



*Manufacturers of Stainless Steel Welded /  
 Seamless Pipes & Tubes*



**AN ISO 9001 : 2015 CERTIFIED COMPANY**

*Stainless we know how ....*

## ABOUT US



INOX PIPE & FITTINGS INDUSTRIES is a well established company manufacturing S.S. Pipes & Tubes, we also manufacture special steel pipes & tubes like inconel, duplex, super duplex, etc.

INOX PIPE & FITTINGS INDUSTRIES has its manufacturing unit at Por, Vadodara, Gujarat, India which manufactures stainless steel welded and seamless pipes & tubes with an installed capacity of 10,000 MT / Annum.

The product range covers from OD 6mm to 812 mm, Thickness 1mm to 20mm. As per national and international standard like ASTM, ASME, DIN, JIS and EN etc.

The quality of our products, engineered by us has been hailed and vouched by numerous companies and MNC's across the world. Since dealing with the most successful clients, we have realized the global requirement & its need for superior quality, for which our R&D team has proposed the necessary changes & upgradation in our facilities and ensure that the high quality standards are maintained.

We export our products to more than 10 countries all over the world, South Africa, Europe, USA, Middle-East Asia and many more. Since last few years INOX PIPE & FITTINGS INDUSTRIES has become a trustworthy brand among the quality conscious customers & we shall ensure that our brand image grows.



STRENGTH

## Applications

- ◆ Boiler
- ◆ Synthetic Fibers
- ◆ Power Plants
- ◆ Pulp & Paper Mills
- ◆ Fertilizers
- ◆ Breweries
- ◆ Chemical Industries
- ◆ Fluid Piping
- ◆ Oil & Gas
- ◆ Dairy
- ◆ Sugar Industries
- ◆ Fabrication
- ◆ Textile Machinery
- ◆ Refinery & Petrochemicals
- ◆ Pharmaceuticals

## PRODUCT NAME

### S.S. WELDED TUBES

**Outer Diameter** : 6 mm to 114.3 mm  
**Thickness** : 1 mm to 6.00 mm  
**Specification** : ASTM A-249, A-269, A-270

### S.S. SEAMLESS TUBES

**Outer Diameter** : 6 mm to 114.3 mm  
**Thickness** : 1 mm to 5.00 mm  
**Specification** : ASTM A-213, A-269, A-270

### S.S. WELDED PIPES

**Outer Diameter** : 1/8" NB to 2" NB  
**Thickness** : upto Schedule 80  
**Outer Diameter** : Above 2" NB to 4" NB  
**Thickness** : upto Schedule 40S  
**Specification** : ASTM A-312

### S.S. EFW PIPES

**Outer Diameter** : 125 mm to 812 mm  
**Thickness** : 2.0 mm to 20.0 mm  
**Specification** : ASTM A-358

### S.S. SEAMLESS PIPES

**Outer Diameter** : 1/8" NB to 12" NB  
**Thickness** : Available in all Schedule Size  
**Specification** : ASTM A-312

### S.S. GRADES

304, 304L, 304H, 316, 316L, 316Ti, 321, 347, 347H, 310S, 317, 317L, 400 series, Duplex Series

### FINISH

Mill Finish  
Annealed, Pickled & Passivated  
Bright Annealed (for the power sector)  
Polished Finish

### LENGTH

Random Length / Fixed Lengths  
upto 12 Meters in Straight Length

## Inspection & Tests

- ◆ CORROSION TEST
- ◆ HYDROSTATIC / PNEUMATIC PRESSURE TEST
- ◆ FLARING TEST
- ◆ REVERSE FLATTENING TEST
- ◆ TENSILE TEST
- ◆ FLATTENING TEST
- ◆ HARDNESS TEST
- ◆ PMI TESTING
- ◆ RADIOGRAPHY TEST
- ◆ CHEMICAL TEST



## THIRD PARTY INSPECTION

We supply each & every product with our test certificates, we can also supply the materials under the third party inspection agencies as per your requirement.

