

Material	Seamless or welded stainless steel tube, depending on outer diameter (see dimensions). 1.4404 / 1.4435 / UNS S31603 (316L)
Dimensions	Stock dimensions: Imperial: 1/4" (6.35 x 0.89 mm) to 6" (152.40 x 2.77 mm) Pipe: see section dimensions (tubes) Metric: 6.00 x 1.00 mm to 35.00 x 1.50 mm Further dimensions on demand: ISO, metric
Technical terms of delivery Tubes Length Fittings Tube components Machined components: Tolerances Ends	Acc. to ASTM A 269 / A 632 / A 312 (Pipe), DIN EN 10217-7 / 10216-5 5900 - 6090 mm (max. 10% short lengths possible) Prematerial acc. to ASTM A 269 / A 632 / A 312 / A 403 (Pipe), DIN EN 10217-7 / 10216-5 Prematerial according to ASTM A 479, DIN EN 10088-3, DIN 17440 Pipe dimensions acc. to ASTM A 182 According to ASTM A 269 / A 632 or DIN EN ISO 1127 - D4/T3 Tubes and fittings are prepared for orbital welding
Surface options Tubes and Fittings Fittings Pipes	Inner surface: OD ≤ 63.50 mm: Ra ≤ 0.40 µm (16 µin), OD > 63.50 mm: Ra ≤ 0.60 µm (24 µin) Outer surface: Ra ≤ 0.80 µm (32 µin) Surface roughness of the cold worked area is not defined Specified roughness of total surface available on request Inner and outer surface an request
Inner surface treatment Tubes Fittings	finetron: Cleaning and test procedure ASTM A 632, S3 finetron.1: Anodic cleaning procedure Spec. HE 175 3VNS finetron: Cleaning and test procedure ASTM A 632, S3 finetron.1: Anodic cleaning procedure Spec. HE 111 3VNS
Hardness	Max. 180 HV / 90 HRB
Test procedures	<ul style="list-style-type: none"> • Verification of basic test certificate • Verification of dimensions • Visual inspection • Roughness measurements • Endoscopic inspection of bright finished tubes
Marking Tubes Fittings	Permanently marked Needle marking
Information	<ul style="list-style-type: none"> • DOCKWEILER • DW number • Dimensions • Material • Heat number
Documentation	Inspection certificate 3.1 according to DIN EN 10204 for prematerial
Packing and delivery	Bright finished and anodic cleaned tubes and fittings closed with transparent PE caps (anodic clean tubes and fittings with PE/PA squares), sleeved and sealed in PE and marked with blue sticker „finetron“ or „finetron.1“. Delivery of tubes in tubular container or wooden crate, fittings in strong cardboard box with shock-absorbing filler.