

GOST 13663-86 STEEL SECTION PIPE TECHNICAL REQUIREMENTS

Pipe to this standard shall be hot-finished, cold-drawn, extruded and electric welded, of carbon and alloy steel grades.

Pipe shall have either mechanical properties specified (grade A) or mechanical properties and chemical composition guaranteed by the manufacturer (grade B).

Mechanical properties of section pipe shall conform to the requirements of GOST 380-88.

Section pipe shall be delivered in heat treated condition or without heat treatment; mechanical properties of pipe without heat treatment are subject to agreement.

Heat treated pipe shall have mechanical properties given in Table 1.

Table 1 Mechanical Properties

Марка стали Steel grade	Временное сопротивление разрыву, кгс/мм ² Yield limit, kg/mm ²	Предел текучести, кгс/мм ² Tensile strength, kg/mm ²	Относительное удлинение, % Elongation, %
	не менее (not lower)		
Ст2, 10	21	34	24
Ст4, 20	25	40	20
35	30	52	18
45	33	56	14

Mechanical properties of section pipe produced of steel grades 15H, 20H, 40H, 30HGSA, 15HM and 12H1MF are subject to agreement.

Pipe surface shall be free of cracks, excessive scale, laps and tears.

Insignificant scale, scratches, indentations and grinding marks are permissible provided they do not result in wall thickness lower than that specified. Electric welded pipe may weld bead traces on the inside surface. On agreement pipe may be descaled.

Pipe ends shall be cut square.

Pipe for pressure uses shall withstand hydraulic test pressures calculated from the formulas given elsewhere.

Pipe in a lot shall be visual-inspected and measured; pipe quantity in a lot is given below:

OD<30 mm	500 pcs.
70>OD>30 mm	200 pcs.
OD>70 mm	100 pcs.

Chemical composition of section pipe metal shall be certified by the sheet metal supplier.

Tensile test shall be carried out by using longitudinal specimens taken from two pipe lengths in a lot to GOST 10006-73.

Other requirements are given in respective standards or specially developed specifications.