



— JINDAL STEEL TUBES LTD. —



OUR PRODUCT

DEFINES STRENGTH

— 50 years of nation building —

About Us

Set up in the year 1965, Jindal steel tubes ltd. has been one of the pioneers in the field of steel pipes & tubes. Under the leadership of padamshree Lt. Sh. D S Jindal, Jindal steel tubes ltd. was the 1st pipe mill set up in southern India.

Quality Raw Material

We strongly believe that any product can be of optimum quality only and only if the raw material used and the manufacturing process are best in class.

Compromise in either of the two will result in a sub standard final product. Therefore, we use quality raw material from the leading steel manufacturers in the country like JSW, Tata Steel, Bhushan Steel & Power Ltd., Uttam Galva & others.

Cutting Edge Technology

Steel strip in coil, which has been slit into the required width from wide strip, is shaped by a series of forming rolls into a multiple length shell. The longitudinal edges are continuously joined by high frequency resistance/induction welding.

The weld of multiple length shell is then head treated electrically, sized and cut to specified lengths by a flying cut-off machine. The cut pipe is straightened and squared at both ends.

These operations are followed by ultrasonic inspection or hydrostatic testing.

State of the Art Manufacturing

Jindal Pipes & Tubes are manufactured using the latest and modern GMT ERW Tube Mills with most advance entry section, quick changing mill section, variety of flying cutoff machines and accurate tooling to meet the stringent requirements of general engineering, automotive, cross country pipe lines, structural, boiler, heat exchanger and other relevant applications.

The Tube Mills are robust in design, employ highly efficient helical drive system and various levels of automation. The special shaping stands and Turks head ensure complex hollow section production with precise quality.



Our **Manufacturing**



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Features

- Fully Automatic Operation
- Line speed up to 100m/min
- Quick change raft type design
- Driven Shaping stands for accurate shapes
- Accurate cut lengths within + 2mm

STEEL PIPES FOR ORDINARY USES IN WATER, GAS, STEAM & AIR

Conforming to IS:1239 (Part-I) 2004

Nominal Bore (N.B.)		Outside Diameter		CLASS	Wall Thickness		NOMINAL WEIGHT		METERS / TON	
MM	INCH	Minimum	Maximum		MM	SWG*	Kg / Meters		P.E.	S & S
MM	INCH	MM	MM	CLASS	MM	SWG*	P.E.	S & S	P.E.	S & S
15	(1/2")	21.00	21.40	L	2.00	14	0.95	0.96	1056	1046
		21.00	21.80	M	2.60	12	1.21	1.22	826	820
		21.00	21.80	H	3.20	10	1.44	1.45	694	690
20	(3/4")	26.40	26.90	L	2.30	13	1.38	1.39	725	719
		26.50	27.30	M	2.60	12	1.56	1.57	641	637
		26.50	27.30	H	3.20	10	1.87	1.88	535	532
25	(1")	33.20	33.80	L	2.60	12	1.98	2.00	505	500
		33.30	34.20	M	3.20	10	2.41	2.43	415	411
		33.30	34.20	H	4.00	8	2.93	2.95	341	339
32	(1 1/4")	41.90	42.50	L	2.60	12	2.54	2.57	394	389
		42.00	42.90	M	3.20	10	3.10	3.13	322	319
		42.00	42.90	H	4.00	8	3.79	3.82	264	262
40	(1 1/2")	47.80	48.40	L	2.90	11	3.23	3.27	310	306
		47.90	48.80	M	3.20	10	3.56	3.60	281	278
		47.90	48.80	H	4.00	8	4.37	4.41	229	227
50	(2")	59.60	60.20	L	2.90	11	4.08	4.15	245	241
		59.70	60.80	M	3.60	9	5.03	5.10	199	196
		59.70	60.80	H	4.50	7	6.19	6.26	161	160
65	(2 1/2")	75.20	76.00	L	3.20	10	5.71	5.83	175	171.5
		75.30	76.60	M	3.60	9	6.42	6.54	156	153
		75.30	76.60	H	4.50	7	7.93	8.05	126	124
80	(3")	87.90	88.70	L	3.20	10	6.72	6.89	149	145
		88.00	89.50	M	4.00	8	8.36	8.53	120	117
		88.00	89.50	H	4.80	6	9.90	10.10	101	99
100	(4")	113.00	113.90	L	3.60	9	9.75	10.00	102	100
		113.10	115.00	M	4.50	7	12.20	12.50	82	80
		113.10	115.00	H	5.40	5	14.50	14.80	69	67
125	(5")	138.50	140.80	M	4.80	6	15.90	16.40	63	61
		138.50	140.80	H	5.40	5	17.90	18.40	56	54
150	(6")	163.90	166.50	M	4.80	6	18.90	19.50	53	51
		163.90	166.50	H	5.40	5	21.30	21.90	47	46

