

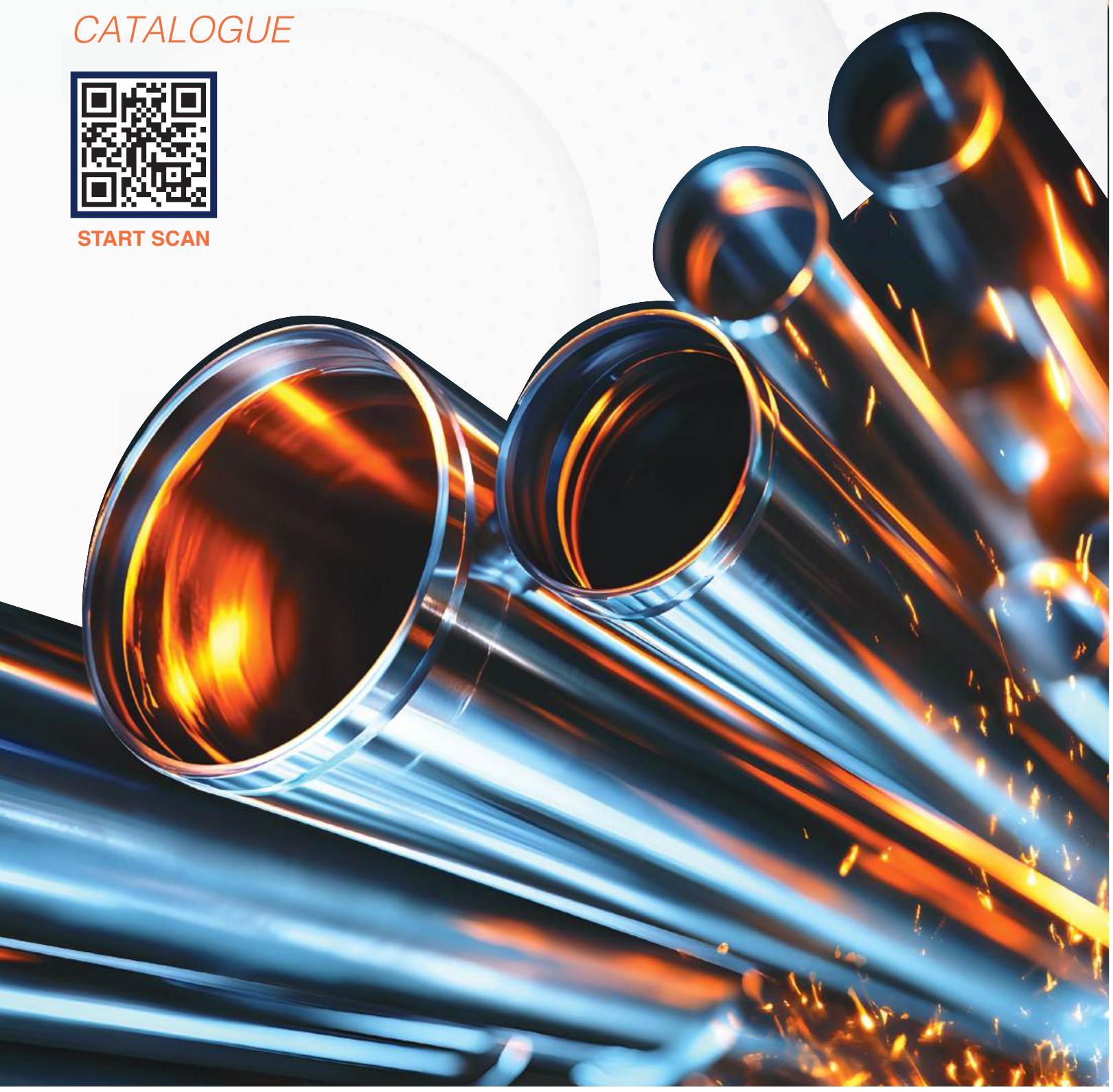


ATLAS BORU PROFIL STEEL

*GENERAL PRODUCT
CATALOGUE*



START SCAN



ERW WATER PIPES



Sizes

Outside Diameter	Wall Thickness	Length
21,3 mm - 339,7 mm 1/2" - 13 3/8"	2,0 mm - 12,7 mm 0,079" - 0,500"	3,00 m - 18,30 m 9,8 ft - 60 ft

Production Standards & Material Qualities

- Production Norms
EN 10224, EN 10255, ISO 65, ASTM A 53, ASTM A 795, ASTM A 589
- Galvanizing Norms
EN 10240, EN ISO 1461 (BS 729), ASTM A 53, NFA 49-700, UNI 5745
- Production Standard for Threading and Coupling (1/2"- 6")
ISO 7/1, ANSI B.1.20.1, EN 10255
- Grooving (3/4"-12") according to Victaulic Standard.
- Our medium series pipes can be guaranteed up to 25 bar operating pressure for water.
- Material Qualities
DIN 17100 St 37, St 44, St 52
EN 10025 S 195, S 235, S 275, S 355, Gr A, Gr B



Tests & Certificates

- Visual and Dimensional Inspection
- Mechanical Tests:
 - Tensile, Flattening, Expanding, Bending
 - Weld Ductility, Fracture Toughness, PP, PE Testing
- Metallographic Examination
 - Purity Analysis
- Chemical Analysis
- Hydrostatic Test
- Non Destructive Inspection:
 - Eddy Current, Ultrasonic Test (Weld Check)
 - Ultrasonic (full body, optional)
- Mill Test Certificates
 - Acc. to EN 10204 2.1; 2.2; 3.1; 3.2
- NDT Standards
 - UT (EN ISO 10893-11 Level U2), ET (EN ISO 10893-2 Level E2), API, EN ISO 3183, CSA Z.245.1

