

GOST 800-78 BEARING TUBES

This standard specifies the size range and requirements to hot-finished bearing tubes.

Size range.

Hot-finished bearing tubes shall be delivered with machined outside surface; tube diameter is 70 to 204mm.

Tube sizes are not specified in any detail; this is subject to negotiations between the manufacturer and the buyer.

However, the standard provides for some limitation which result from the manufacturing process: minimum inside diameter of the tubes shall be 48mm and outside diameter to wall thickness ratio (D/t) shall be 4 to 17.

Hot-finished tubes shall have the length of 2 to 5 meters.

Limit tolerances of the outside diameter shall not exceed $+ 0.2$ mm.

Limit tolerances of the wall thickness shall not exceed $+15$ % for tubes with D/t ratio < 11 ; for D/t ratios over 11 the limit tolerance is subject to agreement.

Tube curvature shall not exceed 1 mm per any meter length.

Technical requirements.

Steel grades.

Bearing tubes shall be made of steel grades ShH15, ShH15SG made by conventional and slag remelting methods and having the chemical composition to GOST 801-78.

Mechanical properties.

Bearing tubes undergo numerous machining operations; therefore, the only requirement to their properties is tube metal hardness.

Hot-finished tube must be with a tube metal hardness withing HB 207-187 (diameter of impring 4.2-4.4 mm) for steel grade ShH15, ShH15-Sh and withing HB 217-197 (diameter of impring 4.1-4.3 mm) for steel grade ShH15SG and ShH15SG-Sh.

The bearing hot-finished tube isn't testing.