AMTP KARVINÁ | TECHNICAL DATA SHEET

EN 10255

Non-alloy steel tubes suitable for welding and threading

ArcelorMittal
Europe – Tubular Products

PRODUCT
Longitudinally welded circular steel tubes
L, M and H series

GRADE / PROCESS
S195T · welded (W)
Cold formed or hot stretch reduced.

DIMENSIONAL RANGE
Ø 13.5–114.3 mm
Nominal thread sizes 1/4”–4”

PRODUCT RANGE AND KEY FEATURES

Standard	EN 10255:2004 + A1:2007
Steel grade	S195T
Manufacturing process	Longitudinally welded tubes; cold forming and hot stretch reduction available at Karviná, depending on dimensions and specification.
Delivery condition	Black / bare, painted or galvanized.
Ends	Plain ends; Victaulic-type grooved and threaded ends available depending on process and dimensions.
Standard lengths	6 m or 12 m; cut-to-length on request, subject to technical review.
Testing / inspection	100% of tubes inspected, with inspection documents in accordance with the agreed order specification. EN 10204 certificate type to be confirmed at quotation / order stage.
Typical applications	Industrial piping, heating installations, fluid conveyance, distribution networks and general mechanical construction.

SURFACE FINISHES AND COATING OPTIONS

Option	Description	Typical use	Order specification
Black / bare	Uncoated steel surface in the as-manufactured condition.	Further processing, indoor use or protection applied by the customer.	Confirm oiling, marking and packaging requirements.
Painted / CCT	Coloured organic coating applied at the factory on Karviná’s coating lines.	Identification, protection during handling and decorative finish.	Colour, paint system, thickness and performance to be agreed; subject to factory feasibility and minimum order quantity.
Galvanized	Hot-dip galvanized tube option.	Enhanced corrosion protection in exposed or damp environments.	Galvanizing specification, coating class, end condition and post-treatment to be agreed.

Important: Coating availability depends on dimensions and process. Final feasibility, minimum quantity, colour, coating thickness, corrosion category and warranty conditions must be confirmed by the Karviná plant before order acceptance.

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AMTP KARVINÁ | DIMENSIONAL PROGRAMME

EN 10255 – L, M and H series

Standard nominal dimensions in Karviná's Ø 13.5–114.3 mm range

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DIMENSIONS AND THEORETICAL MASS – BARE PLAIN-END TUBES

Nominal size	Thread R	O.D. mm	L wall mm	L kg/m	M wall mm	M kg/m	H wall mm	H kg/m
DN 8	**1/4**	**13.5**	2.0	0.567	2.3	0.641	2.9	0.765
DN 10	**3/8**	**17.2**	2.0	0.750	2.3	0.839	2.9	1.020
DN 15	**1/2**	**21.3**	2.3	1.080	2.6	1.210	3.2	1.440
DN 20	**3/4**	**26.9**	2.3	1.400	2.6	1.560	3.2	1.870
DN 25	**1**	**33.7**	2.9	2.200	3.2	2.410	4.0	2.940
DN 32	**1 1/4**	**42.4**	2.9	2.820	3.2	3.100	4.0	3.800
DN 40	**1 1/2**	**48.3**	2.9	3.250	3.2	3.570	4.0	4.380
DN 50	**2**	**60.3**	3.2	4.510	3.6	5.030	4.5	6.190
DN 65	**2 1/2**	**76.1**	3.2	5.750	3.6	6.430	4.5	7.930
DN 80	**3**	**88.9**	3.2	6.760	4.0	8.370	5.0	10.300
DN 100	**4**	**114.3**	3.6	9.830	4.5	12.200	5.4	14.500

TECHNICAL REQUIREMENTS – SUMMARY

Characteristic	Requirement / EN 10255 reference	Details of Karviná's offer
Mechanical properties – S195T	Minimum yield strength: 195 MPa; tensile strength: 320–520 MPa; minimum elongation: 20%.	Depending on the inspection document ordered and the production process.
Chemical composition – S195T	C ≤ 0.20%; Mn ≤ 1.40%; P ≤ 0.035%; S ≤ 0.030%.	Cast analysis / inspection basis in accordance with EN 10255 and order requirements.
Wall thickness tolerance	L, M and H series: ±10%.	Applies to the specified wall thickness, subject to the provisions of the standard.
Leak tightness	Tube integrity verified using the applicable EN 10255 test method.	Test method and certificate level to be confirmed when ordering.
Marking	Standard identification including the manufacturer, EN 10255, series, process symbol W, cast / batch and dimensions as agreed.	Customer-specific marking can be considered.

ORDER CHECKLIST

☐ series (L / M / H) and dimensions ☐ length and end finish
☐ black, painted / CCT or galvanized surface ☐ colour / coating system and required performance
☐ inspection document ☐ marking, bundling and quantity tolerance

Technical note: This customer-facing data sheet presents the product family and Karviná's capabilities. It does not replace EN 10255, the plant's quotation, the order acknowledgement or the applicable inspection certificate. Dimensions, coatings and end finishes remain subject to confirmation by the plant.