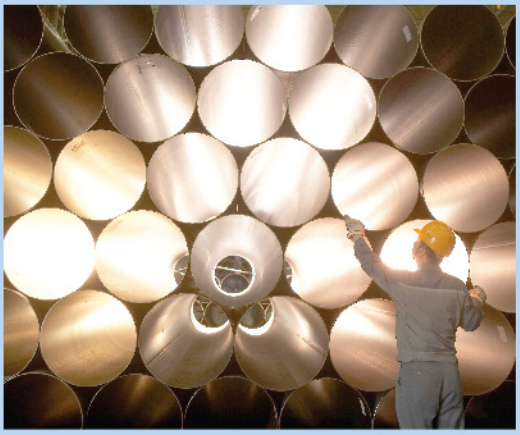
SĚAH Steel

STEEL PIPES & TUBES To

British Standard
BS EN 10255
BS EN 10217



2020

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Brief History

Established in 1960, SeAH Steel was the first in the steel pipe industry to lead exports to the US market in 1967. SeAH Steel carried out its IPO in 1969 at a time when companies were reluctant to go public. Consistently developing new products and pushing into new markets, SeAH Steel has become the steel pipe leader in Korea.

Starting from API steel pipes, the first welded pipes produced in Korea, SeAH Steel continued to secure its global reputation for leading technology and superb quality. The company's Pohang Plant is one of the largest steel plants in the world with an annual capacity of 1.2 million tons. Together with production bases in Gunsan, Suncheon, and Changwon, SeAH Steel produces over 2.2 million tons of various steel pipes and plates each year. Through its overseas production and distribution overseas, including the newly acquired Italian steel pipe producer Inox Tech, SeAH Steel continues to expand its international presence.

Oct. 1960 Pusan Steel Pipe Corporation established in Pusan, Korea

Mar. 1965 Obtained "KS" monogram

Aug. 1967 Steel pipes exported to the United States for the first time in Korea

May. 1969 Company shares listed on the Korea Stock Exchange

Aug. 1970 Seoul plant went into operation

Oct. 1973 Spiral welded pipe mill started operation covering 457.2~2,413.0mm

Fed. 1975 Company name changed to Pusan Steel pipe

Oct. 1978 The first Pohang plant went into operation

Mar. 1979 Authorized to use "API" monogram on casing & tubing, on high tensile line pipe and on line pipe

Aug. 1980 The second Pohang plant went into operation

Apr. 1981 Obtained "LR"(Lloyd's Register Shipping Monogram) and "DNV"(Det Norske Veritas) for welded steel pipe

Dec. 1981 Awarded one hundred million U.S. dollar export tower

Jun. 1982 Pohang plant has been authorized as the "A" grade factory under the quality control program

Oct. 1982 Obtained "UL" label for rigid steel conduit approved by Underwriters Laboratories

Jan. 1983 The Third Pohang plant went into operation covering up to 20 inch high grade line pipe and OCTG.

Jun. 1983 Obtained "JIS" monogram (No.8311,8312)

Jan. 1985 Production of pre-insulated pipe initiated under the technical tie-up with Ecopipe AB, Sweden

Mar. 1990 Stainless Steel Pipe mill went into operation in Seoul plant

Jun. 1991 Large diameter manufacturing mill (OD.22"~82") went into operation

Jan. 1993 Obtained ISO 9001 Certification for quality system

Jun. 1993 Titanium Pipe plant went into operation

Jan. 1996 Company name changed to SeAH Steel Corporation

Aug. 1997 Obtained ISO 14001 Certification for Environmental System

Aug. 1998 Pre Coated Metal Plant established in Gunsan

Aug. 1999 Became the first Korean company to develop Duplex stainless pipe.

Oct. 2000 Moved head-office to Jung-gu Bongnae-Dong

Jan. 2001 The Ansan plant went into operation

July. 2001 Split-off (SeAH Steel Corporation, SeAH Holdings Corporation)

Sep. 2005 Established Galvanized Steel Sheets Plant in Gunsan

Nov. 2005 Awarded two hundred million U.S. dollar Export Tower

Feb. 2007 SeAH-POSCO announced a strategic alliance by swapping equities each other

Mar. 2009 Established United Spiral Pipe, LLC in USA (Joint Venture)

Feb. 2010 Established SeAH Steel U.A.E. in Ras Al Khaimah, U.A.E.

