

# IS: 1239 (Part 1)- 2004



Technical Details And Specifications											
Specifications for Black and Galvanized Steel Pipes Conforming to IS:1239 (Part-I) 2004											
NB	Class	Outside Diameter in mm		Thickness in mm		Calculated nominal weight				Sockets	
		Min	Max			Plain end		Screwed & Sockets		Min. OD mm	Min. Length mm
				Kg/m	M/Ton	Kg/m	M/Ton				
15 (1/2")	L	21	21.4	2	14	0.947	1056	0.956	1046	27	37
	M	21	21.8	2.6	12	1.21	826	1.22	820	27	37
	H	21	21.8	3.2	10	1.44	694	1.45	690	27	37
20 (3/4")	L	26.4	26.9	2.3	13	1.38	725	1.39	719	32.5	39
	M	26.5	27.3	2.6	12	1.56	641	1.57	637	32.5	39
	H	26.5	27.3	3.2	10	1.87	535	1.88	532	32.5	39
25 (1")	L	33.2	33.8	2.6	12	1.98	505	2	500	39.5	46
	M	33.3	34.2	3.2	10	2.41	415	2.43	412	39.5	46
	H	33.3	34.2	4	8	2.93	341	2.95	339	39.5	46
32 (1 1/4")	L	41.9	42.5	2.6	12	2.54	394	2.57	389	49	51
	M	42	42.9	3.2	10	3.1	322	3.13	319	49	51
	H	42	42.9	4	8	3.79	264	3.82	262	49	51
40 (1 1/4")	L	47.8	48.4	2.9	11	3.23	310	3.27	306	56	51
	M	47.9	48.8	3.2	10	3.56	281	3.6	278	56	51
	H	47.9	48.8	4	8	4.37	229	4.41	227	56	51
50 (2")	L	59.6	60.2	2.9	11	4.08	245	4.15	241	68	60
	M	59.7	60.8	3.6	9	5.03	199	5.1	196	68	60
	H	59.7	60.8	4.5	7	6.19	161	6.26	160	68	60
65 (2 1/2")	L	75.2	76	3.2	10	5.71	175	5.83	172	84	69
	M	75.3	76.6	3.6	9	6.42	156	6.54	153	84	69
	H	75.3	76.6	4.5	7	7.93	126	8.05	124	84	69
80 (3")	L	87.9	88.7	3.2	10	6.72	149	6.89	145	98	75
	M	88	89.5	4	8	8.36	120	8.53	117	98	75
	H	88	89.5	4.8	6	9.9	101	10.1	99	98	75
100 (4")	L	113	113.9	3.6	9	9.75	102	10	100	124	87
	M	113.1	115	4.5	7	12.2	82	12.5	80	124	87
	H	113.1	115	5.4	5	14.5	69	14.8	68	124	87
125 (5")	M	138.5	140.8	4.8	6	15.9	63	16.4	61	151	96
	H	138.5	140.8	5.4	5	17.9	56	18.4	54	151	96
150 (6")	M	163.9	166.5	4.8	6	18.9	53	19.5	51	178	96
	H	163.9	166.5	5.4	5	21.3	47	21.9	46	178	96

Tolerances As Per IS: 1239- 2004				
A. Thickness	Tolerance	B. Weight	Tolerance	C. Length
1. Light Tubes	+ Not Limited -8%	1. Single Tube (light series)	+10% -8%	Light, Medium & Heavy tubes Random Length of 4 to 7 meters unless specified otherwise
2. Medium and Heavy Tubes	+ Not Limited -10%	2. Single Tubes (medium & heavy series)	±10%	
		3. For quantities per load of 10 Tons min. (Light series)	+7.5% -5%	
		4. For quantities per load of 10 Tons min. (medium & heavy series)	±7.5%	