Production Range

OD	Wall Thickness (mm & inch)																							
	mm	2,8	3,0	3,2	3,6	3,68	3,7	4,0	4,5	5,1	5,2	6	6,6	7	7,1	8,1	8,4	8,6	9,0	9,5	10,0	11	12	12,7
mm	inch	0.109	0.113	0.133	0.140	0.145	0.147	0.154	0.179	0.200	0.203	0.237	0.258	0.277	0.280	0.318	0.331	0.337	0.354	0.375	0.394	0.432	0.472	0.500
21,3	1/2	1,28	1,35	1,43	1,57	1,60	1,61	1,71																
26,9	3/4	1,66	1,77	1,87	2,07	2,11	2,12	2,26	2,49															
33,7	1	2,13	2,27	2,41	2,67	2,72	2,74	2,93	3,24	3,60														
42,4	1 1/4	2,73	2,91	3,09	3,44	3,51	3,53	3,79	4,21	4,69	4,77													
48,3	1 1/2	3,14	3,35	3,56	3,97	4,05	4,07	4,37	4,86	5,43	5,53													
60,3	2 3/8	3,97	4,24	4,51	5,03	5,14	5,16	5,55	6,19	6,94	7,07													
73	2 7/8	4,85	5,18	5,51	6,16	6,29	6,32	6,81	7,60	8,54	8,69	9,91	10,81	11,39	11,54									
88,9	3 1/2	5,95	6,35	6,76	7,57	7,73	7,77	8,37	9,37	10,54	10,73	12,27	13,39	14,14	14,32									
114,3	4 1/2		8,23	8,77	9,83	10,04	10,09	10,88	12,18	13,73	13,99	16,02	17,53	18,52	18,77	21,21	21,94	22,42	23,37	24,55				
141,3	5 9/16		10,23	10,90	12,22	12,49	12,55	13,54	15,18	17,13	17,45	20,02	21,92	23,18	23,50	26,61	27,53	28,14	29,36	30,88	32,38			
168,3	6 5/8			13,03	14,62	14,94	15,02	16,21	18,18	20,53	20,91	24,01	26,32	27,84	28,22	32,00	33,12	33,87	35,36	37,20	39,04	42,67		
219,1	8 5/8				19,13	19,55	19,65	21,22	23,81	26,91	27,43	31,53	34,59	36,61	37,12	42,15	43,65	44,64	46,63	49,10	51,56	56,45	61,29	64,64
273	10 3/4							26,53	29,80	33,69	34,34	39,51	43,36	45,92	46,56	52,91	54,81	56,07	58,59	61,73	64,86	71,07	77,24	81,52
323,9	12 3/4							31,55	35,44	40,09	40,87	47,04	51,64	54,70	55,47	63,08	65,35	66,87	69,89	73,65	77,41	84,88	92,30	97,46
339,7	13 3/8								37,20	42,08	42,89	49,37	54,21	57,43	58,23	66,24	68,63	70,22	73,40	77,36	81,30	89,16	96,97	102,41

Threading

114.3 mm≤OD≤323.9 mm: API 5L
(Line Pipe according to API 5B)

Finishing Operations

Plain End-Square cut or bevelled / Zaplok
Black self colored / uncoated
Mill protective coating (black varnish) on outside surface
Epoxy lining and coating (AWWA C210), API RP5L2
3 Layer PE coating (DIN 30670, ISO 21809-1)
3 Layer PP coating (DIN 30678, ISO 21809-1)

Heat Treatment

21.3 mm≤OD≤88,9 mm: full body
114.3 mm≤OD≤323.9 mm: weld seam
21.3 mm≤OD≤168,3 mm: off-line heat treatment.

TUBES FOR PRESSURE PURPOSE / BOILER TUBES



Sizes

Outside Diameter	Wall Thickness	Length
21,3 mm - 339,7mm	2,0 mm - 12,7 mm	5,00 m - 18,30 m
1/2" - 13 3/8"	0,079" - 0,500"	16,40 ft - 60 ft

Please ask for shorter lengths.

Finishing Operations

- Plain End-Square cut or bevelled
- Black self colored/uncoated
- Surface protective coating (black varnished)

Production Standards & Material Qualities

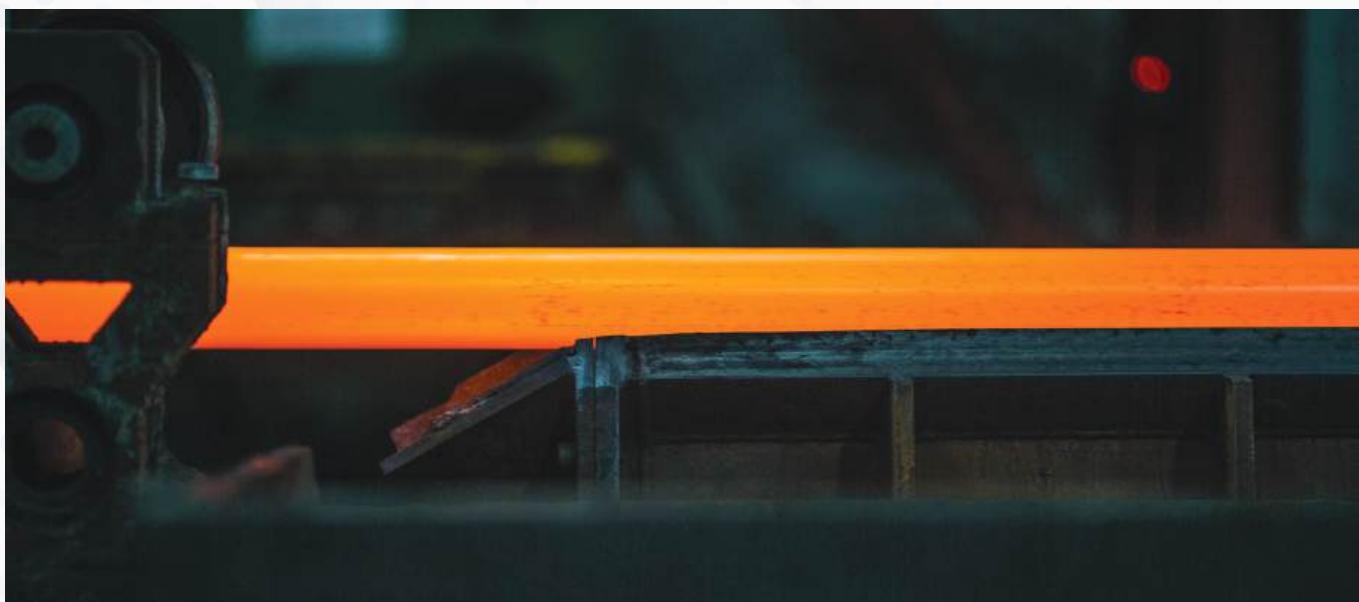
ASTM A 178	GrA, GrC, GrD
EN 10217-1 (BS 3059 Part 1)	P195 TR1/TR2, P235 TR1/TR2, P265 TR1/TR2
EN 10217-2 (BS 3059 Part 2)	P195 GH, P235 GH, P265 GH
EN 10217-3	P355 N, P355 NH

Quality Certificates

AD-2000 WO, AD-2000 W4, PED

NDT Standards

UT (EN ISO 10893-11), ET (EN ISO 10893-2)





Tests & Certificates

- Visual and Dimensional Inspection
- Mechanical Tests:
 - Tensile Test, Flattening Test, Flaring Test
 - Expanding Test
- Metallographic Examination
- Chemical Analysis
- Hydrostatic Test
- Non Destructive Inspection:
 - In-Line Ultrasonic (weld check)
 - Eddy Current
- Mill Test Certificates

Acc. to EN 10204 2.1; 2.2; 3.1; 3.2
 PED Certified-Pressure Equipment Directive 2014/68/eu Certified

Production Range

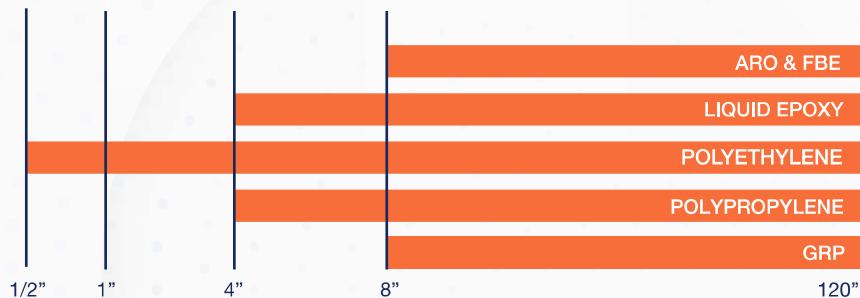
OD mm	Wall Thickness (mm)																								
	2,0	2,3	2,7	2,9	3,0	3,2	3,4	3,6	3,8	4,0	4,2	4,5	4,7	5,0	5,2	5,4	5,5	6,0	6,5	7,0	7,5	8,0	8,5	9,0	9,5
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Please contact our sales department for tolerances.