Mar. 2012 Acquired SPP Steel pipe (change of company name to SeAH Steel Pipe)

Sep. 2012 Acquired Dongkuk R&S Pohang factory (SeAH Steel Mundeok Plant)

Jan. 2013 Merger with SeAH Steel Pipe (SeAH Steel Suncheon Plant)

Apr. 2014 Acquired Inox Tech S.p.A

Dec. 2016 Acquired Laguna Tubular Products Corporation Houston factory

Steel Pipe Product Range and Capacity

Division			Range	Lines	Production Capacity (MT)
Pohang	ERW		1/2" ~ 24"	6	940,000
	SAWL	Spiral	20" ~ 56"	1	60,000
		Longitudinal	18" ~ 64"	2	200,000
	Subtotal			9	1,200,000
	SRM		½" ~ 4"	1	75,000
	Q.T.		4½" ~ 9⅝"	1	60,000
	OCTG Threading		4½"~20"	3	80,000
Suncheon	SAWH – Spiral		20" ~ 160"	2	120,000
	SAWL – JCO		16" ~ 60"	1	90,000
	SAWL – 3Roll Bender		40" ~ 200"	1	30,000
	Subtotal			4	240,000
Gunsan	ERW		½" ~ 8"	4	250,000
	Zinc Galvanising		½" ~ 24"	2	150,000

Carbon Steel Pipe

Application (Usage)

	Ordinary Piping • Black and galvanized steel pipes • Heat Ventilation and Air Conditioning Systems (HVAC) - Chilled water pipe systems - Condenser water pipe systems - Condensate drain pipes • Fire Services - Riser, down feed for fire hydrant and sprinkler systems • Cable ducting
	Petroleum Industry • Line pipe • Casing and Tubing • Offshore Platform
	Heat Transfer • Boiler tube, heat exchange and tube
	Structural Pipes • General structural pipes • Machine structural tubes • Off-shore structural pipes • Square pipes, steel pipe piles

Approved Certifications

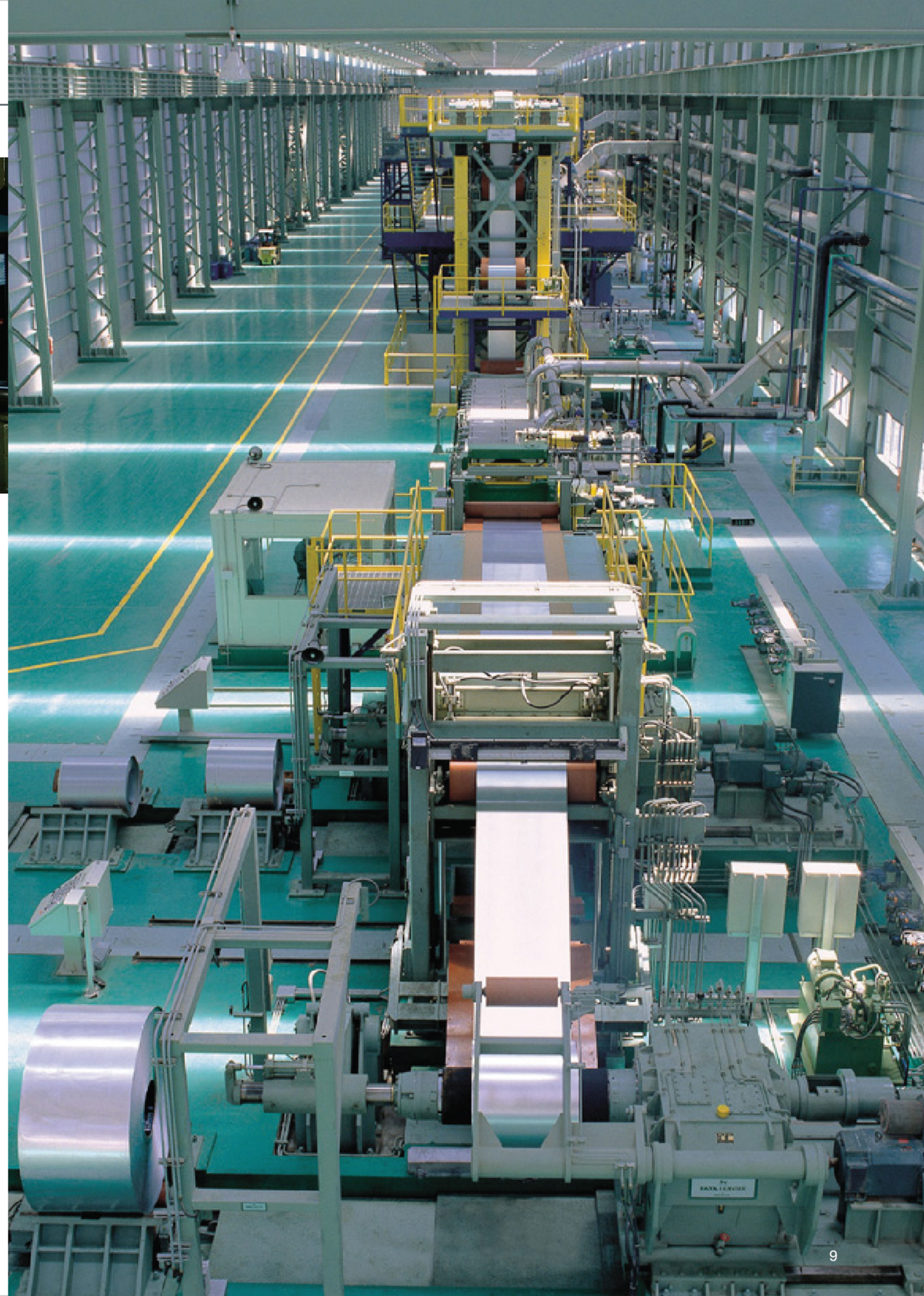
API	UL
- API. Line Pipe (API 5L) Casing & Tubing - Structural pipe (API 2B)	- UL-6 Rigid Metal Conduit
CSA	**ISO**
- Rigid Steel Conduit and Coupling	- ISO 9001 (Carbon Steel Pipe) - ISO 14001 (Carbon Steel Pipe)
DNV	**NSF (USA)**
- Steel Tubes and Pipes for Ordinary Pressure Systems - Steel Tubes and Pipes (ERW & SAW) - Coated Steel Coil and Sheet - Stainless Steel Pipes Tubes & Titanium	- ANSI/NSF Standard 61; Drinking Water System Components Health Effects (ASTM A53 Gr. A, B)

