

# Steel tubes for precision applications — Technical delivery conditions —

## Part 1: Seamless cold drawn tubes

The European Standard EN 10305-1:2002 has the status of a  
British Standard

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## National foreword

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The UK participation in its preparation was entrusted to Technical Committee ISE/8, Steel pipes, which has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible international/European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

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### Summary of pages

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Tubes de précision en acier - Conditions techniques de  
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1: Nahtlose kaltgezogene Rohre

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## Contents

Foreword.....	4
1 Scope .....	5
2 Normative references .....	5
3 Terms and definitions.....	6
4 Symbols .....	6
5 Classification and designation .....	6
5.1 Classification.....	6
5.2 Designation.....	6
6 Information to be supplied by the purchaser.....	7
6.1 Mandatory information .....	7
6.2 Option.....	7
6.3 Example of an order .....	8
7 Manufacturing process .....	8
7.1 Steelmaking process .....	8
7.2 Tube manufacture and delivery conditions .....	8
8 Requirements .....	9
8.1 General.....	9
8.2 Chemical composition.....	9
8.3 Mechanical properties .....	10
8.4 Appearance and internal soundness .....	11
8.5 Dimensions and tolerances .....	12
9 Inspection .....	17
9.1 Types of inspection .....	17
9.2 Inspection documents.....	17
9.3 Summary of inspection and testing.....	18
10 Sampling .....	19
10.1 Test unit .....	19
10.2 Preparation of samples and test pieces .....	19
11 Test methods.....	19
11.1 Tensile test .....	19
11.2 Flattening test.....	20
11.3 Drift expanding test .....	20
11.4 Dimensional inspection.....	20
11.5 Roughness measurement.....	21
11.6 Visual examination .....	21
11.7 Non-destructive testing.....	21

<b>11.8</b>	<b>Retests, sorting and reprocessing</b> .....	<b>21</b>
<b>12</b>	<b>Marking</b> .....	<b>21</b>
<b>13</b>	<b>Protection and packaging</b> .....	<b>21</b>
<b>Annex A</b>	<b>(normative) Requirements for additional steel grades</b> .....	<b>23</b>
<b>Annex B</b>	<b>(informative) List of corresponding former symbols for delivery conditions and national steel designations</b> .....	<b>27</b>
<b>Bibliography</b>	.....	<b>29</b>

## Foreword

This document EN 10305-1:2002 has been prepared by Technical Committee ECISS /TC 29, "Steel tubes and fittings for steel tubes" the secretariat of which is held by UNI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2003, and conflicting national standards shall be withdrawn at the latest by May 2003.

EN 10305 consists of the following Parts under the general title : *Steel tubes for precision applications — Technical delivery conditions* :

- Part 1: *Seamless cold drawn tubes.*
- Part 2: *Welded cold drawn tubes.*
- Part 3: *Welded cold sized tubes.*
- Part 4: *Seamless cold drawn tubes for hydraulic and pneumatic power systems.*
- Part 5: *Welded and cold sized square and rectangular tubes.*
- Part 6: *Welded cold drawn tubes for hydraulic and pneumatic power systems.*

In this European Standard the annex A is normative and the annex B is informative.

This document includes a Bibliography.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard : Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

## 1 Scope

This Part of EN 10305 specifies the technical delivery conditions for seamless cold drawn steel tubes of circular cross section for precision applications.

NOTE This Part of EN 10305 can also cover other types of cross section.

Tubes according to this Part of EN 10305 are characterized by having precisely defined tolerances on dimensions and a specified surface roughness. Typical fields of application are in the vehicle, furniture and general engineering industries.

## 2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text, and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 10002-1, *Metallic materials — Tensile testing — Part 1 : Method of test at ambient temperature.*

EN 10020, *Definition and classification of grades of steel.*

EN 10021, *General technical delivery requirements for steel and iron products.*

EN 10027-1, *Designation systems for steel — Part 1 : Steel names, principal symbols.*

EN 10027-2, *Designation systems for steels — Part 2 : Numerical system.*

EN 10052, *Vocabulary of heat treatment terms for ferrous products.*

EN 10204, *Metallic products — Types of inspection documents.*

EN 10233, *Metallic materials — Tube — Flattening test.*

EN 10234, *Metallic materials — Tube — Drift expanding test.*

EN 10246-1, *Non-destructive testing of steel tubes — Part 1 : Automatic electromagnetic testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for verification of hydraulic leak-tightness.*

EN 10246-3, *Non-destructive testing of steel tubes — Part 3 : Automatic eddy current testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of imperfections.*

EN 10246-5, *Non-destructive testing of steel tubes — Part 5 : Automatic full peripheral magnetic transducer/flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal imperfections.*

EN 10246-7, *Non-destructive testing of steel tubes — Part 7 : Automatic full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal imperfections.*

EN 10256, *Non-destructive testing of steel tubes — Qualification and competence of level 1 and 2 non-destructive testing personnel.*

EN ISO 377, *Steel and steel products — Location and preparation of samples and test pieces for mechanical testing (ISO 377:1997).*

EN ISO 2566-1, *Steel — Conversion of elongation values — Part 1 : Carbon and low alloy steels (ISO 2566-1:1984).*

## EN 10305-1:2002 (E)

prEN 10168<sup>1)</sup>, *Iron and steel products — Inspection documents — List of information and description.*

ENV 10220, *Seamless and welded steel tubes — Dimensions and masses per unit length.*

prEN 10266<sup>1)</sup>, *Steel tubes, fittings and structural hollow sections — Definitions and symbols for use in product standards.*

EN ISO 4287, *Geometrical product specifications (GPS) - Surface texture: Profile method - Terms, definitions and surface texture parameters (ISO 4287:1997).*

CR 10260, *Designation systems for steel — Additional symbols.*

### 3 Terms and definitions

For the purposes of this European Standard, the terms and definitions given in EN 10020, EN 10021, EN 10052, prEN 10266 and the following apply.