COATINGS AND LININGS

Scope and Field of Application

Borusan Pipe products are manufactured with modern types of equipment, offering a wide range of anti-corrosive coatings. The below graph illustrates the type of coatings applied externally and internally according to standards and particular customer requirements.



Surface Preparation

The process enabling the appropriate surface cleanliness and smoothness level according to the type of coating is applied by blasting method. (Sa 2 1/2)
(DIN 55928, SIS 55900)

Galvanizing

Especially for water pipes, Borusan Pipe galvanizing operations are currently applied to export U.S. and many European countries.(ASTM A53, TS EN 10240)

Polyethylene - Polypropylene Coating

Excellent protection for buried pipes, high mechanical strength, and corrosion resistance.

Low, medium, or high-density polyethylene or polypropylene coating.

3 Layer Coating Method:

Layer 1: Electrostatic epoxy primer.

Layer 2: Extrusion adhesive wrapping for spiral, an electrostatic adhesive layer for ERW.

Layer 3: Extrusion polyethylene or polypropylene wrapping for spiral, hot extrusion for ERW.

For PE: EN ISO 21809-1 (DIN 30670, NF A 49-710, UNI 9099)

For PP: EN ISO 21809-1 (DIN 30678, NFA 49-711)



Flow-Coat Epoxy Lining

For gas transmission lines, in order to reduce pipe wall roughness, thus increasing throughput. Average thickness 60 µm. (API RP 5L2)

Liquid Epoxy

Various epoxy coatings enable a hygienic inner surface for potable water transportation and an outer surface to resist soil or seawater corrosion. The coating thickness of up to 600 micron. (AWWA C 210, TS 5140, EN 12944-5)

FBE-Fusion Bonded Epoxy

Provides high protection of pipe lines used for oil, gas, and water transmission. (AWWA C 213, API 5L7, CSA Z 245-20, NACE RP 0394)

Abrasion Resistant Overlay ARO

Dual-layer fusion bonded epoxy provides excellent abrasion, impact resistance and also maintains excellent protection for gas-oil line pipes. (AWWA C 213, API 5L7, CSA Z 245-20, NACE RP 0394)

Glass fibre reinforced plastic (GRP) Coating

For buried and HDD line pipes, GRP coating provides excellent mechanical protection.

Tests Performed

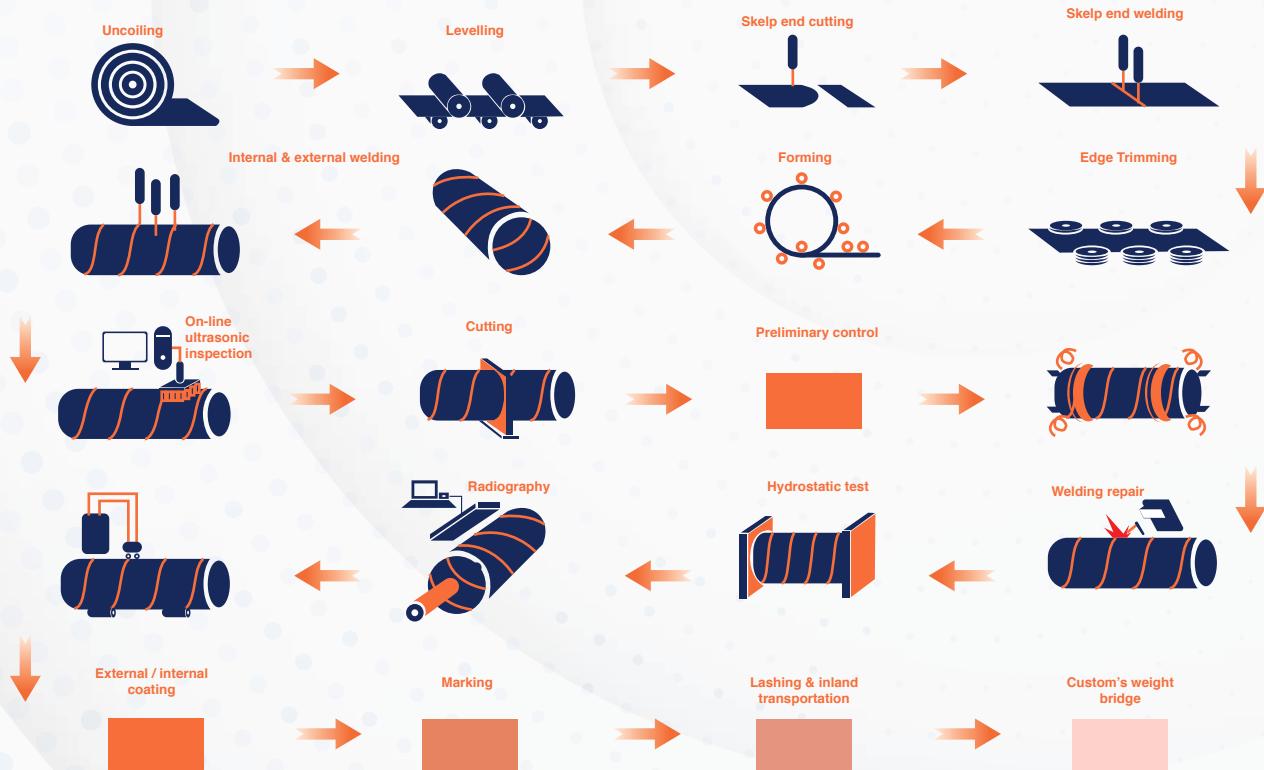
Coating Thickness	MFR and MVR Test	Cross Cut Test
Holiday Testing	CD (Cathodic Disbondment Test)	Epoxy Bend Test
Impact Strength	DSC Test (Differential Scanning Calorimetry test)	V Cut Test
Adhesion Test	Manuel Holiday	FBE Porosity Test
Indentation Strength	Wet Sponge Pinhole Test	Porosity Test
Coating Resistivity	Hot Water Immersion Test	Cross Section Porosity
Elongation Percentage at Break	Buchholz Hardness Test	Low-temperature Flexibility Test
Strain at Break Test	Shore A &Shore D Measurement	Cure & Gel Time Test
	PE/PP Breaking Elongation Test	Moisture Content Test
		FBE Particle Size Test

SPIRALLY WELDED STEEL PIPES

Spirally Welded Steel Pipes Production Process

Our spirally welded pipe production process is meticulously controlled to guarantee superior product quality and performance:

- **Coil Preparation and Slitting:** High-quality steel coils are slit into required widths with precise edge quality to ensure weld integrity.
- **Spiral Forming:** The steel strip is helically formed into pipe shape, offering a wide range of diameters and thicknesses.
- High-strength, uniform welds are created using internal and external SAW techniques.
- **Online Ultrasonic Testing:** Immediate non-destructive testing of weld seams to detect flaws.
- **Hydrostatic Testing:** Each pipe is internally pressurized to verify strength and leak integrity.
- **Beveling and End Finishing:** Pipe ends are prepared for easy joining and welding.
- **Surface Treatment and Coating (Optional):** Pipes are cleaned and coated based on application requirements.