Technical Research Institute

By studying the new steel technologies, new products, research on the automation, design, and facility, SeAH Steel's Technological Research Institute is trying to enhance the value-added products for customers and elevate automation rate of each process for better productivity.

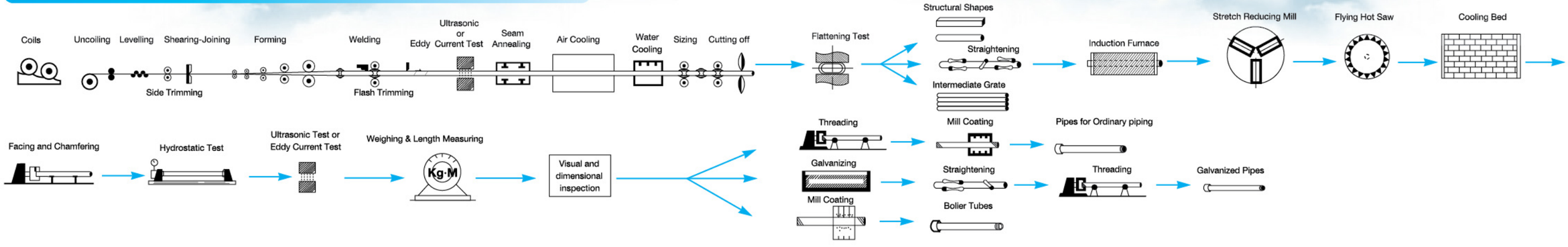
With its accumulated R&D accomplishments and brisk cooperation with other organizations, it has positioned itself as the Think-Tank of SeAH while endeavoring to become a leading research institute in mechanical, electronics, and electrical engineering, as well as metal-making and welding.

Together with customers, for a better future, to become a world-class enterprise, to prove the global acknowledgement on its quality and technological strength, SeAH promises to maintain the devotion with all its energy and efforts.

