



 **Tenaris**  
Authorized distributor





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**GALVANIZED THREADED E COUPLED LINE PIPE**

**GROOVED ENDS GALVANIZED LINE PIPE**

**COUPLINGS IN GALVANIZED STEEL**

**THREAD TUBES - STD API - NPT - ISO**

## WE SUPPLY GALVANIZED CARBON STEEL PIPES FOR OIL & GAS, PETROCHEMICAL, OFFSHORE AND POWER



**COMTUBI GTP**



### SPECIFICATION

Galvanized C.S. pipes to API 5LGR.B/X42  
ASTM A53/A106 GR.B

### MARKING

Stencilled and marked acc. to customer specification

### THREADS

ASME B1.20.1 NPT - ISO 7/1, from 1/2" to 6"

### ENDS

Plain/Bevelled - Threaded and coupled - Grooved

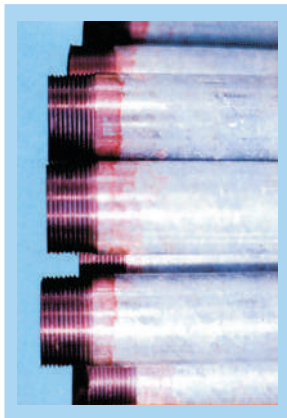
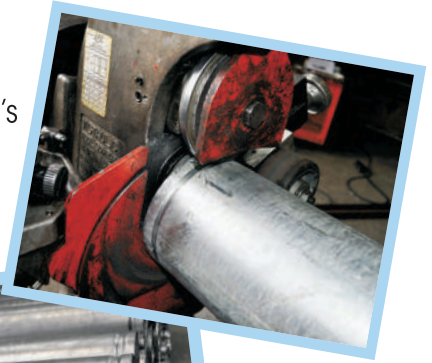
### RANGE

From 1/2" to 6" - Schedule STD/XS/160  
From 2" to 12" grooved



**COMTUBI GTP** provides the customers with the following services:

- availability and quotations given in the same day of the request
- technical consulting regarding specifications, kind of hot dip galvanization, threading
- order handling with issuing of quality control plan, packing list, certificates 3.1
- internal or third party inspection with the following tests: flattening, bending, adhesion, mass and galvanization thickness, tensile test, impact test, chemical analyses
- packing in bundles or wooden crates according to customer's specification, suitable for transport by truck, sea or air.



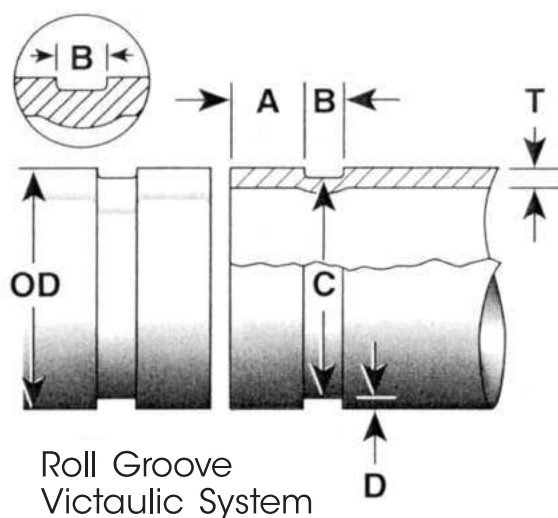
## GALVANIZED CARBON STEEL PIPES, THREADED AND COUPLED NPT API 5L Gr B/x42 - ASTM A106/A53 Gr B

