

Material	UNS S31603 (316L), the chemical compositions in accordance to Table DT-3 ASME BPE Chemical Composition in weights% C max. 0.035 Cr = 16.00 – 18.00 Mn max. 2.00 Mo = 2.00 – 3.00 further materials acc. to ASME BPE
Dimensions	1/4" x 0.035 (6.35 x 0.89 mm) to 6" x 0.109 (152.40 x 2.77 mm)
Technical terms of delivery	
Tubes and Fittings Length	According to ASME BPE, ASTM A 269 / A 270 5900 - 6090 mm (max. 10% short lengths possible)
Tolerances	According to ASME BPE section MMOC
Ends	Tubes and fittings are prepared for orbital welding
Surface options	
Tubes and fittings	inner surface: As per ASME BPE, section SF, bright finished SF1 electropolished SF4 Ra max Ra max 20 µin / 0.51 µm 15 µin / 0.38 µm Outer surface: Tubes and Fittings Ra ≤ 0.80 µm (32 µin)
Inner surface treatment	
Tubes SF1 SF4	Cleaning and test procedure ASTM A 632, S3 Electropolishing procedure Spec. HE 175 4VN
Fittings SF1 SF4	Cleaning and test procedure ASTM A 632, S3 Electropolishing procedure Spec. HE 111 4VN
Hardness	Max. 180 HV / 90 HRB
Test procedures	<ul style="list-style-type: none"> • Verification of basic test certificate • Verification of dimensions • Visual control • Roughness measurements • Endoscopic inspection of bright finished tubes
Marking	
Tubes Fittings	Permanently marked Needle marking
Information	<ul style="list-style-type: none"> • ASME BPE, Surface as per ASME BPE, section SF3 • DOCKWEILER • DW no. (batch no.) • Dimensions • Material • Heat number
Documentation	Certified Test Report 3.1 as per DIN EN 10204 for the prematerial
Packaging and Delivery	Ends are closed with transparent PE caps (electropolished parts with PE/PA squares). Tubes and fittings are individually sealed in PE foil, marked with a white sticker „ASME BPE SF1“, electropolished parts with yellow caps and yellow sticker „ASME BPE SF4“. Delivery of tubes in tubular container or wooden crate, of fittings in strong cardboard box or wooden crate with shock absorbing filler.