

Table 10 — Tolerances for diameter and out-of-roundness

Specified outside diameter <i>D</i> mm (in)	Diameter tolerances ^d				Out-of-roundness tolerances	
	mm (in)		mm (in)		mm (in)	
	Pipe except the end ^a		Pipe end ^{a,b,c}		Pipe except the end ^a	Pipe end ^{a,b,c}
	SMLS pipe	Welded pipe	SMLS pipe	Welded pipe		
< 60,3 (2.375)	- 0,8 (0.031) to + 0,4 (0.016)		- 0,8 (0.031) to + 0,4 (0.016)		1,2 (0.048)	0,9 (0.036)
≥ 60,3 (2.375) to 168,3 (6.625)	± 0,007 5 <i>D</i>		- 0,4 (0.016) to + 1,6 (0.063)		0,020 <i>D</i> for $\frac{D}{t} \leq 75$; by agreement for $\frac{D}{t} > 75$	0,015 <i>D</i> for $\frac{D}{t} \leq 75$; by agreement for $\frac{D}{t} > 75$
> 168,3 (6.625) to 610 (24.000)	± 0,007 5 <i>D</i>	± 0,007 5 <i>D</i> , but maximum of ± 3,2 (0.125)	± 0,005 <i>D</i> , but maximum of ± 1,6 (0.063)		0,020 <i>D</i>	0,015 <i>D</i>
> 610 (24.000) to 1 422 (56.000)	± 0,01 <i>D</i>	± 0,005 <i>D</i> , but maximum of ± 4,0 (0.160)	± 2,0 (0.079)	± 1,6 (0.063)	0,015 <i>D</i> , but maximum of 15 (0.6) for $\frac{D}{t} \leq 75$; by agreement for $\frac{D}{t} > 75$	0,01 <i>D</i> , but maximum of 13 (0.5) for $\frac{D}{t} \leq 75$; by agreement for $\frac{D}{t} > 75$
> 1 422 (56.000)	as agreed					

^a The pipe end includes a length of 100 mm (4.0 in) at each of the pipe extremities.

^b For SMLS pipe, the tolerances apply for $t \leq 25,0$ mm (0.984 in), and the tolerances for thicker pipe shall be as agreed.

^c For expanded pipe with $D \geq 219,1$ mm (8.625 in) and for non-expanded pipe, the diameter tolerance and the out-of-roundness tolerance may be determined using the calculated inside diameter (the specified outside diameter minus two times the specified wall thickness) or measured inside diameter rather than the specified outside diameter (see 10.2.8.3).

^d For determining compliance to diameter tolerances, the pipe diameter is defined as the circumference of the pipe in any circumferential plane divided by Pi.

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