

BS 1387 : 1985 Welded Steel Pipes

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Class A-1

Nominal Size	Outside Diameter		Wall Thickness	Calculated Weight for BP Pipe				Calculated Weight for GI Pipe				Number of Threaded Per Inch	Socket		Test Pressure		Packing	
	Maximum	Minimum		Plain Ends		Threaded and Coupling		Plain Ends		Threaded and Coupling			Outer Diameter	Min Length	bar	psi		
mm.	Inch	mm.	mm.	mm.	kg/m.	kg/ft.	kg/m.	kg/ft.	kg/m.	kg/ft.	kg/m.	kg/ft.	Inch	mm.	mm.	bar	psi	pce./bdl
15	½	21.7	21.1	1.9	0.904	0.276	0.913	0.278	0.940	0.287	0.950	0.290	14	27.0	37.0	50	711	200
20	¾	27.2	26.6	2.1	1.271	0.388	1.284	0.391	1.322	0.403	1.335	0.407	14	32.5	39.0	50	711	127
25	1	34.2	33.4	2.3	1.770	0.540	1.787	0.545	1.840	0.561	1.859	0.567	11	39.5	46.0	50	711	114
32	1¼	42.9	42.1	2.3	2.263	0.690	2.286	0.697	2.354	0.718	2.337	0.725	11	49.0	51.0	50	711	91
40	1½	48.8	48.0	2.5	2.811	0.857	2.839	0.866	2.924	0.891	2.953	0.900	11	56.0	51.0	50	711	70
50	2	60.8	59.8	2.6	3.674	1.120	3.711	1.131	3.821	1.165	3.859	1.177	11	68.0	60.0	50	711	44
65	2½	76.6	75.4	2.9	5.199	1.585	5.251	1.601	5.047	1.648	5.461	1.665	11	84.0	69.0	50	711	37
80	3	89.5	88.1	2.9	6.107	1.862	6.168	1.881	6.352	1.936	6.415	1.956	11	98.0	75.0	50	711	19
100	4	114.9	113.3	3.2	8.700	2.652	8.787	2.679	9.048	2.759	9.135	2.786	11	124.0	87.0	50	711	10
125	5	140.6	138.7	4.5	4.998	4.572	15.148	4.618	15.597	4.755	15.753	4.803	11	151.0	96.0	50	711	10
150	6	166.1	164.1	4.5	7.822	5.433	18.000	5.488	18.535	5.651	18.720	5.707	11	178.0	96.0	50	711	7

Chemical composition and mechanical properties at room temperature

Chemical composition (Ladle)				Mechanical properties at room temperature		
C Max.	Mn Max.	P Max.	S Max.	Tensile Strength, Rm	Yield Strength, Re (min.)	Elongation on gauge Length L0 = 5.65 S0 A (min.)
%	%	%	%	N/mm²	N/mm²	%
0.20	1.20	0.045	0.045	320 to 460	195	20

Testing

Bend test Applies to tubes up to and including DN 50

Type	Bending Angle	Radius	Result
Carbon tube	180°	6 x D	No crack
Hot-dip Zinc coat tube	90°	8 x D	

Flattening test Applies to tubes greater than DN 50

Type	Distance between the platens % x OD	Result
Metal	<75%	No crack or flaws
Welding	<60%	

Leak tightness test

The test shall be either a hydraulic test at a pressure of 50 Bar or alternatively an eddy current test.



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Screwed and Socket Steel Tubes and Tubulars and for plain End Steel tubes suitable for welding or for screwing to BS 21 pipe threads



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Scope

This British Standard specifies requirements for screwed and socketed steel tubes and tubulars and for plain end steel tube suitable for welding or screwing to BS 21 pipe threads. This standard is applicable to tube of nominal size DN 8 to DN 150 in three series of thickness designated light, medium and heavy.

Manufacture of product

COTCO-SV tubes shall be manufactured by Electrical Resistance Welding process. And our quality production process are certified by international inspection agent "SGS" under ISO 9001:2000.

Production Capacity

Carbon steel pipes and tubes 8,500 Mt. per Month
Galvanized Steel pipes and tubes 6,500 Mt. per Month

Class Light (Brown)

Nominal Size	Outside Diameter		Wall Thickness	Calculated Weight for BP Pipe				Calculated Weight for GI Pipe				Number of Threaded Per Inch	Socket		Test Pressure		Packing	
	Maximum	Minimum		Plain Ends	Threaded and Coupling	Plain Ends	Threaded and Coupling	Plain Ends	Threaded and Coupling	Outer Diameter	Min Length		bar	psi				
mm.	Inch	mm.	mm.	mm.	kg/m.	kg/ft.	kg/m.	kg/ft.	kg/m.	kg/ft.	kg/m.	kg/ft.	mm.	mm.	bar	psi	pce./bdl	
15	½	21.4	21.0	2.0	0.947	0.289	0.956	0.292	0.985	0.300	0.995	0.303	14	27.0	37.0	50	711	200
20	¾	26.9	26.4	2.3	1.381	0.421	1.395	0.425	1.436	0.438	1.451	0.442	14	32.5	39.0	50	711	127
25	1	33.8	33.2	2.6	1.981	0.604	2.001	0.610	2.060	0.628	2.081	0.634	11	39.5	46.0	50	711	114
32	1¼	42.5	41.9	2.6	2.539	0.774	2.564	0.782	2.641	0.805	2.667	0.813	11	49.0	51.0	50	711	91
40	1½	48.4	47.8	2.9	3.232	0.985	3.265	0.995	3.362	1.025	3.395	1.035	11	56.0	51.0	50	711	70
50	2	60.2	59.6	2.9	4.076	1.243	4.117	1.255	4.239	1.29	4.262	1.305	11	68.0	60.0	50	711	44
65	2½	76.0	75.2	3.2	5.713	1.742	5.770	1.759	5.942	1.81	6.001	1.829	11	84.0	69.0	50	711	37
80	3	88.7	87.9	3.2	6.715	2.047	6.783	2.068	6.984	2.13	7.054	2.151	11	98.0	75.0	50	711	19
100	4	113.9	113.0	3.6	9.752	2.973	9.850	3.003	10.142	3.09	10.244	3.122	11	124.0	87.0	50	711	10