#### 3.1

##### **employer**

organization for which a person works on a regular basis

NOTE The employer may be either the tube manufacturer or a third party organization providing non-destructive testing (NDT) services.

### 4 Symbols

See prEN 10266.

NOTE In this Part of EN 10305 "T" is the specified or the calculated wall thickness.

### 5 Classification and designation

#### 5.1 Classification

In accordance with the classification system in EN 10020 the steel grades given in Table 2 are non-alloy quality steels.

The steel grades given in Table A.1 are non-alloy quality steels (E255, E410, 26Mn5, 10S10, 15S10, 18S10 and 37S10), non-alloy special steels (C35E and C45E) and alloy special steels (26Mo2, 25CrMo4 and 42CrMo4).

#### 5.2 Designation

For the tubes covered by this Part of EN 10305 the steel designation consists of:

— the number of this Part of EN 10305;

plus either:

— the steel name in accordance with EN 10027-1 and CR 10260; or

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1) In preparation, until this document is published as a European Standard a corresponding national standard should be agreed at the time of enquiry and order.



— the steel number in accordance with EN 10027-2.

## 6 Information to be supplied by the purchaser

### 6.1 Mandatory information

The following information shall be supplied by the purchaser at the time of enquiry and order:

- a) the quantity (mass or total length or number);
- b) the term "tube";
- c) the dimensions (see 8.5);
- d) the designation of the steel grade in accordance with this Part of EN 10305 (see 5.2);
- e) the delivery condition including the surface condition (see 7.2.1 and 7.2.2);
- f) the type of tube length and, where applicable, the length (see 8.5.2).

### 6.2 Option

A number of options are specified in this Part of EN 10305 and these are listed below. In the event that the purchaser does not indicate a wish to implement any of these options at the time of enquiry and order, the tubes shall be supplied in accordance with the basic specification (see 6.1).

- 1) Specification of a steel grade not specified in this Part of EN 10305 (see 8.2);
- 2) specification of a sulphur range to support machinability (see 8.2);
- 3) surface condition for further processing (see 8.4.1.1);
- 4) measurement of surface roughness (see 8.4.1.5);
- 5) lower surface roughness (see 8.4.1.5);
- 6) defined removable substances on surface (see 8.4.1.6);
- 7) non-destructive testing for the detection of longitudinal imperfections (see 8.4.2);
- 8) non-destructive testing for verification of leak-tightness (see 8.4.2);
- 9) agreement on a cross section other than circular (see 8.5.1.1);
- 10) tubes specified by outside or inside diameter and wall thickness (see 8.5.1.1);
- 11) reduced diameter tolerances (see 8.5.1.2);
- 12) diameter tolerances unilateral (see 8.5.1.2);
- 13) reduced concentricity (see 8.5.1.3);
- 14) reduced wall thickness tolerance (see 8.5.1.4);
- 15) wall thickness tolerance unilateral (see 8.5.1.4);
- 16) agreement on a tolerance for exact lengths  $\leq 500$  mm or  $> 8\,000$  mm (see Table 7);
- 17) specified end finishing (see 8.5.4);

## EN 10305-1:2002 (E)

- 18) specific inspection (see 9.1);
- 19) inspection certificates 3.1.A or 3.1.C (see 9.2.1);
- 20) flattening or drift expanding test (see Table 8);
- 21) test unit with tubes from one cast only (see 10.1);
- 22) alternative marking (see clause 12);
- 23) delivery without corrosion protection (see clause 13);
- 24) specified corrosion protection (see clause 13);
- 25) specified method of packaging (see clause 13).

### 6.3 Example of an order

12 000 m tube with an outside diameter of 60 mm and an inside diameter of 56 mm in accordance with this Part of EN 10305, made of steel grade E235 in the normalized condition, delivered in random lengths, with a 3.1.B inspection certificate in accordance with EN 10204 :

12 000 m tube - 60 x ID 56 - EN 10305-1 - E235 +N - random length - Option 18

## 7 Manufacturing process

### 7.1 Steelmaking process

The steelmaking process is at the discretion of the manufacturer.

Steels shall be fully killed.

### 7.2 Tube manufacture and delivery conditions

**7.2.1** The tubes shall be manufactured from hot finished seamless tubes by cold drawing or other suitable processes.

**7.2.2** The tubes shall be supplied in one of the delivery conditions given in Table 1.

**7.2.3** All non-destructive testing (NDT) activities shall be carried out by qualified and competent level 1, 2 and/or 3 personnel authorized to operate by the employer.

The qualification shall be in accordance with EN 10256 or, at least, an equivalent to it.

It is recommended that the level 3 personnel be certified in accordance with EN 473 or, at least, an equivalent to it.

The operating authorization issued by the employer shall be in accordance with a written procedure. NDT operations shall be authorized by a level 3 NDT individual approved by the employer.

NOTE The definition of level 1, 2 and 3 can be found in appropriate standards, e.g. EN 473 and EN 10256.

Table 1 — Delivery conditions

Designation	Symbol <sup>a</sup>	Description
Cold drawn / hard	+C	No heat treatment after the final cold drawing process.
Cold drawn / soft	+LC	After the final heat treatment there is a suitable drawing pass.
Cold drawn and stress relieved	+SR	After the final cold drawing process there is a stress relief heat treatment in a controlled atmosphere.
Annealed	+A	After the final cold drawing process the tubes are annealed in a controlled atmosphere.
Normalized	+N	After the final cold drawing operation the tubes are normalized in a controlled atmosphere.
<sup>a</sup> Former frequently used corresponding heat treatment symbols are given in Table B.1.		

