

CARBON STEEL · WELDED PIPES · 02

Spiral Welded Steel Pipes / SAWH

Spiral submerged-arc welded (SSAW / HSAW) large-diameter line pipe for the transmission and distribution of petroleum, natural gas, water and other fluids — supplied to API 5L & EN ISO 3183.

SSAW

HSAW

SAWH

219–3556 mm

OUTSIDE Ø · 8"–140"

4.0–25.4 mm

WALL THICKNESS

≤ 18.5 m

UNIT LENGTH

X80 max

API 5L / PSL2 GRADE

Spiral Welded Steel Pipes

— 01 / OVERVIEW

Spiral welded steel pipes are produced by helically forming hot-rolled steel coil and joining the edges with a double-sided **submerged-arc weld (SAW)**. The process delivers a very wide diameter range from a limited coil-width stock, with excellent dimensional stability and long unit lengths — **up to 18.5 m** — which reduces the number of field welds and lowers pipeline construction cost.

FIELDS OF APPLICATION

- Oil & petroleum transmission and distribution lines
- Natural gas pipelines
- Water transmission & distribution pipelines
- Flammable & non-flammable fluid conveyance
- Structural steel elements & onshore structures
- Piling, casing & construction base
- Refineries, energy plants & general industry

PRODUCT RANGE

Outside diameter	219 - 3556 mm · 8"-140"
Wall thickness	4.0 - 25.4 mm · 0.156"-1.000"
Unit length	up to 18.5 m
Weld type	Double-sided SAW (helical)
Delivery condition	R · N · Q · M

Delivery conditions: R as-rolled · N normalized · Q quenched & tempered · M thermomechanical.

MATERIAL GRADES

Standard	Grades supplied
API 5L PSL1	Gr B · X42 · X46 · X52 · X56 · X60 · X65 · X70
API 5L PSL2	X42 · X46 · X52 · X56 · X60 · X65 · X70 · X80
EN 10217-1	P235TR1 · P235TR2 · P265TR2
EN 10217-5	P235GH TC1/TC2 · P265GH TC1/TC2
EN 10219-1	S235JRH · S275J0H · S275J2H · S355J0H · S355J2H · S355K2H · S275MH · S355MH · S420MH
EN 10224	L235 · L275 · L355
ASTM A252	Grade 1 · Grade 2 · Grade 3
GOST 20295	K34 · K38 · K42 · K50 · K52 · K55

HEADLINE CAPABILITY

140"	25.4mm	3.1:1
MAX DIAMETER	MAX WALL	COIL ECONOMY

PRODUCTION STANDARDS

EN ISO 3183:2019	API 5L	EN 10217-1	EN 10217-5	
EN 10219-1	EN 10224	ASTM A252	AWWA C200	ISO 3183
DIN 2460	GOST 20295	TS EN 10217-1		

QUALITY SYSTEM & APPROVALS

ISO 9001:2015	API Spec Q1	API 5L Monogram	EN ISO 3834-2
AD 2000 W0/W4 · PED	CE · EN 10219-1	ISO 14001 / 45001	

Mill test laboratory accredited to ISO/IEC 17025. Inspection personnel qualified to ISO 9712 / ISO 11484.

Coating, Ends & Testing

— 02 / TECHNICAL

EXTERNAL COATING

System	Standard
3-layer Polyethylene (3LPE)	EN ISO 21809-1 · DIN 30670
3-layer Polypropylene (3LPP)	DIN 30678 · NFA 49711
Fusion Bonded Epoxy (FBE)	AWWA C213
Solvent-free / liquid epoxy	AWWA C210 · EN 10289
Polyurethane (marine)	EN 10290
Coal-tar / bitumen enamel	DIN 30673 · BS 534