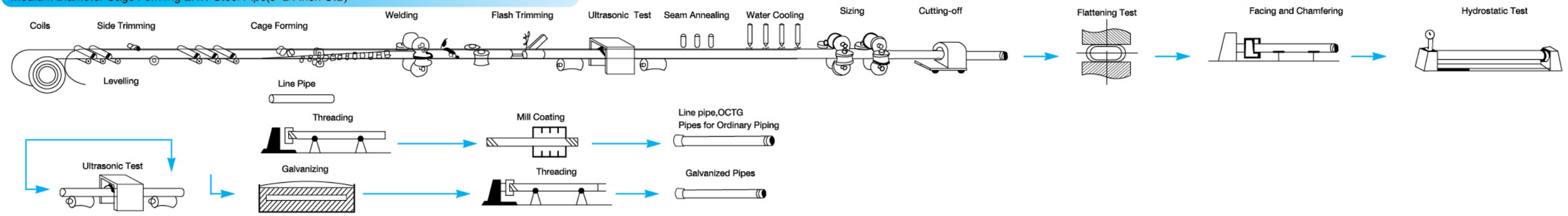


Manufacturing Process

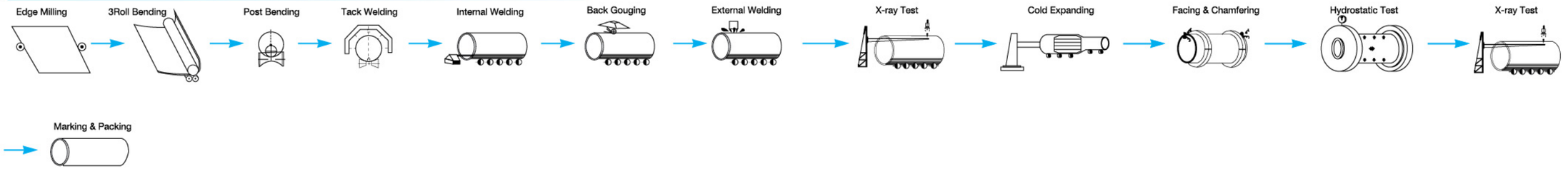
Small Diameter Electric Welded Straight-seam Steel Pipe and Stretch Reducing Mill Pipe(3/8~8 inch O.D)



Medium Diameter Cage Forming ERW Steel Pipe(8~24 inch O.D)



Submerged Arc Welded Logitudinal-Seam Steel Pipe



Submerged Arc Welded Spiral-seam Steel Pipe(400A~2600A)

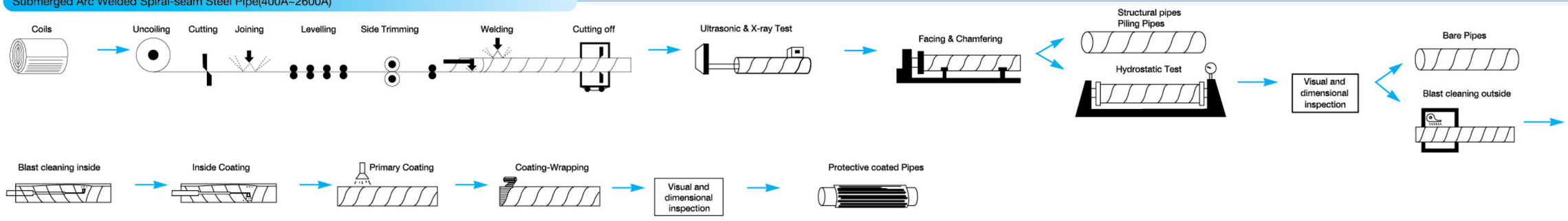
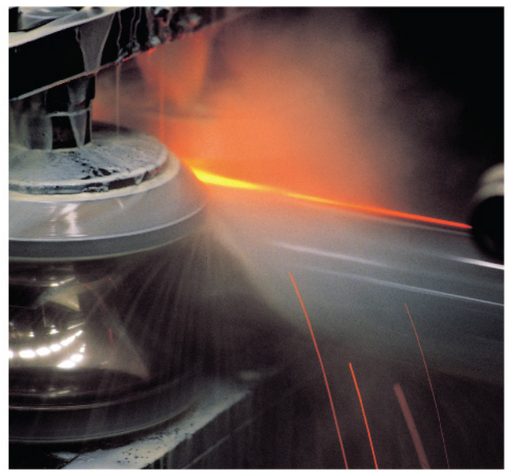