## 8 Requirements

### 8.1 General

The tubes, when supplied in a delivery condition indicated in Table 1 and inspected in accordance with clauses 9, 10 and 11, shall comply with the requirements of this Part of EN 10305.

In addition, the general technical delivery requirements specified in EN 10021 shall apply.

### 8.2 Chemical composition

The cast analysis reported by the steel producer shall apply and comply with the requirements of Table 2 (but see options 1 and 2 or Table A.1. A steel grade not specified in this Part of EN 10305 may be specified (see option 1).

**Option 1:** A steel grade not specified in this Part of EN 10305 with a maximum total content of alloying elements of 5 % is specified. Chemical composition, mechanical properties and delivery condition are specified by the purchaser.

**NOTE** When welding tubes are produced in accordance with this Part of EN 10305 account should be taken of the fact that the behaviour of the steel during and after welding is dependent not only on the steel and the delivery condition but also on the conditions of preparing for and carrying out the welding.

Table 2 — Chemical composition (cast analysis) <sup>a</sup>

Steel grade		% by mass					
Steel name	Steel number	C max.	Si max.	Mn max.	P max.	S <sup>b</sup> max.	Al min.
E215	1.0212	0,10	0,05	0,70	0,025	0,025	0,025
E235	1.0308	0,17	0,35	1,20	0,025	0,025	-
E355 <sup>c</sup>	1.0580	0,22	0,55	1,60	0,025	0,025	-
<sup>a</sup> Elements not included in this Table (but see footnote c) shall not be intentionally added to the steel without the agreement of the purchaser, except for elements which may be added for finishing the cast. All appropriate measures shall be taken to prevent the addition of undesirable elements from scrap or other materials used in the steel making process. <sup>b</sup> See option 2. <sup>c</sup> Additions of Nb, Ti and V are permitted at the discretion of the manufacturer. The content of these elements shall be reported.							

**Option 2:** For the steel grades E235 and E355 a controlled sulphur content of 0,015 % to 0,040 % is specified to support machinability. It shall be obtained by resulphurising the steel after maximum desulphurisation or alternatively by using a low oxygen process.

Table 3 specifies the limit deviations of product analysis from the specified limits on cast analysis given in Table 2.

**Table 3 — Permissible deviations of the product analysis from the specified limits on cast analysis given in Table 2**

Element	Limiting value for cast analysis in accordance with Table 2 in % by mass	Permissible deviation of the product analysis in % by mass
C	≤ 0,22	+0,02
Si	≤ 0,55	+0,05
Mn	≤ 1,60	+0,10
P	≤ 0,025	+0,005
S	≤ 0,040	±0,005
Al	≥ 0,025	-0,005

### 8.3 Mechanical properties

The mechanical properties of the tubes shall conform to the requirements of Table 4, Table A.3 and, if applicable, 11.2 or 11.3.

NOTE Subsequent processing (cold or hot) may change the mechanical properties.

**Table 4 — Mechanical properties at room temperature**

Steel grade		Minimum values for the delivery condition <sup>a,b</sup>											
Steel name	Steel number	+C <sup>c</sup>		+LC <sup>c</sup>		+SR			+A <sup>d</sup>		+N		
		$R_m$ MPa	A %	$R_m$ MPa	A %	$R_m$ MPa	$R_{eH}$ MPa	A %	$R_m$ MPa	A %	$R_m$ MPa	$R_{eH}$ <sup>e</sup> MPa	A %
E215	1.0212	430	8	380	12	380	280	16	280	30	290 to 430	215	30
E235	1.0308	480	6	420	10	420	350	16	315	25	340 to 480	235	25
E355	1.0580	640	4	580	7	580	450 <sup>f</sup>	10	450	22	490 to 630	355	22

<sup>a</sup>  $R_m$  : tensile strength ;  $R_{eH}$  : upper yield strength (but see 11.1) ; A: elongation after fracture. For symbols for the delivery condition see Table 1.

<sup>b</sup> 1 MPa = 1 N/mm<sup>2</sup>.

<sup>c</sup> Depending on the degree of cold work in the finishing pass the yield strength may nearly be as high as the tensile strength. For calculation purposes the following relationships are recommended :  
 — for delivery condition +C :  $R_{eH} \geq 0,8 R_m$  ;  
 — for delivery condition +LC :  $R_{eH} \geq 0,7 R_m$ .

<sup>d</sup> For calculation purposes the following relationship is recommended :  $R_{eH} \geq 0,5 R_m$ .

<sup>e</sup> For tubes with outside diameter ≤ 30 mm and wall thickness ≤ 3 mm the  $R_{eH}$  minimum values are 10 MPa lower than the values given in this Table.

<sup>f</sup> For tubes with outside diameter > 160 mm:  $R_{eH} \geq 420$  MPa.

## 8.4 Appearance and internal soundness

### 8.4.1 Appearance

**8.4.1.1** The internal and external surface finish of the tubes shall be typical of the manufacturing process and, where applicable, the heat treatment, and it shall be such that any surface imperfections such as ridges, dents or shallow grooves requiring dressing can be identified.

**Option 3:** A surface condition suitable for special further processing is specified by the purchaser.

**8.4.1.2** Any surface imperfections, whose depth cannot be clearly identified (i.e. scales, overlaps) shall be dressed in accordance with 8.4.1.3 or treated in accordance with 8.4.1.4.

**8.4.1.3** It shall be permissible to dress, only by grinding or machining, surface imperfections provided that, after doing so, the dimensions are within the specified tolerances. All dressed areas shall blend smoothly into the contour of the tube.

**8.4.1.4** Surface imperfections which encroach on the specified minimum wall thickness shall be considered defects and tubes containing these shall be deemed not to conform to this Part of EN 10305.

