ÒÐÓÁÛ ÑÒÀËÜÍÛÅ ÁÅÑØÎÂÍÛÅ ÃÎÐß×ÅÄÅÎÐÌÈÐÎÂÀÍÍÛÅ ÏÎ ÃÎÑÒ 8731-74/8732-78

Seamless steel hot-worked pipes made to GOST 8731-74/8732-78

Òðóáû èçãîòàâëèâàþòñÿ èç ìàðîê ñòàëåé 10, 20, 35, 40, 45, 50, 15Õ, 20Õ, 35Õ, 40Õ, 45Õ, 20Ã, 10Ã2, 30Ã2, 35Ã2, 18ÔÀ, 33ÔÑ, 15Õ Ì , 20Õ Ì , 30Õ Ì À, 15Ô�õ, 35Õ Ì , 40ÔÒÀ, 40Õ Í , 12Õ Í2, 12Õ Í3À, 20Õ Í3À, 30ÕÃÑÀ, 40Õ Í2 Ì À, 09Ã2Ñ, 16ÃÑ, 38Õ2 Ì ÞÀ, 10ÕÑ Í Ä è äðóãèõ.
Pipes are designated for general application and are made of 10, 20, 35, 40, 45, 50, 15H, 20H, 35H, 40H, 45H, 20G, 10G2, 30G2, 35G2, 18HG, 33HS, 15H Ì , 20H Ì , 30H Ì À, 15HF, 35H Ì , 40HFÀ, 40HN, 12HN2, 12HN3À, 20HN3À, 30HGSÀ, 40HN2 Ì À, 09G2S, 16GS, 38H2 Ì YuÀ, 10HSND steel grades etc.

Ñîðòàìåíò ãîðÿ÷åäåôîðìèðîâàííûõ òðóá ïî ÃÎÑÒ 8731-74/8732-78 èç óãëåðîäèñòûõ è ëåãèðîâàííûõ ñòàëåé

Assortment of hot-worked pipes made of carbon and alloyed steel according to GOST 8731-74/8732-78

Íàðóæíûé äèàìåòð, ìì External diameter, mm	Òîëùèíà ñòåíêè, ìì / Wall thickness, mm																														
	4,5	5,0	5,5	6,0	6,5	7,0	7,5	8,0	8,5	9,0	9,5	10,0	11,0	12,0	13,0	14,0	15,0	16,0	17,0	18,0	19,0	20,0	21,0	22,0	23,0	24,0	25,0	26,0	27,0	28,0	29,0	30,0
	Ìàññà 1 ìåòðà, êã / Weight of 1 meter, kg																Ìàññà 1 ìåòðà, êã / Weight of 1 meter, kg															
73				9,914	10,660	11,394	12,115	12,824	13,521	14,205	14,877	15,537	16,819	18,052																			73
76				10,358	11,141	11,912	12,670	13,416	14,150	14,871	15,580	16,277	17,633	18,940																			76
83				11,394	12,263	13,120	13,965	14,797	15,617	16,425	17,220	18,003	19,532	21,012																			83
89		10,358	11,326	12,281	13,225	14,156	15,074	15,981	16,875	17,756	18,626	19,483	21,160	22,787	24,366	25,895																	89
95		11,098	12,140	13,169	14,187	15,191	16,184	17,164	18,132	19,088	20,031	20,962	22,787	24,563	26,289	27,966	29,594	31,172	32,701	34,181													95
102		11,961	13,089	14,205	15,309	16,400	17,479	18,545	19,600	20,642	21,671	22,689	24,686	26,634	28,533	30,383	32,183	33,934	35,636	37,288	38,891	40,445											102
108	11,486	12,701	13,903	15,093	16,270	17,436	18,589	19,729	20,857	21,973	23,077	24,168	26,314	28,410	30,457	32,455	34,403	36,302	38,151	39,952	41,703	43,404	45,057	46,660									108
114	12,152	13,441	14,717	15,981	17,232	18,471	19,698	20,913	22,115	23,305	24,483	25,648	27,941	30,186	32,381	34,526	36,622	38,669	40,667	42,615	44,514	46,364	48,164	49,915	51,617	53,269							114
121	12,929	14,304	15,666	17,016	18,354	19,680	20,993	22,294	23,583	24,859	26,123	27,374	29,840	32,257	34,625	36,943	39,212	41,431	43,602	45,722	47,794	49,816	51,789	53,713	55,587	57,412	59,188	60,914					121
127	13,595	15,044	16,480	17,904	19,316	20,716	22,103	23,478	24,840	26,191	27,528	28,854	31,468	34,033	36,548	39,014	41,431	43,799	46,117	48,386	50,605	52,776	54,897	56,968	58,990	60,963	62,887	64,761					127
133	14,261	15,783	17,294	18,792	20,278	21,751	23,213	24,662	26,098	27,522	28,934	30,334	33,096	35,809	38,472	41,086	43,651	46,166	48,632	51,049	53,417	55,735	58,004	60,223	62,394	64,514	66,586	68,608					133
140	15,037	16,647	18,243	19,828	21,400	22,960	24,507	26,043	27,565	29,076	30,574	32,060	34,995	37,880	40,716	43,503	46,240	48,928	51,567	54,157	56,697	59,188	61,629	64,021	66,364	68,658	70,902	73,097	75,242	77,338	79,385	81,383	140
146	15,703	17,386	19,057	20,716	22,362	23,996	25,617	27,226	28,823	30,408	31,980	33,540	36,622	39,656	42,640	45,574	48,460	51,296	54,083	56,820	59,508	62,147	64,736	67,277	69,767	72,209	74,601						146
152	16,369	18,126	19,871	21,603	23,324	25,031	26,727	28,410	30,081	31,739	33,386	35,019	38,250	41,431	44,563	47,646	50,679	53,663	56,598	59,484	62,320	65,106	67,844	70,532	73,171	75,760	78,300						152
159	17,146	18,989	20,820	22,639	24,446	26,240	28,022	29,791	31,548	33,293	35,025	36,746	40,149	43,503	46,808	50,063	53,269	56,426	59,533	62,591	65,600	68,559	71,469	74,330	77,141	79,903	82,616						159
168				23,971	25,888	27,794	29,686	31,567	33,435	35,291	37,134	38,965	42,590	46,166																			168