Class Medium (Blue)

Nominal Size	Outside Diameter		Wall Thickness	Calculated Weight for BP Pipe				Calculated Weight for GI Pipe				Number of Threaded Per Inch	Socket		Test Pressure		Packing	
	Maximum	Minimum		Plain Ends	Threaded and Coupling	Plain Ends	Threaded and Coupling	Plain Ends	Threaded and Coupling	Outer Diameter	Min Length		bar	psi				
mm.	Inch	mm.	mm.	mm.	kg/m.	kg/ft.	kg/m.	kg/ft.	kg/m.	kg/ft.	kg/m.	kg/ft.	mm.	mm.	bar	psi	pce./bdl	
15	½	21.7	21.1	2.6	1.21	0.367	1.22	0.371	1.254	0.382	1.27	0.386	14	27.0	37.0	50	711	200
20	¾	27.2	26.6	2.6	1.56	0.475	1.57	0.480	1.620	0.494	1.64	0.499	14	32.5	39.0	50	711	127
25	1	34.2	33.4	3.2	2.41	0.736	2.44	0.744	2.511	0.766	2.54	0.773	11	39.5	46.0	50	711	114
32	1¼	42.9	42.1	3.2	3.10	0.945	3.13	0.955	3.225	0.983	3.26	0.993	11	49.0	51.0	50	711	91
40	1½	48.8	48.0	3.2	3.57	1.087	3.60	1.098	3.709	1.131	3.75	1.142	11	56.0	51.0	50	711	70
50	2	60.8	59.8	3.6	5.03	1.534	5.08	1.550	5.235	1.596	5.29	1.612	11	68.0	60.0	50	711	44
65	2½	76.6	75.4	3.6	6.43	1.959	6.49	1.979	6.684	2.037	6.75	2.058	11	84.0	69.0	50	711	37
80	3	89.5	88.1	4.0	8.36	2.550	8.45	2.575	8.699	2.652	8.79	2.678	11	98.0	75.0	50	711	19
100	4	114.9	113.3	4.5	12.16	3.707	12.28	3.744	12.649	3.855	12.78	3.894	11	124.0	87.0	50	711	10
125	5	140.6	138.7	5.0	16.60	5.060	16.77	5.111	17.266	5.264	17.44	5.314	11	151.0	96.0	50	711	10
150	6	166.1	164.1	5.0	19.74	6.017	19.94	6.077	20.530	6.258	20.74	6.320	11	178.0	93.0	50	711	7

Class Heavy (Red)

Nominal Size	Outside Diameter		Wall Thickness	Calculated Weight for BP Pipe				Calculated Weight for GI Pipe				Number of Threaded Per Inch	Socket		Test Pressure		Packing	
	Maximum	Minimum		Plain Ends	Threaded and Coupling	Plain Ends	Threaded and Coupling	Plain Ends	Threaded and Coupling	Outer Diameter	Min Length		bar	psi				
mm.	Inch	mm.	mm.	mm.	kg/m.	kg/ft.	kg/m.	kg/ft.	kg/m.	kg/ft.	kg/m.	kg/ft.	mm.	mm.	bar	psi	pce./bdl	
15	½	21.7	21.1	3.2	1.44	0.438	1.45	0.442	1.494	0.455	1.51	0.460	14	27.0	37.0	50	711	200
20	¾	27.2	26.6	3.2	1.87	0.570	1.89	0.576	1.945	0.593	1.96	0.599	14	32.5	39.0	50	711	127
25	1	34.2	33.4	4.0	2.94	0.896	2.97	0.905	3.057	0.932	3.09	0.941	11	39.5	46.0	50	711	114
32	1¼	42.9	42.1	4.0	3.80	1.158	3.84	1.169	3.950	1.204	3.99	1.216	11	49.0	51.0	50	711	91
40	1½	48.8	48.0	4.0	4.38	1.335	4.42	1.348	4.555	1.388	4.60	1.402	11	56.0	51.0	50	711	70
50	2	60.8	59.8	4.5	6.19	1.887	6.25	1.906	6.440	1.963	6.50	1.982	11	68.0	60.0	50	711	44
65	2½	76.6	75.4	4.5	7.93	2.418	8.01	2.443	8.252	2.515	8.33	2.540	11	84.0	69.0	50	711	37
80	3	89.5	88.1	5.0	10.33	3.149	10.44	3.181	10.746	3.276	10.85	3.308	11	98.0	75.0	50	711	19
100	4	114.9	113.3	5.4	14.47	4.412	14.62	4.456	15.054	4.590	15.20	4.634	11	124.0	87.0	50	711	10
125	5	140.6	138.7	5.4	17.88	5.449	18.06	5.503	18.592	5.668	18.78	5.724	11	151.0	96.0	50	711	10
150	6	166.1	164.1	5.4	21.27	6.482	21.48	6.547	22.117	6.743	22.34	6.809	11	178.0	96.0	50	711	7

Tolerance

On diameter As per above table
 On thickness Light tube -8%
 Medium and heavy tubes -10%
 On mass Per bundle of 150 M and over +/-4%
 Per single tube +/-10%, -8%