

# DIN EN 10255:2007-07 (Englisc h)

## Non-alloy steel tubes suitable for welding and threading - Technical delivery conditions (includes Amendment A1:2007)

---

<b>Contents</b>		<b>Page</b>
Foreword .....		4
1	Scope .....	5
2	Normative references .....	5
3	Terms and definitions .....	6
4	Classification and designation .....	6
5	Information to be obtained from the purchaser .....	6
5.1	Mandatory information .....	6
5.2	Options .....	6
5.3	Examples of ordering .....	7
5.3.1	By outside diameter and thickness .....	7
5.3.2	By thread size and series .....	7
6	Manufacturing process .....	7
6.1	Steelmaking process .....	7
6.2	Tube manufacturing process .....	7
7	Delivery conditions .....	8
7.1	General .....	8
7.2	Alternative finishes and protection of the tube ends .....	8
7.3	Suitability for hot dip galvanizing .....	8
7.4	Hot dip galvanized condition .....	8
8	Requirements .....	8
8.1	General .....	8
8.2	Chemical composition and mechanical properties .....	9
8.3	Appearance .....	9
8.4	Dimensions, masses and tolerances .....	9
8.5	Leak tightness .....	11
8.6	Dangerous substances .....	11
8.7	Reaction to fire .....	12
9	Inspection .....	12
9.1	Type of inspection .....	12
9.2	Inspection documents .....	12
9.3	Tensile test .....	12
9.4	Bend test .....	12
9.5	Flattening test .....	13
9.6	Leak tightness test .....	13
9.7	Dimensional inspection .....	13
9.8	Visual examination .....	13
10	Marking .....	13
11	Temporary protective coating .....	14
12	Evaluation of conformity .....	14

12.1	General .....	14
12.2	Initial type testing (ITT) .....	14
12.2.1	General .....	14
12.2.2	Characteristics .....	15
12.2.3	Product families .....	15
12.2.4	Use of historical data .....	15
12.2.5	Deemed to satisfy' provisions and use of reference tabulated data .....	15
12.2.6	Sampling .....	15
12.3	Factory production control (FPC) .....	15
12.3.1	General .....	15
12.3.2	Equipment .....	16
12.3.3	Raw materials and components .....	16
12.3.4	Product testing and evaluation .....	16
12.3.5	Inspection .....	16
12.3.6	Non-conforming products .....	16
Annex A (informative) Correlation between specified outside diameter, thread size, and nominal diameter .....		17
Annex B (normative) Types of tubes with wall thickness different from medium and heavy series ...		18
B.1	General .....	18
B.2	Requirements .....	18
B.3	Marking .....	18
Annex ZA (informative) !!!!Clauses of this European Standard addressing the provisions of the EC Construction Products Directive for applications covered by Mandate M/131 .....		20
ZA.1	Scope and relevant characteristics .....	20
ZA.2	Procedure for attestation of conformity of pipes .....	21
ZA.2.2	Declaration of conformity .....	22
ZA.3	CE marking and labelling .....	23