O.D. INCH.	SCH	O.D. MM.	THICK MM.	WEIGHT KG. / M.
1/2"	40	21,3	2,77	1,32
1/2"	80	21,3	3,73	1,69
1/2"	160	21,3	4,78	1,99
1/2"	xxs	21,3	7,47	2,61
3/4"	40	26,7	2,87	1,75
3/4"	80	26,7	3,91	2,28
3/4"	160	26,7	5,56	3,05
3/4"	XXS	26,7	7,82	3,72
1"	40	33,4	3,38	2,60
1"	80	33,4	4,55	3,36
1"	160	33,4	6,35	4,36
1"	XXS	33,4	9,09	5,56
1.1/4"	40	42,2	3,56	3,52
1.1/4"	80	42,2	4,85	4,65
1.1/2"	40	48,3	3,68	4,21
1.1/2"	80	48,3	5,08	5,65
1.1/2"	160	48,3	7,14	7,46
1.1/2"	XXS	48,3	10,16	9,76
2"	40	60,3	3,91	5,70
2"	80	60,3	5,54	7,80
2"	160	60,3	8,74	11,57
2"	XXS	60,3	11,07	13,71
2.1/2"	40	73,0	5,16	9,10
2.1/2"	80	73,0	7,01	12,00
3"	40	88,9	5,49	11,85
3"	80	88,9	7,62	16,00
4"	40	114,3	6,02	16,82
4"	80	114,3	8,56	23,45
5"	40	141,3	6,55	22,90
6"	40	168,3	7,11	28,82

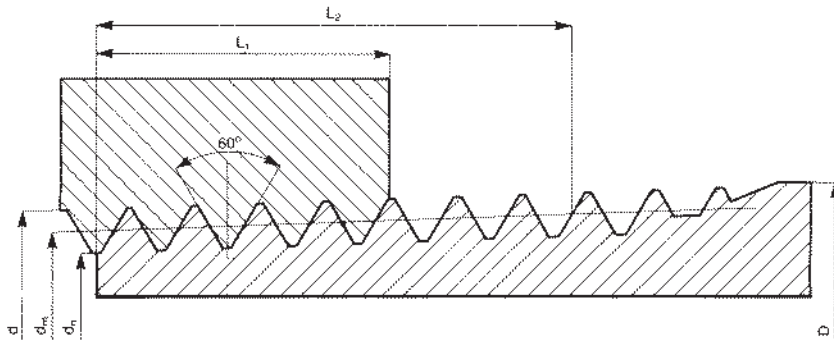
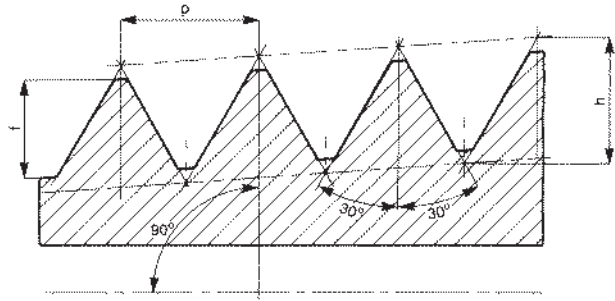
# GALVANIZED LINE PIPE GROOVED ENDS FOR FIRE-FIGHTING SYSTEMS

PIPE O.D.		THICK STD	GASKET SEAT A mm.	GROOVE WIDTH B mm.	GROOVE DIA. C mm.		GROOVE DEPTH D
INCH	mm.	mm.	± 0,76	± 0,76	BASIC	TOL. + 0,00	mm.
1. 1/2"	48,3	3,68	15,88	7,14	45,09	-0,38	1,60
2"	60,3	3,91	15,88	8,74	57,15	-0,38	1,60
2. 1/2"	73,0	5,16	15,88	8,74	69,09	-0,46	1,98
3"	88,9	5,49	15,88	8,74	84,94	-0,46	1,98
4"	114,3	6,02	15,88	8,74	110,08	-0,51	2,11
5"	141,3	6,55	15,88	8,74	137,03	-0,56	2,13
6"	168,3	7,11	15,88	8,74	163,86	-0,56	2,16
8"	219,1	8,18	19,05	11,91	214,40	-0,64	2,34
10"	273,0	9,27	19,05	11,91	268,28	-0,69	2,39
12"	323,8	9,52	19,05	11,91	318,29	-0,76	2,77