* Standard Wire Gauge

TOLERANCE

Thickness:	For quantities per load of 10 ton Min.: +/- 7.5% (Medium & Heavy series)
Light Tubes : + not limited - 8%	Chemical Composition
Medium & Heavy Tubes: + not limited - 10%	
Weight:	Physical Properties
Single Tube : + 10% (light series) - 8%	Tensile strength : Min. 320 Mpa
Single Tube : +/- 10% (Medium & Heavy series)	Elongation % age : 20% Min. above 25 mm NB 12% Min. upto 25 mm NB
For quantities per load of 10 ton Min.: (light series) +7.5% -5.0%	Hydro Test Pressure : 5 Mpa



STEEL PIPES FOR STRUCTURAL PURPOSE

Confirming to IS : 1161 - 2014

Nominal Size NB		Outside Diameter D	Thickness T		Nominal Weight Black Tubes Plain End	
MM	INCH	MM	MM	SWG	Kg/Meter	Meter/Ton
15	(1/2")	21.30	2.00	14	0.947	1056
			2.60	12	1.210	826
			3.20	10	1.440	694
20	(3/4")	26.90	2.30	13	1.380	725
			2.60	12	1.560	641
			3.20	10	1.870	535
25	(1")	33.70	2.60	12	1.980	505
			3.20	10	2.410	415
			4.00	08	2.930	341
32	(1 1/4")	42.40	2.60	12	2.540	394
			3.20	10	3.100	322
			4.00	08	3.790	264
40	(1 1/2")	48.30	2.90	11	3.230	310
			3.20	10	3.560	281
			4.00	08	4.370	229
50	(2")	60.30	2.90	11	4.080	245
			3.60	09	5.030	199
			4.50	07	6.190	162
65	(2 1/2")	76.10	3.20	10	5.710	175
			3.60	09	6.420	156
			4.50	07	7.930	126
80	(3")	88.90	3.20	10	6.720	149
			4.00	08	8.360	120
			4.80	06	9.990	101
100	(4")	114.30	3.60	09	9.750	102
			4.50	07	12.200	82
			5.40	05	14.500	70
110		127.00	4.50	07	13.600	74
			4.80	06	14.500	69
			5.40	05	16.200	62
125	(5")	139.70	4.50	07	15.000	66.5
			4.80	06	15.900	63
			5.40	05	17.900	56
135		152.40	4.50	07	16.400	61
			4.80	06	17.500	57
			5.40	05	19.600	51
150	(6")	165.10	4.50	07	17.800	56
			4.80	05	18.900	53
			5.40	05	21.300	47
150	(6")	168.30	4.50	07	18.200	55
			4.80	06	19.400	51.5
			5.40	05	21.700	46
175	(7")	193.70	6.30	03	25.200	40
			4.80	06	22.400	45
			5.40	05	25.100	40
200	(8")	219.10	5.90	04	27.300	37
			4.80	06	25.400	39
			5.60	05	29.500	34
			5.90	04	31.000	32

Chemical Properties

C	0.20% Max
Mn	1.3% Max
P	0.04% Max
S	0.04% Max

Physical Properties

Grade	YS (Min.) Mpa	TS (Min.) Mpa	% age (Min.) Elong.
YST-210	210	330	20
YST-240	240	410	17
YST-310	310	450	14

Note: For tubes upto size 25mm NB including Elongation of 12% shall be permissible.

Weight

Single tubes (light series) +10%
-8%

Single tubes +/- 10%
(medium & heavy series)

Weight Truck Load

For lot of 10 Ton Min.