**8.4.1.5** The tubes shall have smooth outer and inner surfaces. The roughness  $R_a$  shall be :

—  $\leq 4 \mu\text{m}$  on the outer surface of tubes in the delivery conditions +SR, +A and +N ;

—  $\leq 4 \mu\text{m}$  on the outer and inner surface of tubes in the delivery conditions +C and +LC.

Verification of surface roughness and/or lower roughness values may be specified (see options 4 and 5).

NOTE In the case of the inner surface this requirement applies to inner diameters  $\geq 15$  mm.

**Option 4:** The surface roughness shall be measured and reported.

**Option 5:** The tubes shall have a specified surface roughness. Type and limiting value of roughness shall be agreed at the time of enquiry and order. The roughness shall be measured and reported.

**8.4.1.6** Tubes in the delivery condition +C or +LC normally have thin layers of lubricant and lubricant carrier as a result of the cold finishing process.

**Option 6:** The tube surfaces shall only bear residual substances which can be easily removed during processing of the tube. Specific requirements shall be agreed.

Tubes in the delivery condition +SR may have thin layers of lubricant and lubricant carrier partially transformed during stress relieve annealing. Tubes in the delivery condition +SR, +A or +N shall be free of loose scale but may show discoloration.

### 8.4.2 Internal soundness

Verification of internal soundness by non-destructive testing may be specified by the purchaser (see options 7 and 8).

**Option 7:** Non-destructive testing for the detection of longitudinal imperfections shall be carried out according to 11.7.1.

**Option 8:** Non-destructive testing for verification of leak tightness shall be carried out in accordance with 11.7.2.

## 8.5 Dimensions and tolerances

### 8.5.1 Outside diameter, inside diameter and wall thickness

**8.5.1.1** Circular tubes (but see option 9) shall be specified by the outside and the inside diameter, unless option 10 is specified.

**Option 9:** An agreed cross section other than circular is specified.

**Option 10:** The tubes shall be specified by outside diameter and wall thickness or by inside diameter and wall thickness.

**8.5.1.2** Diameters and wall thicknesses based with minor modifications on sizes in ENV 10220, as well as diameter tolerances, are given in Table 5.

For intermediate sizes the tolerances of the next greater size apply.

The diameter tolerances include the out-of-roundness.

The diameter tolerances given in Table 5 apply for tubes in delivery condition +C or +LC. Depending on the ratio of wall thickness and outside diameter the corresponding tolerances of heat treated tubes in delivery condition +SR, +A and +N are given by consideration of the corrective factors in Table 6. Other diameter tolerances may be specified (see options 11 and 12).



Table 5 (end)

Specified outside diameter <i>D</i> and tolerance	Wall thickness <i>T</i>																											
	0,5	0,6	1	1,2	1,5	1,8	2	2,2	2,5	2,6	3	3,5	4	4,5	5	5,5	6	7	8	9	10	12	14	16	18	20	22	25
150 ±0,80											144 <sup>+0,80</sup>	143 <sup>+0,80</sup>	142 <sup>+0,80</sup>	141 <sup>+0,80</sup>	140 <sup>+0,80</sup>	139 <sup>+0,80</sup>	138 <sup>+0,80</sup>	136 <sup>+0,80</sup>	134 <sup>+0,80</sup>	132 <sup>+0,80</sup>	130 <sup>-0,80</sup>	126 <sup>+0,80</sup>	122 <sup>+0,80</sup>	118 <sup>+0,80</sup>	114 <sup>+0,80</sup>	110 <sup>+0,80</sup>		
160											154 <sup>+0,80</sup>	153 <sup>+0,80</sup>	152 <sup>+0,80</sup>	151 <sup>+0,80</sup>	150 <sup>+0,80</sup>	149 <sup>+0,80</sup>	148 <sup>+0,80</sup>	146 <sup>+0,80</sup>	144 <sup>+0,80</sup>	142 <sup>+0,80</sup>	140 <sup>-0,80</sup>	136 <sup>+0,80</sup>	132 <sup>+0,80</sup>	128 <sup>+0,80</sup>	124 <sup>+0,80</sup>	120 <sup>+0,80</sup>		
170 ±0,80											164 <sup>+0,90</sup>	163 <sup>+0,90</sup>	162 <sup>+0,90</sup>	161 <sup>+0,90</sup>	160 <sup>+0,90</sup>	159 <sup>+0,90</sup>	158 <sup>+0,90</sup>	156 <sup>+0,90</sup>	154 <sup>+0,90</sup>	152 <sup>+0,90</sup>	150 <sup>-0,90</sup>	146 <sup>+0,90</sup>	142 <sup>+0,90</sup>	138 <sup>+0,90</sup>	134 <sup>+0,90</sup>	130 <sup>+0,90</sup>		
180											173 <sup>+0,90</sup>	173 <sup>+0,90</sup>	172 <sup>+0,90</sup>	171 <sup>+0,90</sup>	170 <sup>+0,90</sup>	169 <sup>+0,90</sup>	168 <sup>+0,90</sup>	166 <sup>+0,90</sup>	164 <sup>+0,90</sup>	162 <sup>+0,90</sup>	160 <sup>-0,90</sup>	156 <sup>+0,90</sup>	152 <sup>+0,90</sup>	148 <sup>+0,90</sup>	144 <sup>+0,90</sup>	140 <sup>+0,90</sup>		
190 ±1,00											183 <sup>+1,0</sup>	183 <sup>+1,0</sup>	182 <sup>+1,0</sup>	181 <sup>+1,0</sup>	180 <sup>+1,0</sup>	179 <sup>+1,0</sup>	178 <sup>+1,0</sup>	176 <sup>+1,0</sup>	174 <sup>+1,0</sup>	172 <sup>+1,0</sup>	170 <sup>-1,0</sup>	166 <sup>+1,0</sup>	162 <sup>+1,0</sup>	158 <sup>+1,0</sup>	154 <sup>+1,0</sup>	150 <sup>+1,0</sup>	146 <sup>+1,0</sup>	
200											193 <sup>+1,0</sup>	193 <sup>+1,0</sup>	192 <sup>+1,0</sup>	191 <sup>+1,0</sup>	190 <sup>+1,0</sup>	89 <sup>+1,0</sup>	188 <sup>+1,0</sup>	186 <sup>+1,0</sup>	184 <sup>+1,0</sup>	182 <sup>+1,0</sup>	180 <sup>-1,0</sup>	176 <sup>+1,0</sup>	172 <sup>+1,0</sup>	168 <sup>+1,0</sup>	164 <sup>+1,0</sup>	160 <sup>+1,0</sup>	156 <sup>+1,0</sup>	
220 ±1,20														211 <sup>+1,2</sup>	210 <sup>+1,2</sup>	209 <sup>+1,2</sup>	208 <sup>+1,2</sup>	206 <sup>+1,2</sup>	204 <sup>+1,2</sup>	202 <sup>+1,2</sup>	200 <sup>-1,2</sup>	196 <sup>+1,2</sup>	192 <sup>+1,2</sup>	188 <sup>+1,2</sup>	184 <sup>+1,2</sup>	180 <sup>+1,2</sup>	176 <sup>+1,2</sup>	170 <sup>+1,2</sup>
240														231 <sup>+1,2</sup>	230 <sup>+1,2</sup>	229 <sup>+1,2</sup>	228 <sup>+1,2</sup>	226 <sup>+1,2</sup>	224 <sup>+1,2</sup>	222 <sup>+1,2</sup>	220 <sup>-1,2</sup>	216 <sup>+1,2</sup>	212 <sup>+1,2</sup>	208 <sup>+1,2</sup>	204 <sup>+1,2</sup>	200 <sup>+1,2</sup>	196 <sup>+1,2</sup>	190 <sup>+1,2</sup>
260 ±1,30														250 <sup>+1,3</sup>	249 <sup>+1,3</sup>	249 <sup>+1,3</sup>	248 <sup>+1,3</sup>	246 <sup>+1,3</sup>	244 <sup>+1,3</sup>	242 <sup>+1,3</sup>	240 <sup>-1,3</sup>	236 <sup>+1,3</sup>	232 <sup>+1,3</sup>	228 <sup>+1,3</sup>	224 <sup>+1,3</sup>	220 <sup>+1,3</sup>	216 <sup>+1,3</sup>	210 <sup>+1,3</sup>

