

# BS 6323 : Part 8 : 1982

## Seamless and welded steel tubes

### Part 8: Specific requirements for longitudinally welded stainless steel tubes

#### Tolerances

##### Diameter

i. The tolerance on designated diameter, including ovality, for as-welded and sized tube shall be as given in **Table 1**

ii. The tolerance on designated diameter, including ovality, for fully softened tubes the tolerance shall be as given in **Table 2**

##### Thickness

The tolerance on thickness, including eccentricity but excluding the weld, shall be 10%

The external weld bead shall be removed or controlled so that the tube is smooth and circular to the eye. Special requirements for the control of the weld bead shall be the subject of agreement between the purchaser and the manufacturer

The maximum height of the internal weld shall not be greater than 60% of the specified thickness

##### Length

Tubes shall be supplied in either:

- (a) random lengths of 4m to 8m; or
- (b) specified cut lengths to the tolerance given in **Table 3**

Table 2. Tolerance on diameter of as-welded and sized tube		
Outside diameter		Tolerance
Over	Up to and including	
mm	mm	mm
	30	0.15
30	50	0.18
50	70	0.25
70	110	0.35

Table 2. Tolerance on diameter of fully softened tube		
Diameter to thickness ratio D/a		Tolerance
Over	Up to and including	
		mm
-	40	1.5 times value in table 2
40	60	Twice the value in table 2
60	-	2.5 times value in table 2

Table 3. Tolerance on specified cut lengths		
Specified cut length		Tolerance
Over	Up to and including	
mm	mm	mm
		+2
	500	-0
		+3
500	2000	-0
		+5
2000	5000	-0
		+10
5000	7000	-0
7000	-	by agreement

Note: Closer tolerances may be obtained by agreement between the purchaser and the manufacturer