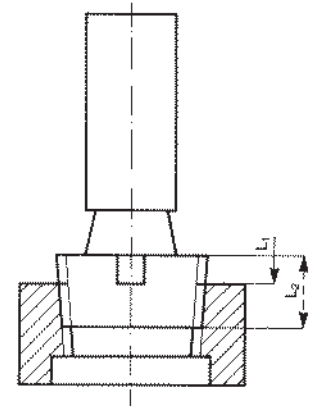
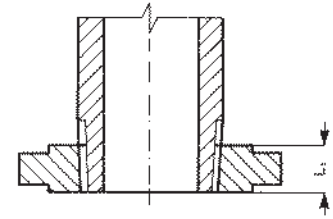
- Material : API 5L gr.B  
ASTM A53 gr.B  
A106 gr.B
  
- Galvanizing : ASTM A53  
A153 (only for thickness)  
A123



# AMERICAN STANDARD THREAD ANSI B1.20.1 NPT



THREAD ANGLE = 60°  
 PITCH = p  
 HEIGHT h = 0.866 p

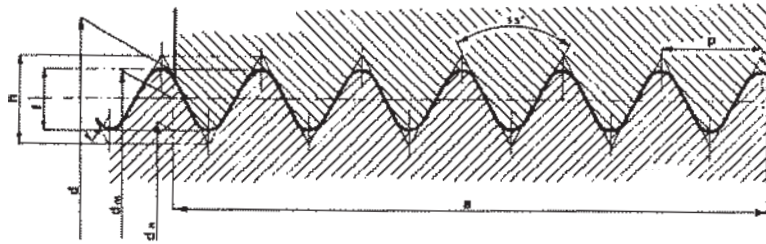


THREAD HEIGHT f = 0.800 p  
 TAPER = 6.25%

DIMENSIONS OF PIPE			NUMBER OF THREADS PER INCH	PITCH p	DIAMETER OF SCREW			CLUTCH L1	LENGTH OF ENGAGEMENT L2	
SIZE NOMINAL	OUTSIDE DIAMETER D				OUTSIDE DIAMETER d	MEDIUM DIAMETER dm	INSIDE DIAMETER dn		INC.	mm.
INC.	INC.	mm.	INC.	mm.	mm.	mm.	mm.	INC.	mm.	
1/8	0.405	10.287	27	0.9407	0.999	9.233	8.484	4.572	6.706	0.264
1/4	0.540	13.716	18	1.4111	13.259	12.126	10.998	5.080	10.211	0.402
3/8	0.675	17.145	18	1.4111	16.662	15.545	14.427	6.906	10.363	0.408
1/2	0.840	21.336	14	1.8143	20.726	19.263	17.805	8.128	13.564	0.534
3/4	1.050	26.070	14	1.8143	26.035	24.580	23.139	8.610	13.919	0.548
1	1.315	33.401	11 1/2	2.2087	32.588	30.825	29.058	10.160	17.348	0.683
1 1/4	1.660	42.164	11 1/2	2.2087	41.326	39.550	37.795	10.668	17.958	0.707
1 1/2	1.900	48.260	11 1/2	2.2087	47.396	45.621	43.866	10.668	18.390	0.724
2	2.375	60.325	11 1/2	2.2087	59.411	57.663	55.855	14.074	19.228	0.757
2 1/2	2.875	73.025	8	3.1750	71.626	69.075	65.548	17.322	28.905	1.138
3	3.500	88.900	8	3.1750	87.401	82.321	79.456	30.480	1.200	
3 1/2	4.000	101.600	8	3.1750	100.025	97.472	94.945	20.853	31.750	1.250
4	4.500	114.300	8	3.1750	112.624	110.094	107.544	21.437	33.020	1.300
5	5.563	141.300	8	3.1750	139.471	136.924	134.391	23.799	35.712	1.406
6	6.625	168.275	8	3.1750	166.268	163.731	161.188	24.333	38.430	1.513



