

GOST 9567-75 HIGH-ACCURACY STEEL TUBES.SIZE RANGE

This standard specifies 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 8733-74.

Size range. Tubes to this standard shall be hot-finished, high-accuracy articles with outside diameter 5 to 710 mm, wall thickness 0.2 to 32 mm and length up to 12 meters. For size range and tolerances, see Table below.

Table 1 Size range of high-accuracy steel tubes

OD, mm	Wall thickness, mm	Limit tolerances OD, mm	OD, mm	Wall thickness, mm	Limit tolerances OD, mm
1	2	3	4	5	6
5	0.2; 0.25; 0.3; 0.4; 0.5; 0.8; 1.0; 1.5	±0.10	73	0.8-12.0	±0.35
6	0.2-1.5; 1.8; 2.0		76	0.8-12.0	
7	0.2-2.0; 2.5		80	0.8-12.0	
8	0.2-2.5		83	0.8-12.0	±0.40
9	0.2-2.5		85	0.8-12.0	
10	0.2-2.5; 2.8; 3.0; 3.2; 3.5		89	0.8-12.0	
11	0.2-3.5	±0.10	90	0.8-12.0	±0.45
12	0.2-3.5		95	0.8-12.0	
14	0.2-3.5; 4.0		100	0.8-12.0	
15	0.2-4.0; 4.5; 5.0		102	1.0-12.0; 14.0; 16.0; 18.0	
16	0.2-5.0		108	20.0; 22.0; 24.0; 28.0; 30.0; 32.0	
18	0.2-5.0				
19	0.2-5.0				
20	0.2-5.0; 5.5; 6.0		110	1.0-32.0	±0.50
21	0.2-6.0		120	1.0-32.0	
22	0.2-6.0				

23	0.2-6.0		130	1.0-32.0	-0.8%
24	0.2-6.0		140	1.0-32.0	
25	0.2-6.0; 7.0		150	1.0-32.0	
26	0.2-7.0		160	1.0-32.0	
27	0.2-7.0; 8.0; 9.0		170	1.0-32.0	
28	0.2-7.0		180	1.0-32.0	
30	0.2-8.0		190	1.0-32.0	
+			200	1.0-32.0	
32	0.2-8.0	±0.15	210	1.0-32.0	
34	0.2-8.0		220	1.0-32.0	
35	0.2-8.0		240	1.0-32.0	
36	0.2-8.0		250	1.5-32.0	
38	0.2-8.0; 9.0		273	1.5-32.0	
40	0.2-9.0		325	1.5-32.0	
+			351	1.5-32.0	
42	0.3-9.0	±0.20	377	1.5-32.0	
45	0.3-9.0; 10.0		402	1.5-32.0	
48	0.3-10.0		426	1.5-32.0	
50	0.3-10.0; 12.0		450	1.5-32.0	
+			480	1.5-32.0	
51	0.3-12.0	±0.25	500	1.5-32.0	
53	0.3-12.0		530	2.0-32.0	
54	0.3-12.0		560	2.0-32.0	
56	0.3-12.0		600	2.0-32.0	
57	0.3-12.0		630	2.8-32.0	
60	0.3-12.0		710	2.8-32.0	
+					
63	0.8-12.0	±0.30			
65	0.8-12.0				
68	0.8-12.0				
70	0.8-12.0				
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Notes.

1. Tubes with OD over 273 mm shall be made on agreement.
2. Tubes with OD 102 to 108 mm and w.t. over 14 mm shall be made on agreement.
3. Tubes with OD 110 to 130 mm and w.t. over 22 mm shall be made on agreement.

4. Tubes with OD 140 to 170 mm and w.t. over 24 mm shall be made on agreement.
5. Tubes with OD 180 to 240 mm and w.t. over 28 mm shall be made on agreement.
6. Tubes with OD 100 to 250 mm and OD/w.t. ratio over 50 and under 4 are made on agreement.

Limit tolerances for wall thickness of tubes are given below:

Наружный диаметр, мм Outside diameter, mm	Толщина стенки, мм (Wall thickness, mm)		
	0.2-0.8	0.8-5.0	>5 (over 5)
5-108	±0.05 mm	±7.5%	±6%

Наружный диаметр, мм Outside diameter, mm	Толщина стенки, мм (Wall thickness, mm)		
	<2.5 (lower 2.5)	2.5-5.0	>5 (over 5)
110-250	±10%	(+10)%-(-7.5)%	±7.5%

Limit tolerance for tube length shall be +10 mm.

Curvature of cold-finished tubes per meter length shall not be over 2 mm for tubes with OD under 10 mm and 1.5 mm for tubes with OD over 10 mm.