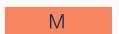
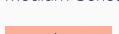


- Water Transmission and Distribution Lines
- Oil and Gas Pipelines
- Offshore and Subsea Installations
- Piling and Structural Foundations
- Port and Marine Structures
- Industrial and Energy Infrastructure Projects

PRODUCTION RANGE (EN 10255)



Outside Diameter (mm)	Nominal Bore (mm)	(inch)	Wall Thickness (mm)									
			2,0	2,3	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,4
21,3	15	1/2	L2	L/L1	M		H					
26,9	20	3/4		L2/L1/L	M		H					
33,7	25	1			L2	L/L1	M		H			
42,4	32	1 1/4			L2	L/L1	M		H			
48,3	40	1 1/2				L2/L/L1	M		H			
60,3	50	2				L2	L/L1	M		H		
76,1	65	2 1/2					L2/L/L1	M		H		
88,9	80	3					L2/L	L1	M		H	
114,3	100	4						L2/L	L1	M		H
139,7	125	5							L	M	H	
165,1	150	6							L	M	H	

 H
 Heavy Series
 M
 Medium Series
 L
 Light Series

Unit Weights for Black Plain End Pipes						
Outside Diameter (inch)	Outside Diameter (mm)	Unit Weights L Series (kg/mt)	Unit Weights L1 Series (kg/mt)	Unit Weights L2 Series (kg/mt)	Unit Weights M Series (kg/mt)	Unit Weights H Series (kg/mt)
1/2	21,30	1,08	1,08	0,95	1,21	1,44
3/4	26,90	1,40	1,39	1,38	1,56	1,87
1	33,70	2,20	2,20	1,98	2,41	2,93
1 1/4	42,40	2,82	2,82	2,54	3,10	3,79
1 1/2	48,30	3,25	3,24	3,23	3,56	4,37
2	60,30	4,51	4,49	4,08	5,03	6,19
2 1/2	76,10	5,75	5,73	5,71	6,42	7,93
3	88,90	6,76	7,55	6,72	8,36	10,30
4	114,30	9,83	10,80	9,75	12,20	14,50
5	139,70	15,00			16,60	17,90
6	165,10	17,80			19,80	21,30

Tests & Certificates

- Visual and Dimensional Inspection
- Leak tightness testing: Hydrostatic Test, Eddy Current Test
- Destructive Tests: Flattening, Bending
- Mechanical Tests
- Chemical Analysis
- Metallographic Examination
- Others as required by the standards
- Ultrasonic weld seam test if applicable for gas pipes
- Mill Test Certificates
 - Issued upon request according to EN 10204 2.1; 2.2; 3.1; 3.2
- NDT Standards:
 - ET (EN ISO 10893-2), ET (ASTM E309)
- UKCA Certification

Finishing Operations

- Plain end (square cut or bevelled)
- Threaded and coupled (Max OD: 168.3 mm)
- Grooved
- Outside protective coating (black or red vanished)
 - (Other colors are available upon request.)
- Temporary oil application
- Hot dip galvanizing
- PE, PP Coating
- Bare Pipe (Uncoated)
- Temporary oil application

A795 / A795M



TABLE 1 Dimensions, Weights, and Test Pressure For Light -Weight Fire Protection Pipe- Schedule 10

NPS Designator	DN Designator	Outside Diameter		Nominal Wall Thickness		Weight Plain End		Electric-Resistance-Welded		
		in.	mm	in.	mm	lb/ft	kg/m	kPa	kPa	kPa
3/4	20	1.050	(26.7)	0.083	(2.11)	0.86	(1.28)	(3400)	700	(4800)
1	25	1.315	(33.4)	0.109	(2.77)	1.41	(2.09)	(3400)	700	(4800)
1 1/4	32	1.660	(42.2)	0.109	(2.77)	1.81	(2.69)	(3400)	1000	(6900)
1 1/2	40	1.900	(48.3)	0.109	(2.77)	2.09	(3.11)	(3400)	1000	(6900)
2	50	2.375	(60.3)	0.109	(2.77)	2.64	(3.93)	(3400)	1000	(6900)
2 1/2	65	2.875	(73.0)	0.120	(3.05)	3.53	(5.26)	(3400)	1000	(6900)
3	80	3.500	(88.9)	0.120	(3.05)	4.34	(6.46)	(3400)	1000	(6900)
3 1/2	90	4.000	(101.6)	0.120	(3.05)	4.98	(7.41)	(3400)	1200	(8300)
4	100	4.500	(114.3)	0.120	(3.05)	5.62	(8.37)	(3400)	1200	(8300)
5	125	5.563	(141.3)	0.134	(3.40)	7.78	(11.58)	B	1200	(8300)
6	150	6.625	(168.3)	0.134	(3.40)	9.30	(13.85)	B	1000	(6900)
8	200	8.625	(219.1)	0.188C	(4.78)	16.96	(25.26)	B	800	(5500)
10	250	10.750	(273.1)	0.188C	(4.78)	21.23	(31.62)	B	700	(4800)

TABLE 2 Dimensions,Weights, Test Pressures For Standard-Weight Fire Protection Pipe - Schedule 30 and Schedule 40

