**Annexure – ‘B’**

**Technical Specification of** GI pipe B Class 150 mm dia 3 mtr long

1. **SCOPE –**

Manufacturing Testing and Supply of GI pipe B Class 150 mm dia NB(Nominal Bore) 3 mtr long as per IS:1239 (latest amendment) screwed and socket type.

1. **Appilicable Standards:**

The manufacturing and testing G.I pipe confirms to IS:1239/2004 and other standards which are given in

**3.1 Black Tube**

Tube as manufactured without any subsequent surface treatment.

**3.2 Nominal Bore**

A size reference denoting the approximate bore of the tube. For each size of tube, the outside diameter is fixed by the corresponding screw thread dimensions of IS 554 and therefore, the actual bore of each size of tube will vary according to the thickness.

**3.3 Plain End**

The end of the tubes shall be finished clean.

**3.4 Bevel End**

The finished tube end shall be with a specified angle and root face as given in IS: 1239 Fig 1

**3.5 Tube, Pipe**

A long, hollow, open-ended object of circular or other cross-section. The term tube is synonymous with the term pipe.

**3.6 Socket**

The screwed coupling utilized in joining the tubes together.

**3.7 Length**

**3.7.1 Random Length**

Normal manufacturing lengths, which may vary over a wide range; alternatively, a length range may be agreed to between the purchaser and the manufacturer.

**3.7.2 Exact Length of Screwed and Socketed Tube**

The length of the tube exclusive of the socket.

**3.7.3 Length of Screwed and Socketed Tube**

The length of the tube inclusive of the socket on one end with handling tight.

NOTE — Handling tight means that the socket is so tight fitted that it should not fall down during handling or transit.

1. **DESIGNATION**

Steel tubes covered by this standard shall be designated by their nominal bore and shall be further classified as light, medium and heavy depending on the wall thickness; and screwed and socketed or plain end/ bevel-end to denote end condition, and black or galvanized to denote surface condition.

**5 SUPPLY OF MATERIALS**

General requirements relating to the supply of steel tubes shall conform to IS 1387.

**6. MANUFACTURE**

6.1 Seamless steel tube shall be made from tested quality steel manufactured by any approved process and shall be fully killed.

6.1.1 Chemical composition of the steel shall comply with of IS:1239.1b/2004Table 1 in Ladle

Sample analysis.

**7. TEST ON TUBES**

All test shall be in accordance to IS 1239 and

1. Tensile Strength
2. Flattening Test
3. Galvanizing Test
4. Uniformity test
5. Adhesion test

**8. MARKING**

1. Each tube shall be marked with manufacturer’s name or trade-mark, IS No. that is, IS 1239 (Part 1) and class of tubes, that is, L, M, and H, for light, medium and heavy class.
2. The different classes of tubes shall be distinguished by colour bands, which shall be applied as follows before the tubes leave the manufacturer’s works:

a) Light tubes—Yellow

b) Medium tubes— Blue

c) Heavy tubes —Red

d)BIS Certification Marking /Standard Marking

**9. PACKING**

Black tubes not otherwise protected shall be varnished or suitably painted externally throughout the length unless ordered unvarnished or unpainted. Where tubes are bundled for transport, all qualities of tubes shall be packed in accordance with IS 4740