↑  $T = 0,025$

↓  $T = 0,05 D$



**Option 11:** The tolerances of the outside and the inside diameter shall be in accordance with Table 5 divided by 2, with a minimum of  $\pm 0,05$  mm.

**Option 12:** The diameter tolerances shall be unilateral, with the corresponding tolerance range specified in Table 5.

**8.5.1.3** For tubes specified by the outside and the inside diameter, the deviation from concentricity shall fulfil the following requirement:

$$\frac{T_{\max} - T_{\min}}{T_{\max} + T_{\min}} \leq 0,10$$

where  $T_{\max}$  and  $T_{\min}$  are measured in the same cross section (but see option 13).

**Option 13:** A reduced concentricity shall be applied. The value shall be agreed at the time of enquiry and order.

**Table 6 — Diameter tolerances for heat treated tubes**

<i>TID</i> -ratio	Tolerance limits of Table 5 to be multiplied by
$\geq 0,05$	1
$0,05 > TID \geq 0,025$	1,5
$< 0,025$	2

**8.5.1.4** Tubes specified by outside diameter and wall thickness or by inside diameter and wall thickness shall have a wall thickness tolerance of  $\pm 10\%$  or  $\pm 0,1$  mm, whichever is the greater, unless option 14 or 15 is specified.

**Option 14:** A reduced wall thickness tolerance shall be applied. The value shall be agreed at the time of enquiry and order.

**Option 15:** The wall thickness tolerance shall be unilateral, with the tolerance range specified in Table 5.

**8.5.2 Lengths**

The type of tube length shall be specified at the time of enquiry and order by either:

- random length; or
- approximate length; or
- exact length.

They are defined as follows:

a) random length : length with a minimum of 3 m and a maximum of 8 m. The maximum range shall be 2 m per order item;

The purchaser shall be informed of the delivery range, at the time of enquiry and order.

b) approximate length: specified length with a tolerance of  $\pm 500$  mm;

Up to 10 % of the quantity ordered may have lengths other than specified but not shorter than 2 m. Those quantities shall be bundled separately.

c) exact length: specified length with tolerances as given in Table 7. For lengths  $\leq 500$  mm or  $> 8\,000$  mm, tolerances shall be agreed (see option 16).

**Option 16:** An agreed unilateral tolerance is specified for the exact length.

**Table 5 — Tolerances for exact lengths**

Length <i>L</i> mm	Tolerance mm
$\leq 500$	a
$500 < L \leq 2\,000$	+3 0
$2\,000 < L \leq 5\,000$	+5 0
$5\,000 < L \leq 8\,000$	+10 0
$> 8\,000$	a
a See option 16.	

**8.5.3 Straightness**

For tubes with an outside diameter greater than 15 mm the deviation from straightness of any tube length *L* shall not exceed :

- $0,0015 L$  for  $R_{eH} \leq 500$  MPa ;

—  $0,002 L$  for  $R_{eH} > 500$  MPa.

Deviations from straightness over one metre length shall not exceed 3 mm.

NOTE 1 For tubes with an outside diameter of  $\leq 15$  mm a limit deviation from straightness and the inspection method to be used may be agreed at the time of enquiry and order.