NPS Designator	DN Designator	Specified Outside Diameter Sch 30		Nominal Wall Thickness Sch 40		Weight Plain End		Weight Threaded and Coupled		Electric - Resistance - Welded		
		in.	mm	in.	mm	lb/ft	kg/m	lb/ft	kg/m	kPa	kPa	kPa
1/2	15	0.840	(21.3)	0.109	(2.77)	0.85	(1.27)	0.85	(1.27)	(4800)	700	(4800)
3/4	20	1.050	(26.7)	0.113	(2.87)	1.13	(1.69)	1.13	(1.68)	(4800)	700	(4800)
1	25	1.315	(33.4)	0.133	(3.38)	1.68	(2.50)	1.68	(2.50)	(4800)	700	(4800)
1 1/4	32	1.660	(42.2)	0.140	(3.56)	2.27	(3.39)	2.28	(3.40)	(6900)	1000	(6900)
1 1/2	40	1.900	(48.3)	0.145	(3.68)	2.72	(4.05)	2.73	(4.07)	(6900)	1000	(6900)
2	50	2.375	(60.3)	0.154	(3.91)	3.66	(5.45)	3.69	(5.50)	(6900)	1000	(6900)
2 1/2	65	2.875	(73.0)	0.203	(5.16)	5.80	(8.64)	5.83	(8.68)	(6900)	1000	(6900)
3	80	3.500	(88.9)	0.216	(5.49)	7.58	(11.29)	7.62	(11.35)	(6900)	1000	(6900)
3 1/2	90	4.000	(101.6)	0.226	(5.74)	9.12	(13.58)	9.21	(13.71)	(8300)	1200	(8300)
4	100	4.500	(114.3)	0.237	(6.02)	10.80	(16.09)	10.91	(16.25)	(8300)	1200	(8300)
5	125	5.563	(141.3)	0.258	(6.55)	14.63	(21.79)	14.82	(22.07)	C	1200	(8300)
6	150	6.625	(168.3)	0.280	(7.11)	18.99	(28.29)	19.20	(28.60)	C	1200	(8300)
8	200	8.625	(219.1)	0.277A	(7.04)	24.72	(36.82)	25.57	(38.09)	C	1200	(8300)
10	250	10.750	(273.1)	0.307A	(7.80)	34.27	(51.05)	35.78	(53.29)	C	1000	(6900)

FIRESPRINKLER PIPES - FIRESIST +



Sizes

Outside Diameter	Wall Thickness
21,3 mm - 323,9 mm	2,0 mm - 12,70 mm
1/2" - 12,751"	0,079" - 0,500"

Technical Specifications

- Superior epoxy coating up to 250 microns
- Corrosivity category C4-M certified
- DEKRA certified
- Available in Gray (RAL 7012)
- Roll grooved, Threaded & Coupled or Beveled pipe end
- Eliminates field painting
- Widest range of UL and FM approval, CE certified
- Produced according to ASTM and EN standards
- Pressure ratings up to 300 psi
- Size range between 1/2" -12"
- Reliable in all sizes
- Inner weld seam removal and custom length upon request
- Tight tolerances, consistent roundness and straightness



FIRESPRINKLER PIPES - FIRESIST +



Sizes

Outside Diameter	Wall Thickness
21,3 mm - 323,9 mm	2,0 mm - 12,70 mm
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- Reliable in all sizes
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- Tight tolerances, consistent roundness and straightness



EASY FLOW NON THREADABLE LIGHTWALL



	OD (mm)	OD (inch)	Wall Thickness (mm)	Wall Thickness (inch)	Weight (kg/m)	Weight (lb/ft)	UL	FM
Easy Flow Light Wall	33,7	1"	2,00	0,079	1,56	1,05		✓
	33,7	1"	2,60	0,102	1,99	1,34		✓
	42,4	1 1/4"	2,00	0,079	1,99	1,34		✓
	42,4	1 1/4"	2,30	0,091	2,27	1,53		✓
	42,4	1 1/4"	2,60	0,102	2,55	1,71		✓
	48,3	1 1/2"	2,00	0,079	2,28	1,53		✓
	48,3	1 1/2"	2,60	0,102	2,93	1,97		✓
	60,3	2"	2,00	0,079	2,88	1,93		✓
	60,3	2"	2,90	0,114	4,10	2,76		✓
	76,1	2 1/2"	2,18	0,086	3,97	2,67		✓
	76,1	2 1/2"	2,90	0,114	5,23	3,52		✓
	88,9	3"	2,36	0,093	5,04	3,38		✓
	88,9	3"	3,20	0,126	6,76	4,54		✓
	114,3	4"	2,60	0,102	7,16	4,81		✓
	114,3	4"	3,60	0,142	9,83	6,60		✓
	139,7	5"	3,40	0,134	11,43	7,68		✓
SCH 7	33,4	1"	2,00	0,079	1,55	1,04	✓	✓
	42,2	1 1/4"	2,00	0,079	1,98	1,33	✓	✓
	48,3	1 1/2"	2,13	0,084	2,42	1,62	✓	✓
	60,3	2"	2,13	0,084	3,05	2,05	✓	✓
	73	2 1/2"	2,18	0,086	3,80	2,55	✓	✓
	88,9	3"	2,36	0,093	5,04	3,38	✓	✓
	114,3	4"	2,60	0,108	7,16	4,81	✓	✓
	141,3	5"	3,40	0,134	11,56	7,76	✓	✓
SCH 10	26,7	3/4"	2,11	0,083	1,28	0,86	✓	
	33,4	1"	2,77	0,109	2,09	1,41	✓	✓
	42,2	1 1/4"	2,77	0,109	2,69	1,81	✓	✓
	48,3	1 1/2"	2,77	0,109	3,11	2,09	✓	✓
	60,3	2"	2,77	0,109	3,93	2,64	✓	✓
	73	2 1/2"	3,05	0,120	5,26	3,53	✓	✓
	88,9	3"	3,05	0,120	6,46	4,34	✓	✓
	101,6	3 1/2"	3,05	0,120	7,41	4,98	✓	✓
	114,3	4"	3,05	0,120	8,37	5,62	✓	✓
	141,3	5"	3,4	0,134	11,58	7,78	✓	✓
	168,3	6"	3,4	0,134	13,85	9,30	✓	✓
	219,1	8"	4,78	0,188	25,26	16,96	✓	✓
	273,1	10"	4,78	0,188	31,62	21,23	✓	✓
	323,8	12"	4,78	0,188	37,61	25,28	✓	✓
SCH 30	33,4	1"	2,90	0,114	2,18	1,46		✓
	42,2	1 1/4"	2,97	0,117	2,87	1,93		✓
	48,3	1 1/2"	3,18	0,125	3,53	2,37		✓
	60,3	2"	3,18	0,125	4,48	3,00		✓
	73	2 1/2"	4,78	0,188	8,04	5,40		✓
	88,9	3"	4,78	0,188	9,92	6,65		✓
	101,6	3 1/2"	4,78	0,188	11,41	7,65		✓
	114,3	4"	4,78	0,188	12,91	8,66		✓
	219,1	8"	7,04	0,277	36,82	24,72		✓
	273,1	10"	7,8	0,307	51,05	34,27		✓
SCH 40	21,3	1/2"	2,77	0,109	1,27	0,85	✓	✓
	26,7	3/4"	2,87	0,113	1,69	1,13	✓	✓
	33,4	1"	3,38	0,133	2,50	1,68	✓	✓
	42,2	1 1/4"	3,56	0,140	3,39	2,27	✓	✓
	48,3	1 1/2"	3,68	0,145	4,05	2,72	✓	✓
	60,3	2"	3,91	0,154	5,45	3,66	✓	✓
	73	2 1/2"	5,16	0,203	8,64	5,80	✓	✓
	88,9	3"	5,49	0,216	11,29	7,58	✓	✓
	101,6	3 1/2"	5,74	0,226	13,58	9,12	✓	✓
	114,3	4"	6,02	0,237	16,09	10,80	✓	✓
	141,3	5"	6,55	0,258	21,79	14,63	✓	✓
	168,3	6"	7,11	0,280	28,29	18,99	✓	✓
	219,1	8"	8,18	0,322	45,34	30,45	✓	✓
	273,1	10"	9,27	0,365	60,29	40,52	✓	✓
SCH 80	21,3	1/2"	3,73	0,147	1,62	1,09		✓
	26,7	3/4"	3,91	0,154	2,20	1,48		✓
	33,4	1"	4,55	0,179	3,25	2,19		✓
	42,2	1 1/4"	4,85	0,191	4,49	3,03		✓
	48,3	1 1/2"	5,08	0,200	5,39	3,65		✓
	60,3	2"	5,54	0,218	7,55	5,08		✓
	73	2 1/2"	7,01	0,276	11,52	7,75		✓
	88,9	3"	7,62	0,300	15,39	10,35		✓
	101,6	3 1/2"	8,08	0,318	18,82	12,67		✓
	114,3	4"	8,56	0,337	22,60	15,20		✓
	141,3	5"	9,52	0,375	31,42	21,04		✓
	168,3	6"	10,97	0,432	43,05	28,88		✓
	219,1	8"	12,70	0,500	65,41	44,00		✓

