

## GOST 19277-73 SEAMLESS STEEL TUBES FOR OIL AND FUEL LINES

Size range of the tubes is given in Table 1.

Table 1 Size range of seamless steel tubes for oil and fuel lines

Out- side dia- me- ter, mm	Wall thickness, mm	Limit tole- rances for diameter, mm, for		Out- side dia- me- ter, mm	Wall thickness, mm	Limit tole- rances for diameter, mm, for	
		usual	impro- ved ac- curacy			usual	impro- ved ac- curacy
1	2	3	4	5	6	7	8
4	0.5; 0.6; 0.7; 0.8	±0.15	±0.10	28	0.5; 0.6; 0.8; 0.9; 1.0; 1.2; 1.4; 1.5; 1.6; 1.8; 2.0	±0.20	±0.15
5	0.5-0.8						
6	0.5-0.8; 0.9; 1.0; 1.2; 1.4						
7	0.5-1.4; 1.5			30	0.5-3.0		
8	0.5-1.5; 1.6; 1.8; 2.0						
9	0.5-2.0			32	0.5-3.0	±0.30	±0.20
10	0.5-2.0			34	0.5-3.0		
11	0.5-2.0			35	0.5-3.0		
12	0.5-2.0			36	0.5-3.0		
13	0.5-2.0			38	0.5-3.0		
14	0.5-2.0			40	0.5-3.0		
15	0.5-2.0						
16	0.5-2.0			42	1.0-3.0	±0.40	±0.30
17	0.5-2.0			45	1.0-3.0		
18	0.5-2.0			48	1.0-3.0		
				50	1.0-3.0		

Продолжение табл. 1.				Table 1 (contd.)			
1	2	3	4	5	6	7	8
19	0.5-2.0	±0.20	±0.15	53	1.0-3.0	±0.40	±0.30
20	0.5-2.0			56	1.0-3.0		
21	0.5-2.0			60	1.0-3.0		
22	0.5-2.0; 2.2; 2.5;			63	1.0-3.0		
	2.8; 3.0			65	1.0-3.0		
24	0.5-3.0			70	1.0-3.0		
25	0.5-3.0						
27	0.5; 0.6; 0.8;						
	0.9; 1.0; 1.2; 1.5						

Note.

Limit tolerances for dimensions are given for tubes of steel grades 20A, 30HGSA, 30HGSA-VD, 12H18N10T, 12H18N10T-VD, 08H18N10T, 08H18N10T-VD.

Tube length shall be random from 1.5 m to 7 m, specified within random length, multiple within random with 5 mm allowance per cut. Limit deviations of tube length within specified and multiple length shall be under +10 mm.

Limit tolerances for wall thickness are given in Table 2.

Table 2 Limit tolerances for wall thickness of tubes for oil and fuel lines

Wall thickness, mm	Limit tolerances, mm, for	
	usual accuracy	improved accuracy
≤ 0.8	± 0.10	± 0.05
> 0.8	± 10*	± 7.5*
0.5-0.6	(+0.10) - (-0.05)	± 0.05
0.6-0.9	(+0.15) - (-0.05)	(+0.10) - (-0.05)
> 0.9	(+15) - (-7.5)*	(+10) - (-7.5)*
* - Предельные отклонения в %.      * - Limit tolerances are given in %.		

Note.

Limit tolerances for dimensions are given for tubes of steel grades 20A, 30HGSA, 30HGSA-VD, 12H18N10T, 12H18N10T-VD, 08H18N10T, 08H18N10T-VD.

Tube curvature per meter length for tubes of steel grades 20A, 30HGSA, 30HGSA-VD, shall be under 1 mm; for tubes of steel grades 12H18N10T, 12H18N10T-VD, 08H18N10T, 08H18N10T-VD shall be under 1.5 mm.

Tubes to this standard shall be manufactured from peeled steel billets.

Tubes shall be delivered heat treated; tube ends shall be cut square and deburred. On the buyer's request tubes of corrosion-resistant steel grades shall be delivered electropolished or with ground outside and electropolished inside surfaces. Tubes of steel grades 20A, 30HGSA, and 30HGSA-VD shall have ground surfaces.

On agreement tube surfaces shall not be ground.

Other properties.

Tubes to this standard shall withstand hydraulic test pressure which shall not be over 19.6 MPa.

Tubes shall undergo an intercrystalline corrosion test, an expansion test (10 percent diameter increase) and a flattening test. On the buyer's request tubes shall undergo a bending test.