

**BS 1864-67 STEEL TUBES AND TUBLARS SUITABLE FOR SCREWING TO BS 21 PIPE THREADS****1. SCOPE**

Specification for stainless steel milk pipes and fittings (recessed ring joint type)

| Grade | Mfg. Process | Chemical composition (%) |         |         |          |          |           |           |          |               |
|-------|--------------|--------------------------|---------|---------|----------|----------|-----------|-----------|----------|---------------|
|       |              | C                        | Si      | Mn      | P        | S        | Ni        | Cr        | Mo       | Others        |
| Gr. 1 | S,W          | 0.06Max                  | 0.2~1.0 | 0.5~2.0 | 0.040Max | 0.035Max | 8.0~11.0  | 18.0~20.0 | -        | -             |
| Gr. 2 | S,W          | 0.08Max                  | 0.2~1.0 | 0.5~2.0 | 0.040Max | 0.5Max   | 9.0~11.0  | 18.0~20.0 | -        | -             |
| Gr. 3 | S,W          | 0.08Max                  | 0.2~1.0 | 0.5~2.0 | 0.040Max | 0.035Max | 8.0~11.0  | 17.0~19.0 | -        | Ti : 5×C~0.70 |
| Gr. 4 | S,W          | 0.08Max                  | 0.2~1.0 | 0.5~2.0 | 0.040Max | 0.030Max | 10.0~13.0 | 17.0~19.0 | -        | Ti : 5×C~0.70 |
| Gr. 5 | S,W          | 0.07Max                  | 0.2~0.8 | 0.5~2.0 | 0.040Max | 0.035Max | 10.0~13.0 | 16.5~18.5 | 2.25~3.0 | -             |
| Gr. 6 | S,W          | 0.08Max                  | 1.50Max | 1.0~2.0 | 0.040Max | 0.030Max | 11.0~14.0 | 16.5~18.5 | 2.5~3.0  | -             |
| Gr. 7 | S,W          | 0.08Max                  | 1.50Max | 2.0Max  | 0.040Max | 0.5Max   | 80Min     | 17.0~21.0 | -        | -             |
| Gr. 8 | S,W          | 0.08Max                  | 1.50Max | 2.0Max  | 0.050Max | 0.5Max   | 80Min     | 17.0~20.0 | 2.0~3.0  | -             |
| Gr. 9 | S,W          | 0.08Max                  | -       | 2.0Max  | 0.040Max | 0.040Max | 80Min     | 17.0~20.0 | 2.0~3.0  | -             |

| Grade | Tensile Test MPa or N/mm <sup>2</sup> |                  | Remarks<br>(Similar to JIS) |
|-------|---------------------------------------|------------------|-----------------------------|
|       | Min Yield point                       | Tensile Strength |                             |
| Gr. 1 | -                                     | -                | (SUS304TBS)v                |
| Gr. 2 | -                                     | -                | Free Cutting Steel          |
| Gr. 3 | -                                     | -                | -                           |
| Gr. 4 | -                                     | -                | -                           |
| Gr. 5 | -                                     | -                | (SUS316TBS)                 |
| Gr. 6 | -                                     | -                | (SUS31678BS)                |
| Gr. 7 | -                                     | -                | Free Cutting Steel          |
| Gr. 8 | -                                     | -                | Free Cutting Steel          |
| Gr. 9 | -                                     | -                | -                           |

JIS Number and Corresponding Foreign Standards

[illegible]