ASTM FM & UL



	OD (mm)	OD (inch)	Wall Thickness (mm)	Wall Thickness (inch)	Weight (lb/ft)	Weight (kg/mt PE)	FM Approval	UL
Lightwall	33,7	1"	2,00	0,079	1,05	1,56	✓	
	33,7	1"	2,60	0,102	1,34	1,99	✓	
	42,4	1 1/4"	2,00	0,079	1,34	1,99	✓	
	42,4	1 1/4"	2,30	0,091	1,53	2,27	✓	
	42,4	1 1/4"	2,60	0,102	1,71	2,55	✓	
	48,3	1 1/2"	2,00	0,079	1,53	2,28	✓	
	48,3	1 1/2"	2,60	0,102	1,97	2,93	✓	
	60,3	2"	2,00	0,079	1,93	2,88	✓	
	60,3	2"	2,90	0,114	2,76	4,10	✓	
	76,1	2 1/2"	2,18	0,086	2,67	3,97	✓	
	76,1	2 1/2"	2,90	0,114	3,52	5,23	✓	
	88,9	3"	2,36	0,093	3,38	5,04	✓	
	88,9	3"	3,20	0,126	4,54	6,76	✓	
	114,3	4"	2,60	0,102	4,81	7,16	✓	
	114,3	4"	3,60	0,142	6,60	9,83	✓	
	139,7	5"	3,40	0,134	7,68	11,43	✓	

	OD (mm)	OD (inch)	Wall Thickness (mm)	Wall Thickness (inch)	FM	UL
EN10255 Medium	21,3	1/2"	2,6	0,102		
	26,9	3/4"	2,6	0,102		
	33,7	1"	3,2	0,126	✓	
	42,4	1 1/4"	3,2	0,126	✓	✓
	48,3	1 1/2"	3,2	0,126	✓	✓
	60,3	2"	3,6	0,142	✓	✓
	76,1	2 1/2"	3,6	0,142	✓	✓
	88,9	3"	4	0,157	✓	✓
	114,3	4"	4,5	0,177	✓	✓
	139,7	5"	5	0,197	✓	✓
	165,1	6"	5	0,197	✓	✓

	OD (mm)	OD (inch)	Wall Thickness (mm)	Wall Thickness (inch)	FM
EN10255 Heavy	21,3	1/2"	3,2	0,126	✓
	26,9	3/4"	3,2	0,126	✓
	33,7	1"	4	0,157	✓
	42,4	1 1/4"	4	0,157	✓
	48,3	1 1/2"	4	0,157	✓
	60,3	2"	4,5	0,177	✓
	76,1	2 1/2"	4,5	0,177	✓
	88,9	3"	5	0,197	✓
	114,3	4"	5,4	0,213	✓
	139,7	5"	5,4	0,213	✓
	165,1	6"	5,4	0,213	✓

ERW LINE PIPES



Sizes

Outside Diameter	Wall Thickness	Length
21,3 mm - 339,7 mm	2,8 mm - 12,7 mm*	6,00 m - 18,30 m
1/2" - 13 3/8"	0.109" - 0,500"	19,68 ft - 60,04 ft

Please ask for shorter lengths

* For US mill up to 15,88 mm available

Production Standards & Material Qualities

Line Pipe

API 5L, PSL 1, PSL 2 A, B, X42, X46, X52, X56, X60, X65, X70

CSA Z 245.1 Gr 241-Gr 359

EN ISO 3183 L245-L485 (N, M, NE, ME)

SI 530 Grade B



SPIRALLY WELDED STEEL PIPES

Technical Specifications

Specification Item	Available Range / Option
Outside Diameter (OD)	406 mm – 3048 mm
Wall Thickness (WT)	5 mm – 25 mm
Pipe Length	6 m – 12 m (Standard) / Custom project-specific lengths
Steel Grades	S235JR, S275JR, S355JR, API 5L Gr. B, X42, X46, X52
Manufacturing Method	Helically Submerged Arc Welded (HSAW / SSAW)
Ends	Beveled (standard) or Plain Ends (upon request)
Surface Finish	Bare, Varnished, External Coated, Internal Coated
Coating Options	3LPE, 3LPP, SFBE, DFBF, Bitumen, Concrete / Epoxy (internal)
Standard Compliance	API 5L, EN 10217-1, EN 10219, ASTM A252
Certification	EN 10204 3.1 / PED / CE



QUALITY CONTROL & TESTING

At Hera Global Steel, every pipe undergoes a stringent quality control process:

- **Hydrostatic Pressure Testing:** Pipes are filled with high-pressure water to verify structural integrity.
- **Ultrasonic Weld Seam Inspection:** Non-destructive testing of weld seams for defects.
- **Ultrasonic Full Body Testing:** Complete body inspection for subsurface flaws.
- **Visual Inspection:** Surface, weld quality, and dimension inspections.
- **Dimensional Inspection:** Verification of diameter, thickness, and length according to standards.
- **Tensile Strength Testing:** Determination of mechanical properties such as yield strength and tensile strength.
- **Impact Testing (Charpy V-Notch):** Assessment of toughness under low-temperature conditions.
- **Flattening Test:** Ensures ductility and proper weld fusion by compressing pipe sections.
- **Bend Test:** Evaluation of pipe flexibility and weld ductility under stress.



