

Tab. 2.1 Hot Rolled Mechanical Tubes - ASSEL mill

WT	7.1	8.0	8.8	10.0	11.0	12.5	14.2	16.0	17.5	20.0	22.2	25.0	28.0	30.0	32.0	35.0	36.0	40.0	45.0	50.0	55.0	60	
OD	Мин-макс длина (m)/Lungime min-max (m)																						
60.300				9-11	9-11	9-11	8-10	7.5-10															
63.500				9.5-11	9-11	8-11	7.2-10	7-10	7-10														
70.000				9-10.5	9-11	7-11	6.5-11	6-10	6-10	6-9													
73.000				8-10	7.5-10	7-10.5	6.5-10.5	6-10	5.6-10	5.6-9													
76.100				8-10	7-10	6.5-10	5.8-10.5	5.5-10.5	5.5-10	5.5-9													
82.500				6.9-10.5	6.5-10	5.9-10	5.6-10	5.4-10	5.3-10	4.5-9	5.2-9	5.5-9											
88.900				6.3-10	5.8-10	5.6-10	5.4-10	5.2-10	5.0-10	4.9-9	4-9	4.5-9											
95.000				5.8-10	5.6-10	5.3-10	5.2-9	5.0-9.0	4.8-9.0	4.0-9.0	4.0-9.0	4.0-9.0											
101.600				5.5-7	5-7	4.5-7	4.3-8.0	4.2-8.0	4.0-7.0	4.0-7.0	4.0-7.0	4.0-7.0											
108.000				5.5-7	4.8-7	4.7-7	4.4-8.0	4.1-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.0	4.0-7.0									
114.300				5.5-7	5.0-7	5.0-7.0	4.2-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.0	4.0-7.0	4.0-7.0								
121.000	9.5-11	9-11	8.5-11	5.5-7.0	5.0-7.0	4.3-7.0	4.2-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.0	4.0-7.0	4.0-7.0	4.0-6.5	4.0-6.5						
127.000	9.0-11	8.5-11	8-11	7.5-11	5.0-7.0	4.5-7.0	4.3-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4-7.5	4.0-7.0	4.0-7.0	4.0-6.5	4.0-6.5						
133.000	9.0-11	8.5-11	8-11	7.5-11	5.0-7.0	4.3-7.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.5						
139.700	9.0-11	8.5-11	8-11	7.5-11	6-9.0	5.0-7.0	4.5-8.0	4.2-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.0	4.0-7.0	4.0-6.5	4.0-6.5					
146.000	8.5-11	8.0-11	7.5-11	7.5-11	7.0-11	5-7.0	4.5-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.5					
152.400	8.5-11	8.0-11	7.5-11	7.0-11	6.6-11	4.5-7.0	4.5-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.3					
159.000	8.0-11	7.5-11	7.5-11	7.0-11	6.5-11	4.5-7.0	4.5-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.5	4.0-6.3				
165.100	8.6-11	8.0-11	7.5-11	7.0-11	6.7-11	6.4-11	4.5-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.3				
168.300	8.5-11	8.0-11	7.5-11	7.0-11.5	6.5-11.5	6.2-11.5	4.5-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5				
177.800	8.5-11	7.5-11	7.5-11	7.0-11.5	6.5-11.5	6.2-11.5	4.5-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.2			
193.700		8.5-11	7.5-11	7.0-11.5	6.5-11.5	6.2-11	6-10	4.2-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.9	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6	4.0-5.7		
203.000		8.0-11	7.5-11	7.0-11.5	6.5-11.5	6.2-11	6-10	4.2-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.0		
216.000		8.0-11	7.5-11	7.0-11.5	6.5-11	6.2-11	6-10	7-9.0	4.2-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.9	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.3	4.0-5.9	
219.100		8.0-11	7.5-11	7.0-11.5	6.5-11	5.8-10.8	6-10	7-9.0	4.2-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.8	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.5	4.0-6.0	4.0-5.7	
224.000										4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.0	4.0-7.0	4.0-6.5	4.0-6.0	4.0-5.6	
229.000										4.0-8.0	4.0-8.0	4.0-8.0	4.0-8.0	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.5	4.0-7.0	4.0-6.7	4.0-6.2	4.0-5.7	4.0-5.4	
244.500											4.5-7.0	4.5-7.0	4.5-7.5	4.5-7.5	4.5-7.0	4.5-7	4.5-7	4.0-6.5	4.5-6.5	4.5-6.2	4.5-5.7	4.5-5.4	
250.825													4.5-7.5	4.5-7.5	4.5-7.0	4.5-7	4.5-7	4.0-6.5	4.5-6.5	4.5-6.2	4.5-5.7	4.5-5.4	

categoria H1-OD/WT>12.5 si Mannesmann ASSEL

categoria H2-OD>=60 si reductor;

aspect poligonal

categoria H4-OD/WT<4 si calibror;

categoria H3- 4<OD/WT<12.5 si calibror;

dimensiunile cu lungimi mai mari de 11 m (se accepta max. 33% la lungimea de 10.6-11.5 m pentru DRL si min. 67% la lungimea de 8-11 m)