Brief examples of achievements, that Inox & its Associate Co's have earned

SUCCESS

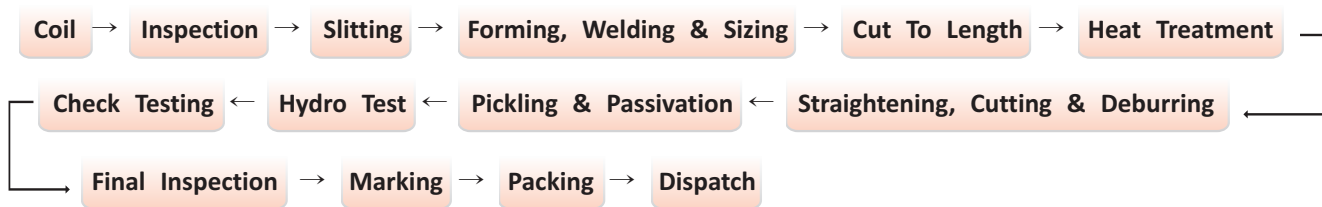
ACHIEVE

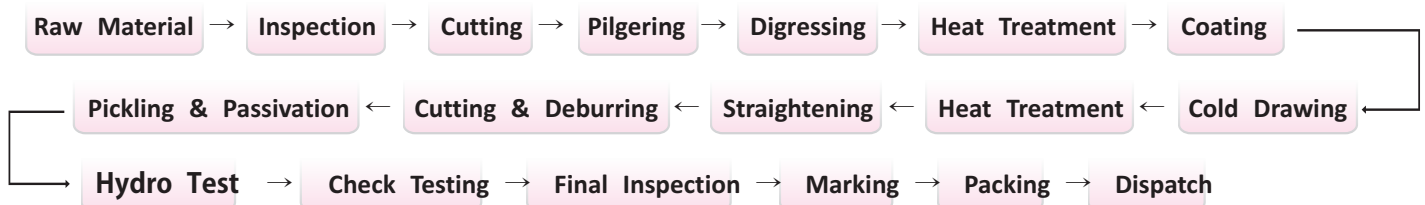
CUSTOMER APPROVAL

## MANUFACTURING PROCESS FLOW CHART

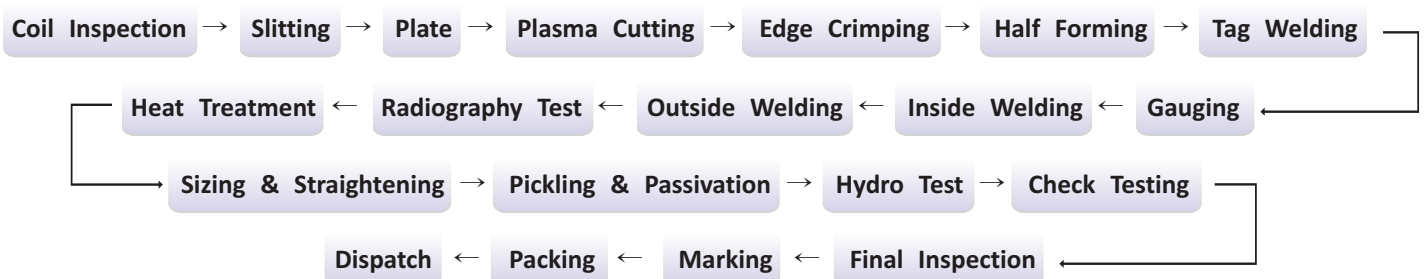
### ERW PIPES & TUBES



### SEAMLESS PIPES & TUBES



### LARGE DIAMETER EFW PIPES



# ACCURACY



## ASTM STANDARDS FOR STAINLESS STEEL SEAMLESS, WELDED TUBES PIPES

	Allowable Outside Diameter Variation in mm				Allowable Wall		Exact Length		Testing
	Nominal	Diameter	Over	Under	Over %	Under %	Over %	Under %	
ASTM A.213 Seamless Boiler Supperheater & Heat Exchange tubes	Under 25.4		.1016	.1016	+20	-0	3.175	0	Tension Test Flattening Test Flaring Test Hardness Test 100% Hydrostatic Test Refer to ASTM A- 1016
	25.4-	38.1 Incl	.1524	.1524	+20	-0	3.175	0	
	38.1-	50.8 excl.	.2032	.2032	+22	-0	3.176	0	
	50.8-	63.5 excl.	.254	.254	+22	-0	3.76	0	
	63.5-	76.2 excl.	.3048	.3048	+22	-0	4.76	0	
	76.2-	101.6 incl.	.381	.381	+22	-0	4.76	0	
ASTM A.249 Welded Boiler Supperheater & Heat Exchange & Condenser tubes	Under 25.4		.1016	.1016	+10	-10	3.175	0	Tension Test Flattening Test Flaring Test * Reverse Band Test Hardness Test 100% Hydrostatic Test * Reverse Flattening Test Refer to ASTM A- 1016 * Whenever Applicable
	25.4-	38.1 Incl	.1524	.1524	+10	-10	3.175	0	
	38.1-	50.8 excl.	.2032	.2032	+10	-10	3.176	0	
	50.8-	63.5 excl.	.254	.254	+10	-10	3.76	0	
	63.5-	76.2 excl.	.3048	.3048	+10	-10	4.76	0	
	76.2-	101.6 incl.	.381	.381	+10	-10	4.76	0	
Minimum Wall Tubes + 18% - 0 available on request									
ASTM A-269 Seamless Boiler Tubing General Service	Under 12.7		.13	.13	+15	-15	3.2	0	Flare Test (Seamless Tube) Flange Test (Welded only) Hardness Test Reverse Flattening Test (Welded Only) 100% Hydrostatic Test Refer to ASTM A - 1016
	12.7-	38.1 excl.	.13	.13	+10	-10	3.2	0	
	38.1-	88.9 excl.	.25	.25	+10	-10	4.8	0	
	88.9-	139.7 excl.	.38	.38	+10	-10	4.8	0	
	139.7	203.2 excl	.76	.76	+10	-10	4.8	0	
ASTM A-312 Seamless & Selded Austenitic Pipes	10.29 - 48.26		0.40	0.80	+20	-12.5			Tension Test Flattening Test 100% Hydrostatic Test
	48.9 - 73.03		0.80	0.80	+22.5	-12.5			
	73.03 - 114.3		0.80	0.80	+22.5	-12.5			
	114.3 - 219.08		1.60	0.80	+22.5	-12.5			