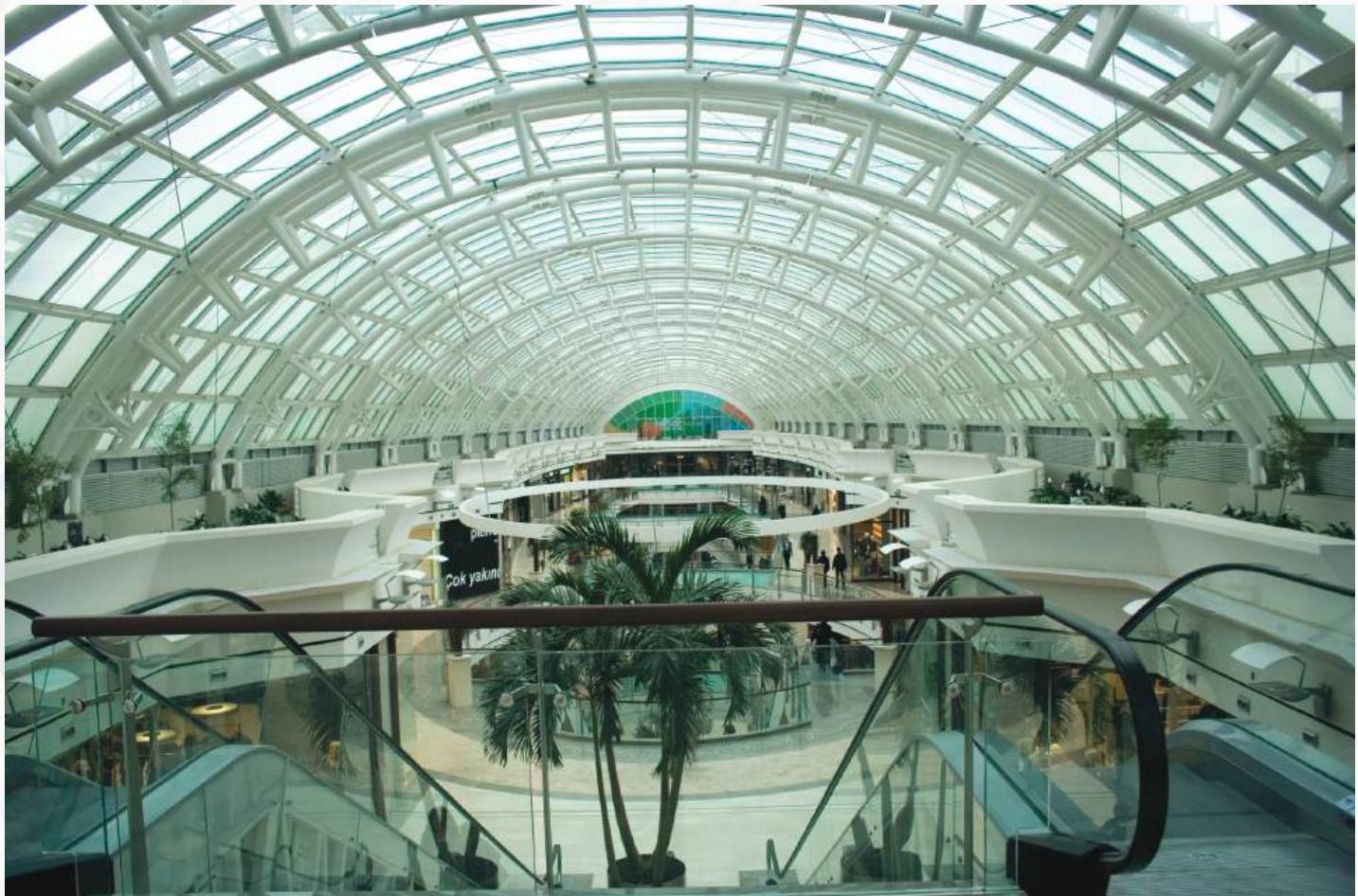
CIRCULAR HOLLOW SECTIONS

Sizes

Outside Diameter	Wall Thickness	Length
21,3 mm - 339,7 mm	2,0 mm - 12,7 mm	5,00 m - 12,0 m
1/2" - 13 3/8"	0,079" - 0,500"	16,40 ft - 39,37 ft

Production Standards & Material Qualities

EN 10305-5	E 195, E 235, E 275, E 355
ASTM A 500	GR A, GR B, GR C
EN 10219 (BS 6363)	S 235, S 275, S 355, S 460 MH, NH (J0H, JRH, J2H, K2H, GR 34/26, GR 43/36)
EN 10210	S 235, S 275, S355, S460 MH, NH (J0H, JRH, J2H, K2H)



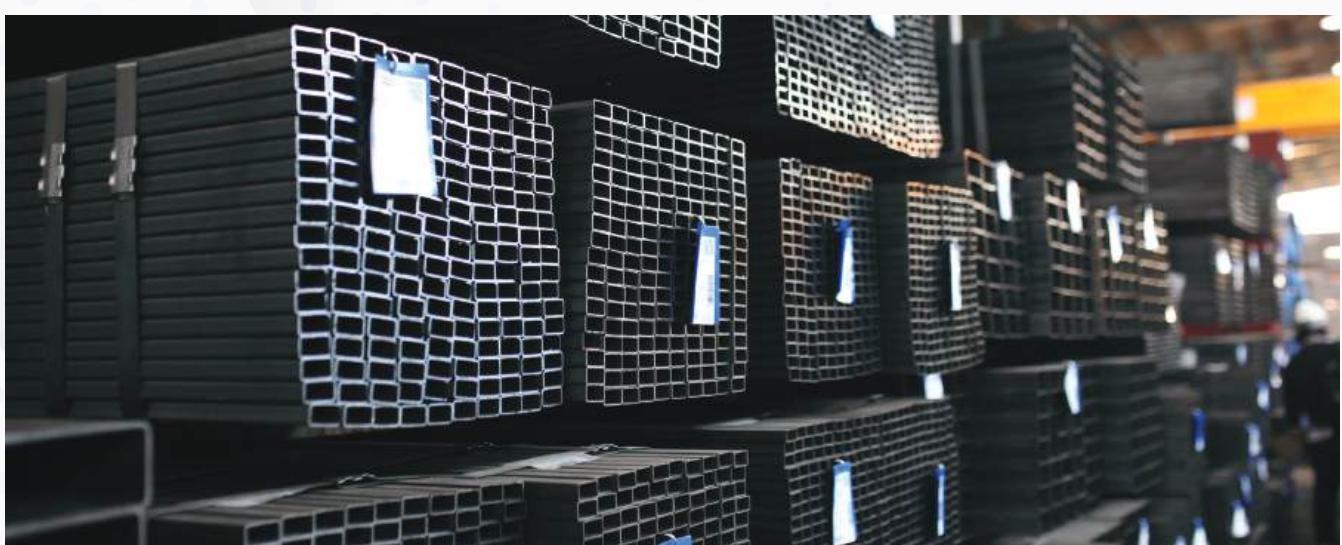
Tests & Certificates

- Visual and Dimensional Inspection
- Mechanical Tests:
 - Tensile Test
 - Flattening Test, Flaring Test
 - Expanding Test
 - Impact Test
- Mill Test Certificates
 - According to EN 10204 2.1; 2.2; 3.1; 3.2
- NDT Standards
 - ET (ISO 10893-2)
- Metallographic Examination
- Chemical Analysis
- Non Destructive Inspection: In-Line Ultrasonic (weld check)
 - In-Line and offline Eddy Current (for round tubes)
- Quality Certificates
 - EN 10219 - EN10210 CE marked

Finishing Operations

- Plain End-Square cut or bevelled
- Black, self-colored/uncoated

- Mill protective oil coating; for both round, square and rectangular tubes, black & red varnish for outside surface of round tubes.



