1338.77 1992.56	1528.69 2275.22	1907.52 2839.05	2096.44 3120.22	
150 3810.0			599.82 892.73	700.29 1042.28	799.09 1189.32	897.80 1336.24	998.02 1485.41	1098.16 1634.44	1196.63 1780.99	1394.90 2076.09	1592.83 2370.68	1987.70 2958.38	2184.63 3251.48	Max. wall thickness of 3.5" (88.9mm). Please call for weight.
156 3962.4			623.87 928.53	728.39 1084.09	831.16 1237.05	933.85 1389.89	1038.11 1545.07	1142.29 1700.12	1244.73 1852.59	1451.02 2159.62	1656.97 2466.15	2067.77 3077.71	2272.82 3382.75	
162 4114.8				756.48 1125.90	863.23 1284.78	969.90 1443.54	1078.20 1604.73	1186.42 1765.80	1292.84 1924.19	1507.14 2243.15	1721.11 2561.61	2148.05 3197.04	2361.02 3514.01	Max. wall thickness of 3.75" (95.3mm). Please call for weight.
168 4267.2				784.57 1167.71	895.30 1332.51	1005.94 1497.19	1118.29 1664.40	1230.55 1831.48	1340.94 1995.79	1563.27 2326.68	1785.25 2657.07	2228.23 3316.37	2449.21 3645.27	
169-204 4293 - 5182	Please call for weight.													

Rolled and Welded Pipe

Steel Pipe Specification

When specifying steel pipe it is important to note that there are often multiple ASTM specifications involved. Steel plate, for the production of rolled and welded pipe, is often manufactured to specifications like A36, A572, & A709.

Pipe manufacturing is different from steel grade and falls under specifications like A139 and A252. These specifications control the manufacturing tolerances of the pipe.

If the designer requires a steel grade that is more specific than the requirements that are described in A252 or other pipe manufacturing specifications it would be acceptable to specify steel pipe like below.

A252 Gr. 3 with physical and chemical requirements that meet A572 Gr. 55

Pipe Manufacturing Specifications

ASTM	YIELD STRENGTH		ASTM	YIELD STRENGTH	
	ksi	MPa		ksi	MPa
A 139 Grade A	30	205	A 252 Grade 1	30	205
A 139 Grade B	35	240	A 252 Grade 2	35	240
A 139 Grade C	42	290	A 252 Grade 3	45	310
A 139 Grade D	46	315	A 252 Grade 3 (Mod)	50	345
A 139 Grade E	52	360			

Highlighted fields represent the most commonly used and readily available steel grades. Additional grades available upon request.

Steel Specification

ASTM	YIELD STRENGTH		ASTM	YIELD STRENGTH	
	ksi	MPa		ksi	MPa
A 36	36	250	A 516 Grade 55	30	205
A 572 Grade 42	42	290	A 516 Grade 60	32	220
A 572 Grade 50	50	345	A 516 Grade 65	35	240
A 572 Grade 55	55	380	A 516 Grade 70	38	260
A 572 Grade 60	60	415			
A 572 Grade 65	65	450			
A 588	50	345			

Additional Capabilities

Installation of:

Bands, Cutting Shoes, End Plates, Carbide Teeth, Rolled Channel and Angle Iron, Twisting Slots, Picking Eyes, Lifting Lugs, etc.

Fabrication of Segmented Fittings:

Elbows, Wyes, Laterals, Tees, Concentric and Eccentric Reducers.

Manufacturers of concentric tapered pipe from .250" to 2" wall thickness.

Pipe manufactured to American Welding Society standards. Structural welding code AWS D1.1 or D1.5 is also available.

Delivery Conditions & Tolerances

	ASTM
Outside Diameter	± 1%
Weight/Thickness	Per Specification
Length	± 1 in.

Maximum Rolled Lengths*

Rolled & Welded	120 ft.	36.6 m
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* Longer lengths may be possible upon request.