## THREAD ISO 7/1



$h = 0,96049 p$      $f = 0,64033 p$      $r = 0,13733 p$     Taper: 1:16

Size nominal inc.	Outside diameter of thread mm.	Pitch P mm.	Number of threads per inch.	Medium diameter d <sub>m</sub> mm.	Inside diameter d <sub>n</sub> mm.
1/8	9,73	0,907	28	9,147	8,57
1/4	13,16	1,337	19	12,301	11,45
3/8	16,66	1,337	19	15,806	14,95
1/2	20,96	1,814	14	19,793	18,63
3/4	26,44	1,814	14	25,279	24,12
1"	33,25	2,309	11	31,770	30,29
1" 1/4	41,91	2,309	11	40,431	38,95
1" 1/2	47,80	2,309	11	46,324	44,85
2"	59,61	2,309	11	58,135	56,66
2 1/2	75,18	2,309	11	73,706	72,23
3"	87,88	2,309	11	86,405	84,93
4"	113,03	2,309	11	111,551	110,07
5"	138,43	2,309	11	136,951	135,47
6"	163,83	2,309	11	162,351	160,81

## STANDARD HOT DIP GALVANIZATION

STANDARD	THICKNESS OF ZINC COATING microns	GR/M2
ASTM A123	75	530
ASTM A153	88	610
ASTM A53	80	550
BS 729	88	610
NFA 49700	72	500
EN 10240	56	400
ISO 1461	85	590

## GALVANIZATION PROCEDURE

### CLEANING PROCESS

#### - *DEGREASING*

Immersion in water, containing acid based degreaser, at room temperature

#### - *PICKLING*

Immersion into acid solution containing HCL=120-130 g/lit. at room temperature

#### - *WASHING WITH DRINKING WATER*

In running water to aid dissolution of remaining pickling solution.

#### - *FLUXING*

Immersion in the fluxing bath containing water, fluxing solution ZnCl<sub>2</sub>-NH<sub>4</sub>Cl and double iron salt. Temperature: 70-80° C.

#### - *DRYING ON HOT AIR FURNACE*

Passage into rotary furnace at fixed temperature of 110° C.

### GALVANIZING PROCESS

- Immersion of pipes into bath of molten zinc at 450° C (kettle temperature) for a time of 30-60 seconds to obtain a zinc thickness according to specifications and customer requirements.

Zinc used of high quality with purity 99,5% corresponding to Zn 99,5/EN 1179.

### INTERNAL AND EXTERNAL BLOWING BY HOT AIR

- External through a special compressed air ring.

- Internal through an air compressed gun with overheated vapor at 220° C.

### COOLING AND WASHING

- Cooling has to be naturally in calm area.

### MECHANICAL STRAIGHTENING OF PIPES

#### *TEST*

- Visual check to examine that pipes are free from uncoated areas, blisters, flux deposits, dross inclusions and lumps.

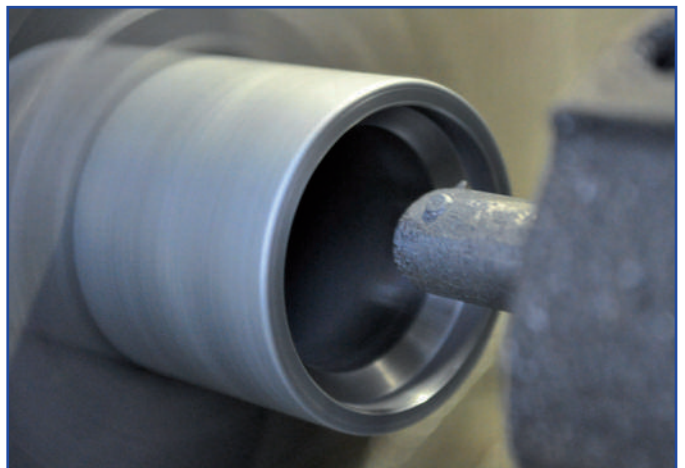
- Thickness of coating determined by magnetic thickness gauge measurements.

- Marking in continuous by ink on each pipe.

