

GOST 9567-75 HIGH-ACURACY STEEL TUBES SIZE RANGE

This standard specified the size range and limit tolerances for high-accuracy hot-finished tubes of carbon and low alloy steel. Technical requirements to the tubes are given in GOST 8731-74.

Size range. Tubes to this standard shall be hot-finished, high-accuracy articles with outside diameter 25 to 325 mm, wall thickness 2.5 to 50 mm and length up to 12 meters. For size range and tolerances, see Table 1.

Tubes with the dimensions not specified in the Table above are delivered to other specifications.

Limit tolerances for dimensions are given in Table 1.

For tubes with the dimensions not specified in the Table above, limit tolerances for diameter under 42 mm shall be ± 0.35 mm, for diameters over 219 mm ± 1 %.

Tube length shall be given in the order; it can be random (4 to 12 m), specified (4 to 8 m) and multiple (not over 8 m plus 5 mm allowance per cut).

When requested by the customer, tubes shall be delivered with only one size specified (i.e., diameter or wall thickness).

Tube curvature per meter length shall not exceed 1.5 mm.

To make an order, specify diameter and wall thickness, length, steel grade and other.

Table 1 Size range and limit tolerances of high-accuracy hot-finished seamless tubes

Outside diameter, mm	Wall thickness, mm	Limit tolerances	
		outside diameter	wall thickness
25; 28; 32; 38	2.5; 2.8; 3.0; 3.5; 4.0; 4.5; 5.0; 5.5; 6.0; 6.5; 7.0; 7.7; 8.0	± 0.35 mm	$\pm 10\%$ при толщине стенки до 15 мм включительно;
42; 45; 50	2.5-8.0; 8.5; 9.0; 9.5; 10		for wall thick- ness < 15 mm:
54	3.0-10; 11	± 0.8 %	± 10 %;
57	3.0-11; 12; 13		
60; 63.5	3.0-13; 14		$\pm 8\%$ при толщине
68; 70	3.0-14; 15; 16		стенки более
73; 76	3.0-16; 17; 18; 19		15 мм;

83	3.5-19		for wall thick-
89	3.5-19; 20		ness over 15 mm:
95	3.5-20; 22		±8 %;
102	3.5-22; 24		
108	4.0-24; 25; 26		±6% при толщине
114	4.0-26; 28		стенки от 7 до
121; 127	4.0-28; 30		45 мм с соотно-
133	4.0-30; 32		шением D/S,
140	4.5-32; 34		равным 4-10;
146; 152	4.5-34; 35; 36		for D/t ratios
159	4.5-36; 38		4 to 10 and
168	5.0-38; 40		wall thickness
180	5.0-40; 42		7 to 45 mm :
194	5.0-42; 45		±6 %;
203	6.0-45; 48; 50		
219	6.0-20		при других соот-
			ношениях D/S:
245; 273	6.5-20	1.0 %	для S≤15 ±10 %
299; 325	7.5-20		для S>15 ±8 %
			for other D/t
			ratios:
			for t≤15 ±10 %
			for t>15 ±8 %

Note.

Limit deviations of outside diameter are ±0.5 % for OD 68 to 194 mm incl. at OD/w.t. ratios 4 to 10.