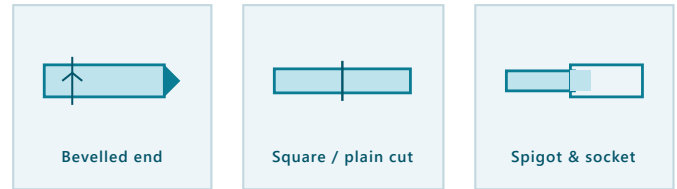
INTERNAL LINING

System	Standard
Liquid epoxy lining	AWWA C210 · EN 10289
Flow-coat epoxy (friction red.)	EN 10301
Cement mortar lining	AWWA C205 · EN 10298 · DIN 2614

SURFACE PREPARATION

Cleanliness / grade	ISO 8501-1
Soluble salts	ISO 8502-3
Surface profile	ISO 8503-1

PIPE END PREPARATION



Also available: welded-joint ends and flanged connections. Bevel weld groove carbide-machined for precise field joint fit-up.

NON-DESTRUCTIVE TESTS

- ◆ AUT coil lamination — 100% coverage
- ◆ AUT online weld inspection
- ◆ Ultrasonic inspection of weld seam
- ◆ Hydrostatic test
- ◆ Digital X-ray weld inspection
- ◆ Weld HAZ & pipe-end lamination (AUT)
- ◆ Pipe-end magnetic examination
- ◆ MPI + final visual & dimensional

DESTRUCTIVE & LABORATORY TESTS

- ◆ Tensile test
- ◆ Guided bend test
- ◆ Charpy V-notch impact
- ◆ Hardness test
- ◆ Macro & micro metallography
- ◆ DWTT drop-weight tear
- ◆ CTOD crack-tip opening
- ◆ Chemical analysis

INSPECTION CERTIFICATES

MTC · EN 10204 3.1

ISO 9712

ISO 11484

ISO/IEC 17025 lab

Dimensional Availability

— 03 / SIZE CHART

SAWH MANUFACTURING RANGE — OUTSIDE DIAMETER × WALL THICKNESS

SAWH — Spiral Welded Pipe · manufacturing range																						
mm	inch	Wall thickness (mm)																				
		4	4.8	5.6	6.4	7.1	7.9	8.7	9.5	10.3	11.1	11.9	12.7	14.3	15.9	17.5	19.1	20.6	22.2	23.8	25.4	
219.1	8"																					
273.1	10"																					
323.9	12"																					
406.4	16"																					
508	20"																					
610	24"																					
711	28"																					
813	32"																					
914	36"																					
1016	40"																					
1219	48"																					
1422	56"																					
1626	64"																					
2032	80"																					
2540	100"																					
3048	120"																					
3556	140"																					

Standard availability
 On request — consult mill

Diameters to 140" (3556 mm). Intermediate sizes & grades produced to order.

HOW TO ORDER

Specify the following when raising an enquiry or purchase order:

1 · Product	SAWH spiral welded pipe
2 · Outside Ø × wall	e.g. 1016 × 12.7 mm
3 · Grade / standard	e.g. API 5L X65 PSL2
4 · Length	e.g. 18 m · SRL/DRL
5 · Ends	bevelled / plain / S&S
6 · Coating / lining	e.g. 3LPE ext / cement int
7 · Certification	EN 10204 3.1

WORKED EXAMPLE

SAWH · 1016 × 12.7 mm
API 5L X65 PSL2 · 18 m
Bevelled ends
3LPE external · epoxy internal
MTC EN 10204 3.1

Reads as: a spiral submerged-arc welded line pipe, 40" outside diameter, 12.7 mm wall, in API 5L grade X65 PSL2, 18 m random length, bevelled ends, 3-layer polyethylene external coating with liquid-epoxy internal lining, supplied with a 3.1 mill test certificate.



GET A QUOTATION

HEAD OFFICE

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WHATSAPP

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PRODUCT REFERENCE

YTM-WP-02 · Spiral Welded (SAWH)

CERTIFICATIONS & APPROVALS

ISO 9001:2015	ISO 14001:2015	ISO 45001:2018	API Spec Q1	API 5L Monogram	EN ISO 3834-2	AD 2000 W0/W4 · PED
CE · EN 10219-1	EN 10204 3.1					