FOUNDATION / PILLING TUBES

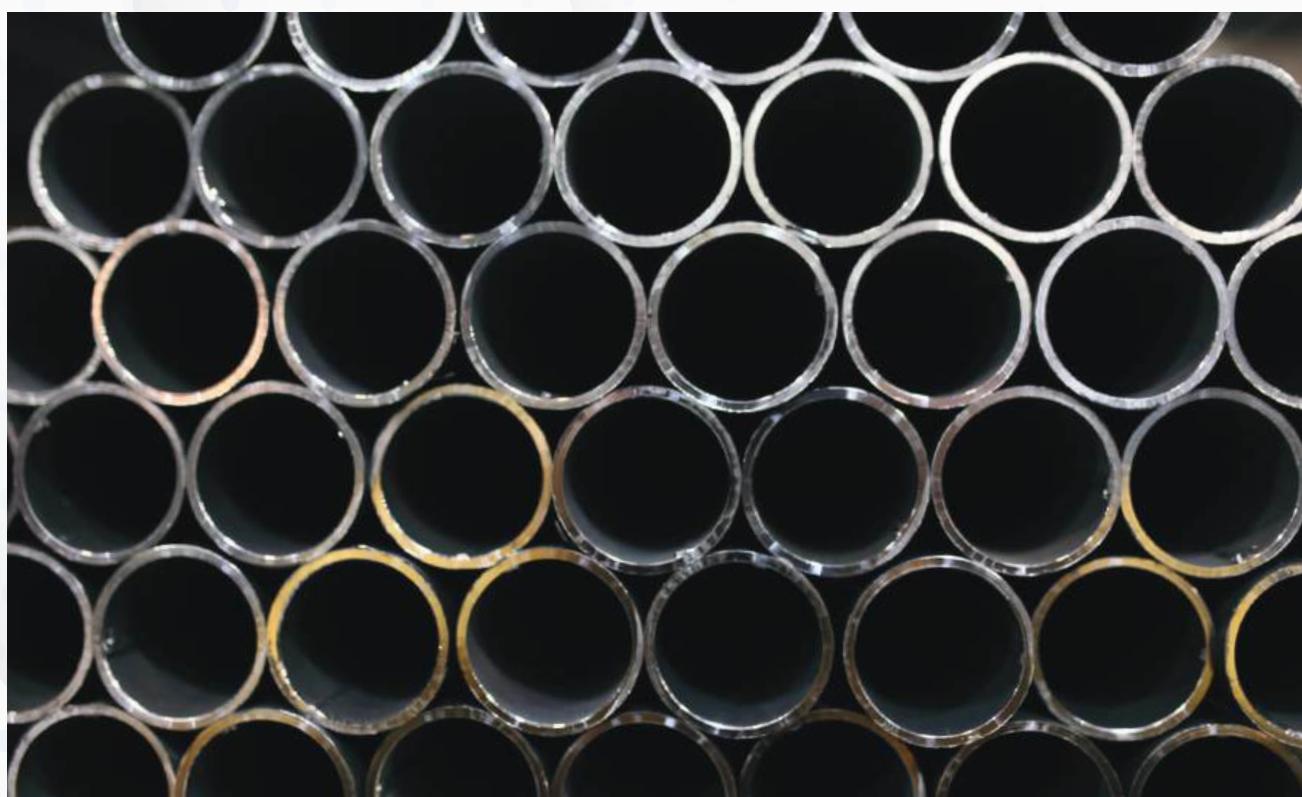
Sizes

For Spirally Welded Pipes

Outside Diameter	Wall Thickness	Length
508 mm - 3.048 mm 20" - 120"	5,16 mm - 25,4 mm 0,203" - 1"	Single lengths up to 55,0 m

For ERW Micro Pilling Pipes

Outside Diameter	Wall Thickness	Length
21,3 mm - 339,7 mm 1/2" - 13 3/8"	2,8 mm - 12,7 mm 0.110" - 0.500"	6,00 m - 18,30 m 19.69 ft - 60.04 ft



Production Standards & Material Qualities

EN 10219-1 Grade including S355 J2H, CE marking according to S355, S460 MH, S550 J2H
 ASTM A252 Grade including Grade 3
 Inner weld bead removed

Coating Standards

- Dual Layer Abrasion Resistant FBE OD Coating: API 5L7, CSA Z 245-20, NACE RP 0394, AWWA C213
- FBE (Fusion Bonded Epoxy) OD Coating: API 5L7, CSA Z 245-20, NACE RP 0394, AWWA C213
- Polyethylene OD Coating: DIN 30670, TS 5139, NF A 49-710, UNI 9099, EN ISO 21809-1
- Polypropylene OD Coating: DIN 30678, NF A 49-711, EN ISO 21809-1
- Epoxy ID Coating: AWWA C 210 Dual Layer Abrasion Resistant FBE OD Coating: API 5L7, CSA Z 245-20, NACE RP 0394, AWWA C213
- FBE (Fusion Bonded Epoxy) OD Coating: API 5L7, CSA Z 245-20, NACE RP 0394, AWWA C213
- Polyethylene OD Coating: DIN 30670, TS 5139, NF A 49-710, UNI 9099, EN ISO 21809-1
- Polypropylene OD Coating: DIN 30678, NF A 49-711, EN ISO 21809-1
- Epoxy ID Coating: AWWA C 210

Protective Paint Systems

BS EN ISO 12944-5.2019

Paints and varnishes. Corrision protection of steel structures by protective paint systems.

Most Common ERW Piling Tube Sizes

Diameter (mm)	Wall Thickness (mm)	kg/meter
76,1	6,3	10,84
88,9	6,3	12,83
114,3	6,3	16,78
114,3	8	20,97
139,7	8	25,98
139,7	10	31,99
168,3	10	39,04
168,3	12,5	48,03
219,1	10	51,57
219,1	12,5	63,69
273,0	10	64,86
273,0	12,5	80,30
323,9	10	77,41
323,9	12,5	95,99

Chemical (max)	C	Mn	P	S	CEV%
S 460 MH	0,20%	1,70%	0,035%	0,03%	0,46%
S 550 J2H	0,16%	2,20%	0,03%	0,03%	0,47%

Mechanical	Yield Strength (Mpa) min	Tensile Strength (Mpa) min	Elongation min	Impact Energy at -20°C
S 460 MH	460	530 - 720	17%	40 Joule
S 550 J2H	550	605 - 760	14%	27 Joule



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