Òðóáû ñ òîëùèíîé ñòåíêè 4,5 è 5,0 ìì ïîñòàâëÿþòñÿ ïðè íàëè÷èè ïîíóòíûõ çàêàçîâ íà òðóáû ñ òîëùèíîé ñòåíêè 5,0 è 5,5 ìì.
Pipes with a wall thickness from 4,5 to 5,0 mm are delivered if there are accompanying orders for pipes with a wall thickness from 5,0 to 5,5 mm.

Ïîñòàâêà òðóá äðóãèõ ðàçìåðîâ è èç äðóãèõ ñòàëåé ïðîèçâîäèòñÿ ïî ñîãëàñîâàíèþ ìåæäó èçãîòîâèòåëåì è ïîòðåáèòåëåì.
Pipes having other sizes made of other steel grades are delivered by agreement between manufacturer and consumer.

Òðóáû ñ òîëùèíîé ñòåíêè 6-22 ìì ïîñòàâëÿþòñÿ äëèíîé 4,5-9,0 ìåòðîâ;
ïî ñîãëàñîâàíèþ ñ ïîòðåáèòåëåì - äî 12,0 ì;
Tubes having a wall thickness from 6 mm to 22 mm are supplied from 4,5 to 9,0 m in length;
the length can be up to 12,0 m by agreement with a consumer.

Òðóáû ñ òîëùèíîé ñòåíêè 4,5-5,0 ìì ïîñòàâëÿþòñÿ ìàêñèìàëüíîé äëèíû äî 9,5 ì;
ñ òîëùèíîé ñòåíêè ñâûøå 22 ìì – äëèíîé äî 7,0 ì.
Tubes having a wall thickness from 4,5 to 5,0 mm are supplied up to 9,5 m maximum in length,
tubes having a wall thickness of more than 22 mm are supplied up to 7,0 m in length

Äîïóñêàåìûå îòêëîíåíèÿ ïî ðàçìåðàì äëÿ ãîðÿ÷åäåôîðìèðîâàííûõ òðóá

Permissible deviations in dimensions for hot-worked pipes

Íàðóæíûé äèàìåòð, ìì External diameter, mm	Äîïóñêàåìûå îòêëîíåíèÿ äëÿ òðóá òî÷íîñòè èçãîòîâëåíèÿ, % Permissible tube deviations depending on precision of manufacture, pct.	
	ïîâûøåííîé / high	îáû÷íîé / normal
76-168	± 0,8	± 1,0
Òîëùèíà ñòåíêè, ìì Wall thickness, mm		
äî 15 âêëþ÷èòåëüíî / to 15 inclusive	±12,5	+12,5 –15,0
ñâûøå 15 äî 30 / over 15 to 30	+10,0 –12,5	±12,5
30 è âûøå / 30 and over	±10,0	+10,0 –12,5

Ìåõàíè÷åñêèå ñâîéñòâà

Mechanical properties

Ìàðêà ñòàëè Steel grade	Âðåìåííîå ñîïðîòèâëåíèå ðàçðûâó, Ì Ïà Tensile strength, MPa	Ïðåäåë òåêó÷åñòè, Ì Ïà Yield strength, MPa	Îòíîñèòåëüíîå óäëèíåíèå, % Elongation, pct
	íå ìåíåå / not less		
10	360	220	24
20	420	250	21
35	520	300	17
45	600	330	14
10Ã2	480	270	21
20Õ	440	-	16
40Õ	670	-	9
30ÕÃÑÀ	700	-	11
15Õ Ì	440	230	21
30Õ Ì À	600	400	13