Table 2 - Dimensions, diameter tolerance and mass per unit length

Nominal Size		Specified outside diameter	Outside diameter		H			M		
					Heavy series			Medium series		
		D	max.	min.	Wall thickness	Mass per unit length of bare tube		Wall thickness	Mass per unit length of bare tube	
					T	Plain end	Socketed	T	Plain end	Threaded and socketed
(mm)	(in.)	(mm)	(mm)	(mm)	(mm)	(kg/m)	(kg/m)	(mm)	(kg/m)	(kg/m)
6	1/8	10.2	10.6	9.8	2.6	0.487	0.490	2.0	0.404	0.407
8	1/4	13.5	14.0	13.2	2.9	0.765	0.769	2.3	0.641	0.645
10	3/8	17.2	17.5	16.7	2.9	1.02	1.03	2.3	0.839	0.845
15	1/2	21.3	21.8	21.0	3.2	1.44	1.45	2.6	1.21	1.22
20	3/4	26.9	27.3	26.5	3.2	1.87	1.88	2.6	1.56	1.57
25	1	33.7	34.2	33.3	4.0	2.93	2.95	3.2	2.41	2.43
32	1 1/4	42.4	42.9	42.0	4.0	3.79	3.82	3.2	3.10	3.13
40	1 1/2	48.3	48.8	47.9	4.0	4.37	4.41	3.2	3.56	3.60
50	2	60.3	60.8	59.7	4.5	6.19	6.26	3.6	5.03	5.10
65	2 1/2	76.1	76.6	75.3	4.5	7.93	8.05	3.6	6.42	6.45
80	3	88.9	89.5	88.0	5.0	10.3	10.5	4.0	8.36	8.53
100	4	114.3	115.0	113.1	5.4	14.5	14.8	4.5	12.2	12.5
125	5	139.7	140.8	138.5	5.4	17.9	18.4	5.0	16.6	17.1
150	6	165.1	166.5	163.9	5.4	21.3	21.9	5.0	19.8	20.4



Nominal Size		Specified outside diameter	Outside diameter		L			Outside diameter		L1			Outside diameter		L2		
					Light series					Light series (L1)					Light series (L2)		
		D	max.	min.	Wall thickness	Mass per unit length of bare tube		max.	min.	Wall thickness	Mass length of	per unit bare tube	max.	min.	Wall thickness	Mass per unit length of bare tube	
					T	Plain end	Socketed			T	Plain end	Threaded and socketed			T	Plain end	Threaded and socketed
(mm)	(in.)	(mm)	(mm)	(mm)	(mm)	(kg/m)	(kg/m)	(mm)	(mm)	(mm)	(kg/m)	(kg/m)	(mm)	(mm)	(mm)	(kg/m)	(kg/m)
6	1/4	13.5	13.9	13.2	2.0	0.567	0.571	13.9	13.2	2.0	0.570	0.574	13.6	13.2	1.8	0.515	0.519
8	3/8	17.2	17.4	16.7	2.0	0.750	0.756	17.4	16.7	2.0	0.742	0.748	17.1	16.7	1.8	0.670	0.676
10	1/2	21.3	21.7	21.0	2.3	1.08	1.09	21.7	21.0	2.3	1.08	1.09	21.4	21.0	2.0	0.947	0.956
15	3/4	26.9	27.1	26.4	2.3	1.40	1.41	27.1	26.4	2.3	1.39	1.40	26.9	26.4	2.3	1.38	1.39
20	1	33.7	34.0	33.2	2.9	2.20	2.22	34.0	33.2	2.9	2.20	2.22	33.8	33.2	2.6	1.98	2.00
25	1 1/4	42.4	42.7	41.9	2.9	2.82	2.85	42.7	41.9	2.9	2.82	2.85	42.5	41.9	2.6	2.54	2.57
32	1 1/2	48.3	48.6	47.8	2.9	3.25	3.29	48.6	47.8	2.9	3.24	3.28	48.4	47.8	2.9	3.23	3.27
40	2	60.3	60.7	59.6	3.2	4.51	4.58	60.7	59.6	3.2	4.49	4.56	60.2	59.6	2.9	4.08	4.15
50	2 1/2	76.1	76.0	75.2	3.2	5.75	5.87	76.3	75.2	3.2	5.73	5.85	76.0	75.2	3.2	5.71	5.83
65	3	88.9	88.7	87.9	3.2	6.76	6.93	89.4	87.9	3.6	7.55	7.72	88.7	87.9	3.2	6.72	6.89
80	3 1/2	101.6	101.2	100.3	3.6	8.70	8.88	114.9	113.0	4.0	10.8	11.1	113.9	113.0	3.6	9.75	10.0
100	4	114.3	113.9	113.0	3.6	9.83	10.10										
125	5	139.7	140.8	138.5	4.5	15.0	15.5										
150	6	165.1	166.5	163.9	4.5	17.8	18.4										