NOTE 2 Short exact lengths below 1 000 mm may have a limit deviation from straightness of  $0,003 L$ .

#### 8.5.4 Preparation of ends

The tubes shall be delivered with square cut ends. The ends shall be free of excessive burrs.

NOTE Due to the cutting method the ends of random lengths and approximate lengths can have diameters outside the tolerances given in 8.5.1.2.

*Option 17:* A specified end finishing shall be carried out.

## 9 Inspection

### 9.1 Types of inspection

The compliance with the requirements of the order, shall be checked by non-specific inspection, unless option 18 is specified.

*Option 18:* Tubes shall be subjected to specific inspection.

### 9.2 Inspection documents

#### 9.2.1 Types of inspection documents

Unless otherwise specified, a test report 2.2 in accordance with EN 10204 shall be issued.

When specific inspection is requested an inspection certificate 3.1.B in accordance with EN 10204 shall be issued (but see option 19).

*Option 19:* An inspection certificate 3.1.A or 3.1.C shall be issued.

When option 19 is specified, the purchaser shall supply to the manufacturer the name and address of the organization or person nominated to carry out the inspection and to issue and validate the inspection document.

#### 9.2.2 Content of inspection documents

9.2.2.1 The content of the inspection document shall be in accordance with prEN 10168 as shown in 9.2.2.2 and 9.2.2.3.

9.2.2.2 For tubes supplied with non-specific inspection the test report 2.2 shall contain the following codes and information :

- |           |   |
|-----------|---|
| A         | commercial transactions and parties involved;                     |
| B         | description of products to which the inspection document applies; |
| C10 - C13 | tensile test;   |
| C60 - C69 | other tests;  |
| C71 - C92 | chemical composition;   |

D01 marking and identification, surface appearance, shape and dimensional properties;

Z validation.

**9.2.2.3** For tubes supplied with specific inspection the inspection certificate 3.1.A, 3.1.B or 3.1.C shall contain the following codes and information:

A commercial transactions and parties involved;

B description of products to which the inspection document applies;

C10 to C13 tensile tests;

C60 to C69 other tests;

C71 to C92 chemical composition (cast analysis);

D01 marking and identification, surface appearance, shape and dimensional properties;

D02 to D99 other (optional) tests (e.g. roughness measurement, NDT for defects);

Z validation.

### 9.3 Summary of inspection and testing

Inspection and testing shall be carried out as stated in Table 8 and 10.1.

**Table 6 — Summary of inspection and testing**

Type of inspection or test		Frequency of testing <sup>a</sup>		Reference
		Non-specific inspection	Specific inspection	
Mandatory	Chemical analysis	M	M	8.2
	Tensile test	M	One per test unit	8.3, 11.1
	Dimensional inspection	M	M	8.5, 11.4
	Visual examination	M	M	11.6
Optional	Flattening test or drift expanding test (Option 20) <sup>b</sup>	M	One per test unit	11.2, 11.3
	Roughness measurement	not applicable	One per test unit	8.4.1.5, 11.5
	NDT for longitudinal imperfections	not applicable	Individual	8.4.2, 11.7.1
	NDT for verification of leak tightness			8.4.2, 11.7.2
<sup>a</sup> M : According to manufacturer's procedure. <sup>b</sup> <b>Option 20:</b> A flattening test or a drift expanding test shall be carried out, the test method is at the discretion of the manufacturer. This option only applies for tubes supplied in the annealed or normalized delivery condition.				

## 10 Sampling

### 10.1 Test unit

A test unit is defined as a quantity of tubes of the same steel grade and dimensions continuously manufactured by the same process and in the same delivery condition, heat treated, where applicable, in the same batch and the same heat treatment facility<sup>2)</sup>.

A test unit shall comprise not more than 3 000 m or 500 tubes whichever is the greater mass. Residual quantities of less than 50 tubes may be added to test units evenly.

**Option 21:** The test unit shall only contain tubes from one cast.

### 10.2 Preparation of samples and test pieces

#### 10.2.1 Location, orientation and preparation of samples and test pieces for mechanical tests

##### 10.2.1.1 General

Samples and test pieces shall be taken at the tube ends and in accordance with EN ISO 377 from one sample tube per test unit.

##### 10.2.1.2 Test piece for the tensile test

The test piece shall be prepared in accordance with EN 10002-1. At the manufacturer's discretion the test piece is either a full tube section or a strip section taken in a direction longitudinal to the axis of the tube.

##### 10.2.1.3 Test piece for the flattening or drift expanding test

The test piece shall consist of a full tube section, in accordance with EN 10233 or EN 10234 respectively.

##### 10.2.2 Test piece for roughness measurement

The test piece should be taken from the same location as for the mechanical tests.

## 11 Test methods

### 11.1 Tensile test

The test shall be carried out at room temperature in accordance with EN 10002-1 and the following determined :

- the tensile strength ( $R_m$ );
- the upper yield strength ( $R_{eH}$ ).

If a yield phenomenon is not present the 0,2 % proof strength ( $R_{p0,2}$ ) or the 0,5 % proof strength (total extension) ( $R_{p0,5}$ ) shall be determined. In case of dispute the 0,2% proof strength ( $R_{p0,2}$ ) shall apply.

- the percentage elongation after fracture shall be reported with a reference to a gauge length  $L_0$  of  $5,65\sqrt{S_0}$  .

If a non-proportional test piece is used, the percentage elongation value shall be converted to the value for a gauge length  $L_0 = 5,65\sqrt{S_0}$  using the conversion tables given in EN ISO 2566-1.

<sup>2)</sup> In the case of a continuous furnace or in process annealing a batch is the lot heat treated without intermission with the same process parameters.

