

GOST 8639-82 STEEL TUBES OF SQUARE CROSS SECTION SIZE RANGE

Tubes to this standard shall be seamless hot-finished, cold-drawn or electric welded of square cross section.

Size range of tubes is given in Table 1.

Table 1 Size range of tubes

Сторона квадрата, мм Side of square, mm	Толщины стенок, мм Wall thickness, mm
10	1.0
15	1.0; 1.5
20	1.0; 1.5; 2.0
25	1.0; 1.5; 2.0; 2.5; 3.0
30	2.0; 2.5; 3.0; 3.5; 4.0
35	2.0; 2.5; 3.0; 3.5; 4.0; 5.0
40	2.5; 3.0; 3.5; 4.0; 5.0; 6.0
42	3.0; 3.5; 4.0; 5.0; 6.0; 7.0
45	3.0; 3.5; 4.0; 5.0; 6.0; 7.0; 8.0
50	3.0; 3.5; 4.0; 5.0; 6.0; 7.0; 8.0
60	3.5; 4.0; 5.0; 6.0; 7.0; 8.0
70	4.0; 5.0; 6.0; 7.0; 8.0
80	4.0; 5.0; 6.0; 7.0; 8.0
90	5.0; 6.0; 7.0; 8.0
100	6.0; 7.0; 8.0; 9.0
110	6.0; 7.0; 8.0; 9.0
120	6.0; 7.0; 8.0; 9.0
140	6.0; 7.0; 8.0; 9.0
150	7.0; 8.0; 9.0; 10.0
180	8.0; 9.0; 10; 10.0; 12.0; 14.0
Трубы специальных размеров Special size tubes	
32	4.0
36	4.0
40	1.5
65	7.0

The radius of angular rounding shall not be over two wall thicknesses.

Tube length shall be random up to 12.5 m (seamless hot-finished) or up to 9 m (cold-drawn or welded); specified within random with maximum allowance +100 mm; multiple within random with 5 mm allowance per cut.

Tolerances for concavity of tube sides are given in Table 2.

Permissible deviations from specified dimensions are given below:

outside diameter:

- hot-finished tubes: $\pm 1.5\%$;
- seamless cold drawn and welded tubes with diameters:
 - up to 30 mm: ± 0.3 mm;
 - 30 to 50 mm: ± 0.4 mm;
 - over 50 mm: ± 0.8 %.

wall thickness:

- hot-finished tubes of normal accuracy: $(+12.5)\text{--}(-15)\%$;
- electric welded tubes: $\pm 10\%$;
- cold drawn (seamless and welded tubes) $\pm 12.5\%$.

Wall thickness variations shall leave tube dimensions within specified tolerances.

Tube wall concavity shall not exceed the values given in Table 2.

Table 2 Tolerances for concavity, mm

Размеры сторон Tube side	Вид труб Tube type	
	бесшовные горяче- деформированные Seamless hot-finished	бесшовные холоднодефор- мированные и электро- сварные Seamless cold-drawn and welded
< 50	0.75	0.5
свыше (from) 50 до (to) 70	1.0	0.75
свыше (from) 70 до (to) 100	1.5	1.0
> 100	2.0	1.0

Deviation of tube cross section from the right angle shall not exceed $\pm 1.5\%$.

Tube curvature per meter length shall be under 2 mm.