Light Series +/- 5%

medium & heavy series +/- 7.5%

Tolerance

Outside diameter:
upto and including 48.3mm + 0.4mm
- 0.8mm
Over 48.3mm +/- 1%

Thickness

+ Not Limited - 10%



HOLLOW STEEL SECTIONS FOR STRUCTURAL USE

SQUARE HOLLOW SECTION (SHS)

Conforming to IS : 4923 – 1997

SHS (DxB)*	THICKNESS	UNIT WEIGHT	
		Kg/Meter	Meter/Ton
15 X 15	1.20	0.53	1900
	1.60	0.69	1455
	2.00	0.84	1190
19 X 19	2.00	0.99	1010
	2.60	1.20	833
	2.90	1.30	769
25 X 25	2.00	1.36	735
	2.60	1.69	592
	3.20	1.98	505
32 X 32	2.60	2.26	442
	3.20	2.69	372
	4.00	3.19	313
38 X 38	2.00	2.18	459
	2.60	2.75	364
	3.20	3.29	304
	4.00	3.95	253
40 X 40	2.00	2.31	433
	2.60	2.92	342
	3.20	3.49	287
	4.00	4.20	238
49.5 X 49.5	2.60	3.69	271
	3.20	4.45	225
	4.50	5.95	168
60 X 60	2.60	4.55	220
	3.20	5.50	182
	3.50	5.96	168
	4.50	7.43	135
72 X 72	3.20	6.71	149
	4.00	8.22	122
	5.00	10.01	100

SHS (DxB)*	THICKNESS	UNIT WEIGHT	
		Kg/Meter	Meter/Ton
80 X 80	3.20	7.51	133
	4.00	9.22	108
	5.00	11.27	89
91.5 X 91.5	3.60	9.67	103
	4.50	11.88	84
	5.40	14.01	71
100 X 100	3.60	10.64	94
	4.50	13.08	76
	6.00	16.98	59
113.5 X 113.5	4.00	13.43	74
	5.00	16.53	60
	6.00	19.53	51
125 X 125	4.00	14.87	67
	5.00	18.33	55
	6.00	21.69	46
132 X 132	4.00	15.75	63
	5.00	19.43	51
	6.00	23.01	43
150 X 150	5.00	22.26	45
	6.00	26.40	38
	7.00	30.44	33
180 X 180	5.00	26.97	37
	6.00	32.05	31
	8.00	41.91	24

OTHER ALLOWABLE STRESS VALUES (in Mpa)

Steel Grade	Min. Yield Stress	Min. UTS
Yst 210	210	330
Yst 240	240	410
Yst 310	310	450

Note: Min.% Elongation: 10% for GR. Yst 310, 15% for GR. Yst 240 & 20% for Yst 210
e: The sizes which are not covered in the Table can also be supplied as per customer requirement (Clause – 8.1)

* D : Depth
B : Breadth



SPECIFICATIONS OF STEEL PIPES FOR WATER AND SEWAGE

Conforming to IS : 3589 - 2001

Nominal N.B. Size		Outside Diameter	Wall Thickness	Calculated Weight	
MM	INCH	MM	MM	Kg/m	Mtr/Tonne
150	(6")	168.30	2.60	10.60	94.30
		168.30	3.20	12.00	83.30
		168.30	4.00	16.21	61.70
		168.30	5.00	20.14	49.66
		168.30	6.00	24.01	41.64
		168.30	7.00	27.84	35.91
175	(7")	193.70	4.00	18.71	53.44
		193.70	5.00	23.27	42.97
		193.70	6.00	27.77	36.01
		193.70	7.00	32.23	31.03
200	(8")	219.10	2.60	13.88	72.00
		219.10	3.60	19.13	52.27
		219.10	4.00	21.22	47.13
		219.10	5.00	26.40	37.88
		219.10	5.40	28.46	35.14
		219.10	6.00	31.53	31.72
		219.10	7.00	36.61	27.31