## 11.2 Flattening test

The test shall be carried out in accordance with EN 10233 provided the wall thickness is less than 15 % of the outside diameter. The tube section shall be flattened in a press until the distance  $H$  between the platens reaches the value given by the following formula :

$$H = \frac{(1+C) \cdot T}{C + \frac{T}{D}}$$

where

$H$  is the distance between the platens, in mm, to be measured under load;

$D$  is the specified outside diameter, in mm;

$T$  is the specified wall thickness, in mm;

$C$  is a constant, the value of which is given in Table 9.

**Table 7 — Values of constant  $C$  (delivery conditions +A and +N)**

Steel grade		$C$
Steel name	Steel number	
E215	1.0212	0,09
E235	1.0308	0,09
E355	1.0580	0,07

After testing, the test piece shall be free from cracks or breaks. However, a slight incipient crack at the edges shall not be regarded as justification for rejection.

## 11.3 Drift expanding test

The test shall be carried out in accordance with EN 10234 with a 60° conical mandrel provided the outside diameter is  $\leq 150$  mm and the wall thickness is  $\leq 10$  mm. The tube section shall be expanded until the percentage increase in outside diameter shown in Table 10 is reached.

**Table 8 — Requirements for the drift expanding test (delivery conditions +A and +N)**

Steel grade		increase of the diameter $D$ in % for	
Steel name	Steel number	$T \leq 4$ mm	$T > 4$ mm
E215	1.0212	20	15
E235	1.0308	18	12
E355	1.0580	15	10

After testing, the test piece shall be free from cracks or breaks. However, slight incipient cracks at the edges shall not be regarded as justification for rejection.

## 11.4 Dimensional inspection

Specified dimensions, including straightness, shall be verified. Where diameter measurements are carried out, they shall be at a distance of  $\geq 100$  mm off the tube ends.

### 11.5 Roughness measurement

Roughness shall be measured in the axial direction in accordance with EN ISO 4287.

### 11.6 Visual examination

The tubes shall be visually examined for compliance with the requirements of 8.4.1.

### 11.7 Non-destructive testing

#### 11.7.1 Testing for longitudinal imperfections

Non-destructive testing for the detection of longitudinal imperfections shall be carried out, at the discretion of the manufacturer, in accordance with one or more of the following methods :

- eddy current testing: EN 10246-3, acceptance level E3;
- magnetic transducer/flux leakage testing: EN 10246-5, acceptance level F3;
- ultrasonic testing: EN 10246-7, acceptance level U3.

#### 11.7.2 Leak tightness

Non-destructive testing for the verification of leak-tightness shall be carried out in accordance with EN 10246-1.

### 11.8 Retests, sorting and reprocessing

For retests, sorting and reprocessing EN 10021 applies.

## 12 Marking

The following marking shall, unless option 22 is specified, be shown on a label attached to the bundle:

- the manufacturer's name or trade mark;
- the specified dimensions;
- the number of this European Standard;
- the steel name or number;
- the cast number, when option 21 applies;
- the delivery condition;
- in the case of specific inspection, an identification number (e. g. order or item number) which permits the correlation of the product or delivery unit to the related document.

**Option 22:** Alternative marking is specified.

## 13 Protection and packaging

The tubes shall be delivered with a temporary corrosion protection. The type of protection shall be at the discretion of the manufacturer, unless option 23 or 24 is specified.

**Option 23:** The tubes shall be delivered without corrosion protection.

## EN 10305-1:2002 (E)

**Option 24:** The tubes shall be delivered with a specified corrosion protection to be agreed at the time of enquiry and order.

NOTE Unprotected tubes are prone to corrosion at any stage of storage or transportation.

Where appropriate, the tubes shall be delivered in bundles securely banded.

**Option 25:** The method of packaging shall be as specified by the purchaser.

Care shall be taken in handling and transportation to avoid surface and straightness damage.



**Annex A**  
(normative)

**Requirements for additional steel grades**

Table A.1 — Chemical composition (cast analysis)

Steel grade		% by mass											Cr+Mo+Ni max.
Steel name	Steel number	C	Si	Mn	P	S	Cr	Mo	V	Others			
E255	1.0408	≤ 0,21	≤ 0,35	0,40 to 1,10	0,025 max.	≤ 0,025	-	-	-	-	-	-	-
E410	1.0509	0,16 to 0,22	0,10 to 0,50	1,30 to 1,70	0,030	≤ 0,035	-	-	0,08 to 0,15 <sup>a</sup>	0,010 to 0,060 Al, ≤ 0,07 Nb, ≤ 0,05 Ti	-	-	-
26Mn5	1.1161	0,20 to 0,30	≤ 0,40	1,20 to 1,50	0,035	≤ 0,035	-	-	-	-	-	-	-
C35E	1.1181	0,32 to 0,39	≤ 0,40	0,50 to 0,80	0,035	≤ 0,035	≤ 0,40	≤ 0,10	-	-	-	-	0,63
C45E	1.1191	0,42 to 0,55	≤ 0,40	0,50 to 0,80	0,035	≤ 0,035	≤ 0,40	≤ 0,10	-	-	-	-	0,63
26Mo2	1.5417	0,22 to 0,29	≤ 0,40	≤ 1,50	0,035	≤ 0,035	-	0,15 to 0,25	-	≤ 0,40 Ni	-	-	-
25CrMo4	1.7218	0,22 to 0,29	≤ 0,40	0,60 to 0,90	0,035	≤ 0,035	0,90 to 1,20	0,15 to 0,30	-	-	-	-	-
42CrMo4	1.7225	0,38 to 0,45	≤ 0,40	0,60 to 0,90	0,035	≤ 0,035	0,90 to 1,20	0,15 to 0,30	-	-	-	-	-
10S10	1.0711	≤ 0,12	0,10 to 0,35	0,75 to 1,10	0,030	0,08 to 0,13	-	-	-	-	-	-	-
15S10	1.0710	0,12 to 0,18	0,10 to 0,35	0,70 to 1,10	0,030	0,07 to 0,13	-	-	-	-	-	-	-
18S10	1.0712	0,14 to 0,20	0,10 to 0,35	1,30 to 1,60	0,030	0,08 to 0,13	-	-	-	-	-	-	-
37S10	1.0713	0,32 to 0,39	0,10 to 0,35	1,35 to 1,65	0,030	0,07 to 0,13	-	-	-	-	-	-	-

<sup>a</sup> Nb+V: max. 0,20 %.