BS EN 10217-1 Welded steel tubes for pressure purposes Part1: Non-alloy steel tubes with specified room temperature properties
BS EN 10217-2 Welded steel tubes for pressure purposes Part2: Electric welded non-alloy and alloy steel tubes with specified elevated temperature properties
BS EN 10217-3 Welded steel tubes for pressure purposes Part3: Alloy fine grain steel tubes
BS EN 10217-4 Welded steel tubes for pressure purposes Part4: Electric welded non-alloy steel tubes with specified low temperature properties
BS EN 10217-5 Welded steel tubes for pressure purposes Part5: Submerged arc welded non-alloy and alloy steel tubes with specified elevated temperature properties
BS EN 10217-6 Welded steel tubes for pressure purposes Part6: Submerged arc welded non-alloy and alloy steel tubes with specified low temperature properties
BS EN 10217-7 Welded steel tubes for pressure purposes Part7: Stainless steel tubes

(1) Available Size (Dimension and Weights)

Nominal Size mm	Outside Diameter mm	Thickness (mm)																														Outside Diameter mm	Nominal Size mm
				1.6	1.8	2.0	2.3	2.6	2.9	3.2	3.6	4.0	4.5	5.0	5.4	5.6	6.3	7.1	8.0	8.8	9.5	10.0	11.0	12.5	14.2	16.0	17.5	20.0	22.2	25.0		
		Mass Per Unit Length (kg/m)														Mass Per Unit Length (kg/m)																	
20	26.9					1.23	1.40	1.56	1.72	1.87	2.07	2.26	2.49																			26.9	20
25	33.7					1.56	1.78	1.99	2.20	2.41	2.67	2.93	3.24	3.54	3.77	3.88	4.26															33.7	25
32	42.4				1.80	1.99	2.27	2.55	2.82	3.09	3.44	3.79	4.21	4.61	4.93	5.08	5.61															42.4	32
40	48.3			1.84	2.06	2.28	2.61	2.93	3.25	3.56	3.97	4.37	4.86	5.34	5.71	5.90	6.53	7.21															48.3	40
50	60.3					2.88	3.29	3.70	4.11	4.51	5.03	5.55	6.19	6.82	7.31	7.55	8.39	9.32	10.3	11.2													60.3	50
65	76.1					3.65	4.19	4.71	5.24	5.75	6.44	7.11	7.95	8.77	9.42	9.74	10.8	12.1	13.4	14.6		16.3											76.1	65
80	88.9						4.91	5.53	6.15	6.76	7.57	8.38	9.37	10.3	11.1	11.5	12.8	14.3	16.0	17.4		19.5	21.1											88.9	80
100	114.3						6.35	7.16	7.97	8.77	9.83	10.9	12.2	13.5	14.5	15.0	16.8	18.8	21.0	22.9		25.7	28.0	31.4										114.3	100
125	139.7									10.8	12.1	13.4	15.0	16.6	17.9	18.5	20.7	23.2	26.0	28.4		32.0	34.9	39.2										139.7	125
150	168.3									13.0	14.6	16.2	18.2	20.1	21.7	22.5	25.2	28.2	31.6	34.6		39.0	42.7	48.0										168.3	150
200	219.1											21.2	23.8	26.4	28.5	29.5	33.1	37.1	41.6	45.6		51.6	56.5	63.7	71.8	80.1								219.1	200
250	273.0												29.8	33.0	35.6	36.9	41.4	46.6	52.3	57.3		64.9	71.1	80.3	90.6									273.0	250
300	323.9												35.4	39.3	42.4	44.0	49.3	55.5	62.3	68.4		77.4	84.9	96.0	108									323.9	300
350	355.6												39.0	43.2	46.6	48.3	54.3	61.0	68.6	75.3		85.2	93.5	106	120									355.6	350
400	406.4												44.6	49.5	53.4	55.4	62.2	69.9	78.6	86.3		97.8	107	121	137	154	168							406.4	400
450	457.0												50.2	55.7	60.1	62.3	70.0	78.8	88.6	97.3	105	110	121	137	155	174	190							457.0	450
500	508.0															69.4	77.9	87.7	98.6	108	117	123	135	153	173	194	212	241						508.0	500
550	559.0															76.4	85.9	96.6	109	119	129	135	149	168	191	214	234	266						559.0	550
600	610.0															83.5	93.8	106	119	130	141	148	162	184	209	234	256	291						610.0	600
650	660.0																102	114	129	141		160	176	200	226	254	277	316	349					660.0	650
700	711.0																109	123	139	152		173	190	215	244	274	299	341	377					711.0	700
750	762.0																117	132	149	163		185	204	231	262	294	321	366	405	454				762.0	750
800	813.0																125	141	159	175		198	218	247	280	314	343	391	433	486				813.0	800
850	864.0																133	150	169	186		211	231	262	298	335	365	416	461	517				864.0	850
900	914.0																141	159	179	196		223	245	278	315	354	387	441	488	548				914.0	900
1000	1016.0																157	177	199	219		248	273	309	351	395	431	491	544	611				1016.0	1000
1200	1219.0																189	212	239	263		298	328	372	422	475	519	591	655	736				1219.0	1200
1400	1422.0																220	248	279	307		348	383	435	493	555	606	692	766	861				1422.0	1400
1600	1626.0																	283	319	351		399	438	497	564	635	694	792	878	987				1626.0	1600
1800	1829.0																		359	395		449	493	560	636	715	782	892	989	1112				1829.0	1800
2000	2032.0																			439		499	548	623	707	795	869	992	1100	1237				2032.0	2000
2200	2235.0																					549	604	685	778	876	957	1093	1211	1363				2235.0	2200

