

Specification IS:1239 (Part 1) 2004 (Equivalent BIS : 1387 : 1985) for Black Pipes								
NB	OD (MM)	Series	Outside Diameter		Wall Thickness		Nominal Weight	
			Min	Max	MM	SWG	Plain End	
			MM	MM			KG/M	Mtr/Ton
15 mm	21.3	L	21.0	21.4	2.0	14	0.95	1052
		M	21.0	21.8	2.6	12	1.21	826
		H	21.0	21.8	3.2	10	1.44	694
20 mm	26.9	L	26.4	26.9	2.3	13	1.38	725
		M	26.5	27.3	2.6	12	1.56	641
		H	26.5	27.3	3.2	10	1.87	535
25 mm	33.7	L	33.2	33.8	2.6	12	1.98	505
		M	33.3	34.2	3.2	10	2.41	415
		H	33.3	34.2	4.0	8	2.93	341
32 mm	42.4	L	41.9	42.5	2.6	12	2.54	394
		M	42.0	42.9	3.2	10	3.10	322
		H	42.0	42.9	4.0	8	3.79	264
40 mm	48.3	L	47.8	48.4	2.9	11	3.23	310
		M	47.8	48.8	3.2	10	3.56	281
		H	47.9	48.8	4.0	8	4.37	229
50 mm	60.3	L	59.6	60.2	2.9	11	4.08	245
		M	59.7	60.8	3.6	9	5.03	199
		H	59.7	60.8	4.5	7	6.19	161
65 mm	76.1	L	75.2	76.0	3.2	10	5.74	175
		M	75.3	76.6	3.6	9	6.42	156
		H	75.3	76.6	4.5	7	7.93	126
80 mm	88.9	L	87.9	88.7	3.2	10	6.72	149
		M	88.0	89.5	4.0	8	8.36	120
		H	88.0	89.5	4.8	6	9.90	101
100 mm	114.3	L	113.0	113.9	3.6	9	9.75	102
		M	113.1	115.0	4.5	7	12.20	82
		H	113.1	115.0	5.4	5	14.50	69
125 mm	139.7	M	138.5	140.8	4.8	6	15.90	63
		H	138.5	140.8	5.4	5	17.90	56
150 mm	165.1	M	163.9	165.5	4.8	6	18.90	53
		H	163.9	165.5	5.4	5	21.30	47

Tolerance				
A-Thickness	Tolerance	B-Weight	Tolerance	Length Tolerance
Light Series	+ Not Limited - 8%	1. Single Tube (Light)	+10% -8%	Unless Otherwise Specified 4 - 7 Mtrs Can also be Supplied in Fixed Length +-5 cm
Medium & Heavy Series	+ Not Limited - 10%	2. Single Tube (Medium & Heavy)	+10% -10%	
		3. For Qty. 10 M.Ton Min (Medium & Heavy)	+7.5% -7.5%	