### CERTIFICATION

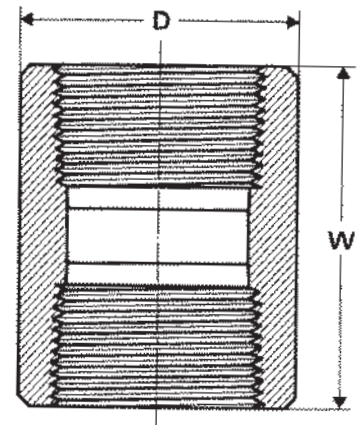
- Conformity certificate according to specifications and customer requirements.

# GALVANIZED STEEL - COUPLINGS DEPT.



## GALVANIZED STEEL - COUPLINGS - ASME B16.11 ASTM A105 - 3000 LBS

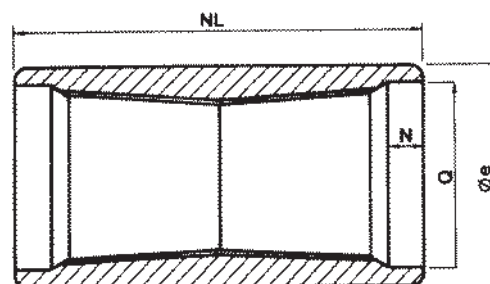
Dt inches	D mm.	W mm.	F n.	WT kg.
1/2	28,6	47,6	14	15
3/4	34,9	50,8	14	20
1	44,4	60,3	11 1/2	38
1 1/4	57,2	66,6	11 1/2	68
1 1/2	63,5	79,4	11 1/2	99
2	76,2	85,7	11 1/2	137
2 1/2	92,1	92,1	8	207
3	108,0	108,0	8	303
4	139,7	120,0	8	544
5	168,3	123,0	8	889
6	193,7	128,8	8	960



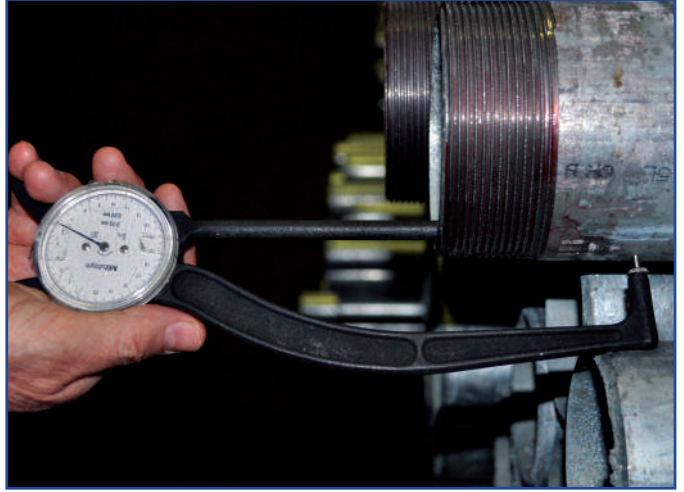
- F : threads for inch.
  - W : weight for 100 pieces
- THREADS ANSI B1.20.1 NPT

## GALVANIZED STEEL - COUPLINGS FOR PIPELINES - API STD

Dt inches	Øe mm.	NL mm.	Q mm.	N mm.	F n.	W kg.
1	40,6	66,7	35,0	5,7	11 1/2	25
1 1/4	52,2	69,8	43,8	5,8	11 1/2	47
1 1/2	55,9	69,8	49,9	6,2	11 1/2	41
2	73,0	73,0	62,7	6,0	11 1/2	84
2 1/2	85,7	104,8	75,4	12,5	8	148
3	101,6	108,0	91,3	12,0	8	186
3 1/2	117,5	111,1	104,0	11,8	8	269
4	132,1	114,3	116,7	12,5	8	345
5	159,9	117,5	143,7	12,8	8	453
6	187,7	123,8	170,7	14,9	8	587



- NL : nominal length
  - F : threads for inch.
  - W : weight for 100 pieces
- THREADS API 5B





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