Note: Sizes not indicated are on inquiry basis.

List of Specification of ERW Tubes and Pipes

Standard Specification		Application	Chemical Requirement (%) C Max	Mn Max	P Max	S Max	Others	Physical Requirement Tensile Strength Rm (Mpa)	Yield Strength ReH Min. (Mpa)	Elongation (Min %)	Gauge Length (in)
EN10255	L	Steel Pipe for Ordinary Uses (For Screwing)	0.20	1.40	0.035	0.030	–	320~520	195	20	$5.65\sqrt{A}$
	M		0.20	1.40	0.035	0.030	–	320~520	195	20	
	H		0.20	1.40	0.035	0.030	–	320~520	195	20	
EN10217-1	P195TR1	Steel Pipe for Pressure Purposes Ordinary Duties	0.13	0.70	0.025	0.020	Si Max 0.35	320~440	T≤16mm: 195 16mm<T≤40mm: 185	L-direction : 27 T-direction : 25	$5.65\sqrt{A}$
	P195TR2		0.13	0.70	0.025	0.020	Si Max 0.35	320~440	T≤16mm: 195 16mm<T≤40mm: 185	L-direction : 27 T-direction : 25	
	P235TR1		0.16	1.20	0.025	0.020	Si Max 0.35	360~500	T≤16mm: 235 16mm<T≤40mm: 225	L-direction : 25 T-direction : 23	
	P235TR2		0.16	1.20	0.025	0.020	Si Min 0.35	360~500	T≤16mm: 235 16mm<T≤40mm: 225	L-direction : 25 T-direction : 23	
	P265TR1		0.20	1.40	0.025	0.020	Si Min 0.40	410~570	T≤16mm: 265 16mm<T≤40mm: 255	L-direction : 21 T-direction : 19	
	P265TR2		0.20	1.40	0.025	0.020	Si Max 0.40	410~570	T≤16mm: 265 16mm<T≤40mm: 255	L-direction : 21 T-direction : 19	
ASTM A53	A	Steel Pipe for General Purposes	0.25	0.95	0.050	0.060	–	Min 48,000 psi (33.8kg/mm²)	Min 30,000 psi (21.1kg/mm²)	$e=625000 \times \frac{A^{02}}{U^{09}}$	2
	B		0.30	1.20	0.050	0.060	–	Min 60,000 psi (42.2kg/mm²)	Min 35,000 psi (24.6kg/mm²)	$e=625000 \times \frac{A^{02}}{U^{09}}$	2