ASTM A-270 Seamless & Weldec Austenitic Pipes	25.4		.05	.20	+12.5	-12.5	3.2	0	Reverse Flattening Test 100% Hydrostatic Test External Polish on all tubes Refer to ASTM A - 1016
	38.1		.05	.20	+12.5	-12.5	3.2	0	
	50.8		.05	.28	+12.5	-12.5	3.2	0	
	63.5		.05	.28	+12.5	-12.5	3.2	0	
	76.2		.05	.30	+12.5	-12.5	3.2	0	
	101.6		.08	.38	+12.5	-12.5	3.2	0	
ASTM A-268 Seamless & Weldec Ferritic & Martengitic Stainless Steel Tubes	Under 12.7		.13	.13	+15	-15	3.2	0	Tension Test, Flaring Test, Flange Test (ERW only) Hardness Test, Reverse Fla- ttening Test, 100% hydrostatic Test, Refer to ASTM A - 450
	12.7-	38.1 excl.	.13	.13	+10	-10	3.2	0	
	38.1 excl.	88.9 excl.	.25	.25	+10	-10	4.8	0	
	88.9-	168.3 excl.	.38	.38	+10	-10	4.8	0	
ASTM A-358 for Welded big diameter Pipes	for all sizes 5" NB & above	+0.5%	-0.5%	-	-0.3 mm	Customer's Specification		Transverse tension test, Transverse guided bend test, Hydrostatic test, radiographic examination (as specified) dye penetrant (optional)	
ASTM A-688 for Welded Feed Water heater "U" tubes	Under 25.4 mm	.1016	.1016	+20 +10	-0 (for min wall thk.) -10 (for avg. wall thk.)	3 to 13	0	Tension, Hardness, Corrosion Reverse bend, Flange, Flattening Hydrostatic Test, Pneumatic Test Non Destructive Test	
ASTM A-409 Welded Large Diameter	wall thickness < 4.8 mm +0.2% > 4.8 mm +0.2% <1.5% of O/D	0.2% 0.4%	0.2% 0.4%	0.46 mm	0.46 mm	<NPS 22 <sup>B</sup> _NPS 22 <sup>B</sup>	less than 9 to 12 feet minimum 5 ft.	Bend Test Hydro Test	
ASTM A-778 Austenitic Stainless	As per Table 1 Welded Unannealed					12.5%	12.5%	RL 10ft > 3 meter FL 6 meter + 6mm - 0mm	Transverse Tension Test Transverse Guided Test

\* Eddy current non destructive test & inter granular corrosion test can be offered on request.

<b>ASTM</b>	American Society for Testing of Materials	<b>ASME</b>	American Society of Mechanical Engineers
<b>SAE</b>	Society of Automotive Engineers	<b>DIN</b>	Deutsches Institute for Normung
<b>JIS</b>	Japan Industrial Standards	<b>UNS</b>	Unified Numbering System
<b>GOST</b>	Gosudarstvenil Standards	<b>TEMA</b>	Tubular Exchanger Manufacturers Association
<b>PED</b>	Pressure Equipment Directive	<b>IBR</b>	Indian Boiler Regulation





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