**Table A.2 — Permissible deviations of the product analysis from the specified limits on cast analysis given in Table A.1**

Element	Limiting value for cast analysis in accordance with Table 2 in % by mass	Permissible deviation of the product analysis in % by mass
C	$\leq 0,55$	$\pm 0,02$
Si	$\leq 0,50$	$\pm 0,05$
Mn	$\leq 1,00$	$\pm 0,05$
	$> 1,00$	$\pm 0,10$
P	$\leq 0,035$	+ 0,005
S	$\leq 0,035$	+ 0,005
	0,07 to 0,13	$\pm 0,01$
Cr	$\leq 1,20$	$\pm 0,05$
Mo	$\leq 0,30$	$\pm 0,03$
Ni	$\leq 0,40$	+ 0,05
Nb	$\leq 0,07$	+ 0,010
V	$\leq 0,15$	$\pm 0,02$
Cr+Mo+Ni	$\leq 0,63$	+ 0,05

Table A.3 — Mechanical properties at room temperature <sup>a</sup>

Steel grade		Values for the delivery condition <sup>b</sup>												
		+C			+LC			+SR			+A			+N
Steel name	Steel number	$R_m$ MPa min.	A % min.	$R_m$ MPa min.	A % min.	$R_m$ MPa min.	$R_{eH}$ MPa min.	A % min.	$R_m$ MPa min.	$R_{eH}$ MPa min.	A % min.	$R_m$ MPa min.	$R_{eH}$ MPa min.	A % min.
E255	1.0408	580	5	520	8	520	375	12	390	21	440 to 570	255	21	
E410	1.0509	750	4	620	8	690	590	12	520	22	550 to 700	410	22	
26Mn5	1.1161	700	4	650	7	-	-	-	-	-	-	-	-	
C35E	1.1181	590	5	540	7	-	-	-	440	22	≥ 460	280	21	
C45E	1.1191	720	4	670	6	-	-	-	510	20	≥ 540	340	18	
26Mo2	1.5417	720	4	670	6	-	-	-	-	-	-	-	-	
25CrMo4	1.7218	720	4	670	6	-	-	-	-	-	-	-	-	
42CrMo4	1.7225	720	4	670	6	-	-	-	-	-	-	-	-	
10S10	1.0711	510	8	-	-	440	370	16	-	-	360 to 500	240	25	
15S10	1.0710	550	7	-	-	490	415	14	-	-	380 to 540	260	22	
18S10	1.0712	650	6	-	-	600	520	12	-	-	520 to 650	360	22	
37S10	1.0713	720	4	-	-	700	630	12	-	-	650 to 720	420	16	

<sup>a</sup> The parameters for the flattening and the drift expanding test (values of constant C and values of expansion) shall be agreed.

<sup>b</sup>  $R_m$  : tensile strength;  $R_{eH}$  : upper yield strength (but see 11.1) ; A: elongation after fracture ; for heat treatment symbols see Table 1.

## Annex B (informative)

### List of corresponding former symbols for delivery conditions and national steel designations

Table B.1 — List of corresponding former frequently used symbols of the delivery condition

Symbol in accordance with this Part of EN 10305 (from CR 10260)	Former symbol
+C	BK
+LC	BKW
+Sr <sup>a</sup>	BKS
+A	GBK
+N	NBK
<sup>a</sup> This symbol will be considered in revised EN 10027-1 replacing both EN 10027-1 and CR 10260.	

Table B.2 — List of corresponding former steel designations

Steel name in accordance with this part of EN 10305	Former	
	steel name	national standard <sup>a</sup>
E215	CFS/CFS3A	BS 6323-4:1982 (1990)
	St 30 Al	DIN 2391:1994
E235	CFS4	BS 6323-4:1982 (1990)
	St 35	DIN 2391:1994
	TU 376	NF A 49-310:1994
	FE 360	UNI 6403:1986
E 255	St 45	DIN 2391:1994
E355	CFS5	BS 6323-4:1982 (1990)
	St 52	DIN 2391:1994
	TU 526	NF A 49-310:1994
	FE 510	UNI 6403:1986
E410	TU 20MV6	NF A 49-310:1994
26Mn5	CFS7	BS 6323-4:1982 (1990)
C35E	CFS6	BS 6323-4:1982 (1990)
	C 35	UNI 6403:1986
C 45 E	CFS8	BS 6323-4:1982 (1990)
	C 45	UNI 6403:1986
26Mo2	CFS9	BS 6323-4:1982 (1990)
25CrMo4	CFS10	BS 6323-4:1982 (1990)
	25CrMo4	UNI 6403:1986
42CrMo4	CFS11	BS 6323-4:1982 (1990)
	42CrMo4	UNI 6403:1986
10S10	S 100	NF A 49-310:1994
15S10	15 S 10	DIN 1651:1988
18S10	18 MF6	NF A 49-310:1994
37S10	37 MF6	NF A 49-310:1994
<sup>a</sup> Corresponding former national steel grades are slightly different the different from the grades specified in this Part of EN 10305.		

## Bibliography

- [1] EN 473, *Non destructive testing - Qualification and certification of NDT personnel — General principles.*

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