TOLERANCE

Outside Diameter:	+/- 0.75% of OD
Thickness:	+/- 10%
Ovality:	Shall not exceed 1% of the specified diameter
Bead Height:	The maximum height of the weld bead on the internal surface of the pipes shall not exceed 60% of nominal wall thickness
Straightness:	Shall not deviate from the straightness by more than 0.2% of total length
Length:	Single random length of 4 to 7 meter
Weight:	+/- 7.5% on Truck Load

PHYSICAL PROPERTIES

Grade	Yield Stress	Tensile Strength	%elongation
	Mpa(Min)	Mpa(Min)	(Min)
Fe-330	195	330	20
Fe-410	235	410	18
Fe-450	275	450	15

The sizes which are not covered in the Table can also be supplied as per customer requirement (Clause – 11.1)



HOLLOW STEEL SECTIONS FOR STRUCTURAL USE

RECTANGULAR HOLLOW SECTION (RHS)

Conforming to IS : 4923 – 1997

RHS MM	THICKNESS MM	UNIT WEIGHT	
		Kg/Meter	Meter/Ton
40 X 20	2.00	1.68	595
	2.60	2.10	476
	3.20	2.49	402
40 X 25	1.60	1.57	640
	2.00	1.94	518
	2.50	2.39	419
50 X 25	2.00	2.15	465
	2.60	2.71	369
	3.20	3.24	309
	4.00	3.88	258
50 X 30	2.00	2.41	418
	2.50	2.98	337
	2.90	3.43	293
50 X 40	2.00	2.88	370
	2.50	3.56	297
	2.90	4.11	260
60 X 40	2.60	3.73	268
	3.20	4.50	222
	4.50	6.02	166
66 X 33	2.60	3.69	271
	3.20	4.45	225
	4.50	5.95	168
75 X 25	2.60	3.73	268
	3.20	4.50	222
	4.50	6.02	166
80 X 40	2.90	5.03	199
	3.50	5.96	168
	4.50	7.43	135
96 X 48	3.20	6.71	149
	4.00	8.22	122
	5.00	10.01	100
90 X 60	3.20	7.01	143
	4.00	8.59	116
	5.00	10.48	95
100 X 50	3.20	7.01	143
	4.00	8.59	116
	5.40	11.21	89
	6.00	12.27	81
120 X 60	3.60	9.50	105
	4.50	11.67	86
	5.40	13.76	73
122 X 61	3.60	9.67	103
	4.50	11.88	84
	5.40	14.01	71
125 X 75	4.00	12.16	83
	5.00	15.08	67
	6.00	17.95	56
125 X 100	4.00	13.71	73
	5.00	17.02	59
	6.00	20.27	49
145 X 82	3.60	12.16	82
	4.50	14.99	67
	5.40	17.74	56
150 X 75	3.60	12.05	83
	4.50	14.85	67
	5.40	17.57	57

RHS	THICKNESS	UNIT WEIGHT	
150 X 100	3.60	13.46	74
	4.50	16.62	60
	5.40	19.69	51
172 X 92	3.60	14.25	70
	4.50	17.61	57
	5.40	20.88	48
200 X 100	4.50	20.15	50
	6.00	26.40	38
	7.00	30.44	33
200 X 150	4.50	23.68	42
	6.00	31.11	32
	8.00	40.66	25

General technical specification and tolerances:

Spec :	IS:4923:1997
Length:	6.0mtrs. +/-6.0mm customized length ranging from 4 mtrs. to 8mtrs. May be supplied.
Thickness:	For all sizes: +/- 10.0%
Outer Dimensions:	1% with a Min. of 0.5mm
Corner Squareness:	90° +/- 2°
Corner Radii:	Max. 3x (thickness of the section)
Weight:	on individual length : +10%, -8% on lots of 10 MT: +/- 7.5%
Straightness:	Min 1:600 th of any length measured along the center line (mill straightened condition) unless otherwise specifically arranged
Twist Tolerance:	Max. 2mm: +/-0.5mm /1m length, the measured relative vertical shift of any adjacent corner of the measured by keeping one side on flat surface.
End Finish:	Plain Ended- Mechanically sheared, mill-cut finish without further machining.
Surface Finish:	Black without any surface treatment of oiling or varnishing.
Raw Material:	Sulphur content: 0.05% max. Phosphorus content:0.05% max.





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