

Cold Drawn Electric Resistance Welded Tube

BS 6323 Part 6 : 1982 CEW 1


Chemical Composition - Ladle Analysis

C	Si	Mn	P	S
max %	max %	max %	max %	max %
0.13	—	0.60	0.05	0.05

Mechanical Properties

Condition	Yield Re min N/mm ²	Tensile Rm min N/mm ²	Elongation min %	
BK as drawn	320	400	6	
GBK annealed	150	270	27	
NBK normalized	155	280	25	

Tolerances

Outside diameter			
Over	Up to and Including	Tolerance	
mm	mm	mm +/-	
	30	0.10	
30	50	0.15	
50	70	0.20	
70	90	0.25	
90	110	0.30	
110	130	0.35	
130	160	0.45	
Wall thickness			Ovality
The tolerance including eccentricity, shall be +/- 7.50% with a minimum of +/- 0.1mm.			The tolerance for outside diameter includes ovality.
			Straightness
			Tubes shall not depart from straightness by more than 1.5 in 1000

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Chemical Composition

GRADE	C %	Si %	Mn %	P & S %
CEW 2	0.16 max		0.70 max	0.050 max
CEW 3	0.20 max	0.35 max	0.90 max	0.050 max
CEW 4	0.25 max	0.35 max	1.20 max	0.050 max
CEW 5	0.23 max	0.50 max	1.50 max	0.050 max

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	Wall	0.71	0.81	0.91	1.22	1.42	1.63	2.03	2.34	2.64	2.95	3.25	4.06	4.76	4.88	6.35	7.94	9.53	12.70
O.D.																			
4.76																			
6.35				●	●		●												
7.94				●	●		●	●											
9.53				●	●	●	●	●		●		●							
11.11				●	●	●	●	●											
12.70				●	●	●	●	●		●		●							
14.29		●		●	●		●	●		●	●	●							
15.88				●	●		●	●		●	●	●	●		●				
17.46				●			●	●				●							
19.05					●		●	●		●	●	●	●		●	●			
20.64							●	●				●							
22.22					●	●	●	●		●	●	●	●		●	●			
25.40					●	●	●	●	●	●	●	●	●		●	●			
26.99							●	●				●	●		●				
28.58					●	●	●	●		●		●	●		●	●			
30.16							●	●		●									
31.75					●		●	●		●		●	●		●	●	●		
33.34							●						●						
34.93					●		●	●		●		●	●		●	●	●	●	
38.10							●	●		●		●	●		●	●	●	●	
39.69												●			●				
41.28							●	●		●		●	●		●	●	●	●	
42.86										●		●							
44.45							●	●		●		●	●		●	●	●	●	
47.63										●		●	●		●	●	●		
50.80					●		●	●		●		●	●		●	●	●	●	
53.98												●			●	●	●	●	
57.15								●		●		●	●		●	●		●	
60.33							●					●	●		●	●	●	●	
63.50								●		●		●	●		●	●	●	●	
66.68												●			●	●			
69.85										●		●	●		●	●		●	●
73.02							●											●	●
76.20							●	●		●		●			●	●	●	●	●
79.38							●												
82.55							●			●		●				●		●	
88.90												●				●	●	●	
95.25												●				●			
101.60												●	●			●			
107.95												●				●			
114.30												●				●			
127.00												●							●

Non standard sizes available upon request