



Institut luxembourgeois de la normalisation  
de l'accréditation, de la sécurité et qualité  
des produits et services

## **ILNAS-EN 10255:2004+A1:2007**

### **Non-Alloy steel tubes suitable for welding and threading - Technical delivery conditions**

Tubes en acier non allié soudables et  
filetables - Conditions techniques de  
livraison

Rohre aus unlegiertem Stahl mit Eignung  
zum Schweißen und Gewindeschneiden -  
Technische Lieferbedingungen

**04/2007**



## National Foreword

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ILNAS-EN 10255:2004+A1:2007

EUROPEAN STANDARD **EN 10255:2004+A1**

NORME EUROPÉENNE

EUROPÄISCHE NORM

April 2007

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ICS 23.040.10

Supersedes EN 10255:2004

English Version

**Non-Alloy steel tubes suitable for welding and threading -  
Technical delivery conditions**

Tubes en acier non-allié filetables et soudables -  
Conditions techniques de livraison

Rohre aus unlegiertem Stahl mit Eignung zum Schweißen  
und Gewindeschneiden - Technische Lieferbedingungen

This European Standard was approved by CEN on 27 May 2004 and includes Amendment 1 approved by CEN on 5 March 2007.

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This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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

## Foreword

This document (EN 10255:2004+A1:2007) 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 document shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2007 and conflicting national standards shall be withdrawn at the latest by October 2007.

This document includes Amendment 1, approved by CEN on 2007-03-05.

This document supersedes EN 10255:2004.

The start and finish of text introduced or altered by amendment is indicated in the text by tags  .

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive 89/106/EEC.

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this document.

This European Standard has been derived, with modifications, from ISO 65 “Carbon steel tube suitable for screwing in accordance with ISO 7/1”.

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

## 1 Scope

This document specifies the requirements for circular non-alloy steel tubes suitable for welding and threading and provides a number of options for the finish of tube ends and coatings. This document covers tubes of specified outside diameter 10,2 mm to 165,1 mm (thread size 1/8 to 6) in two series, medium and heavy, and three types of designated thicknesses.

NOTE Tubes manufactured according to this document can be used for the conveyance of fluids as well as for other applications.

## 2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

The requirements of this European Standard rule when they differ from those in the standards and documents referred to below:

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, A1 *General technical delivery for steel products* A1

EN 10027-1, *Designation systems for steel - A1 Part 1: Steel names* A1

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

EN 10204, *Metallic products - Types of inspection documents*

A1 *deleted text* A1

EN 10240, *Internal and/or external protective coatings for steel tubes - Specification for hot dip galvanized coatings applied in automatic plants*

EN 10241, *Steel threaded pipe fittings*

EN 10242, *Threaded pipe fittings in malleable cast iron*

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 10226-1 *Pipe threads where pressure-tight joints are made on the threads - Part 1: Taper external threads and parallel internal threads - Dimensions, tolerances and designation*

A1 EN 10226-2 A1, *Pipe threads where pressure-tight joints are made on the threads - Part 2: Taper external threads and taper internal threads - Dimensions, tolerances and designation*

EN 10266:2003, *Steel tubes, fittings and structural hollow sections - Symbols and definitions of terms for use in product standards*

EN ISO 1461, *Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods (ISO 1461:1999)*