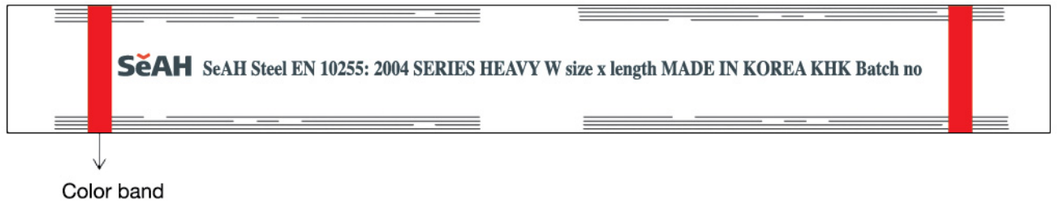
Standard Specification	Flattening Test H = Distance between Exterior Surfaces H¹ = Distance between Interior Surfaces D = Outside Diameter ID = Inside Diameter	Bend Test	Hydrostatic Test P = Test Pressure (psi) S = Allowable Fiber Stress (psi)	Non-Destructive Test and Other Inspections
EN10255	Applicable to O.D. > 60.3mm Welded Part : 0.75 x O.D. Body Part : 0.6 x O.D.	Tested only for O.D. ≤ 60.3mm	Min. 50 bar for at least 5s or NDT or an electro-magnetic test	
EN10217-1	→ O.D. < 600mm, t/D ≤ 0.15 : at 0 or 90 deg. $H = \frac{(1+C)}{C+(T/D)} \times T$ where, H=height, D=O.D., T=W.T. C= 0.09 for P195&P235, 0.07 for P265 → Either flattening or flaring test can be done for O.D. ≤ 150mm & t ≤ 10mm products. d/O.D. (where d=O.D.-2t): ≤0.8 / >0.8 P195: 10% / 12% P235: 10% / 12% P265: 8% / 10%	-	Hydrostatic test or NDT Hydrostatic test shall be carried out Min. 70 bar or following equation P, whichever is lower $P = \frac{20\,st}{D}(bar)$ S = 0.70 x Yield Strength	ERW : ET OR UT SAW : UT OR RT
ASTM A53	Apply for standard weight and extra strong pipe of NB > 2 in. Weld Portion H = ²/₃D The other side of Weld Portion H = ¹/₃D The test shall be made alternately with the weld portion at 0 deg. and at 90 deg.	Apply for NB ≤ 2 in. Ungalvanized Tubes At cold 90°x 6D When ordered for close coiling 180°x 4D	Hydrostatic test shall be carried out following equation P $P = \frac{20\,st}{D}(bar)$ S = 0.60 x Yield Strength But, Maximum pressure is: NB ≤ 2 in. P= 2,500 psi NB > 3 in. P= 2,800 psi	Each pipe shall be inspected by ultrasonic or electromagnetic methods * 6

Continued

Standard Specification	Permissible Variations in Dimensions: Outside Diameter	Wall Thickness	Length	Height of Inside Bead	Permissible Variations in Weight: Single Lengths Standard, Regular, Extra-Strong Double Extra-Strong +10%, -3.5% Special Plain End +10%, -5% Carload Lots -1.75%
EN10255	Specified respectively in Size	±10%	Standard length Welded + 150 / -50, SMLS +/- 500 Random length: 10% can be below range, but none of these to be less than 3m long (0.75 x 4m minimum) Exact length: L ≤ 6m + 10 - 0 6 ≤ L ≤ 12m + 15 -0 L > 12m + by agreement -0	≤50% of wall thickness. For tubes to be galvanized, it should be no higher than 0.3mm + (0.05 x wall thickness)	
EN10217-1	D ≤ 219.1mm, ±1% or ±0.5mm, which ever is larger D > 219.1mm, ±0.75% or ±6mm, which ever is smaller	t ≤ 5mm, ±10% (Min ±0.3) 5mm < t ≤ 40mm, ±8% (Max ±2)	D ≤ 406.4mm → L ≤ 6M, -0/ +10mm → 6M < L ≤ 12M, -0/ +15mm → 12M < L, to be discussed with the customer D ≤ 406.4mm → L ≤ 6M, -0/ +25mm → 6M < L ≤ 12M, -0/ +50mm → 12M < L, to be discussed with the customer	ERW TR1: Max. 1.5mm TR2: 0.5mm + 0.05t SAW → Inside Bead W.T. ≤ 12.5mm, Max 3.5mm 12.5mm < W.T., Max 4.8mm → Outside Bead W.T. ≤ 12.5mm, Max 3.5mm 12.5mm < W.T., Max 4.8mm	Standard ; Random length
ASTM A53	NB ≤ 1 ½ in + 1/64 in. , - 1/32 in. NB ≥ 2 in. ±1%	+Not specified -12.5%	-	-	±10% D ≤ 4 in. may be weighted in convenient lots. D ≤ 4 in. shall be weighted separately

Marking

BS EN 10255



Grade	Color
L	Green
L1	White
L2	Brown
Medium	Blue
Heavy	Red

BS EN 10217

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