

CARBON STEEL · SEAMLESS PIPES · 04

Hot-Rolled Seamless Pipes / HRS

Hot-finished seamless steel pipe with no weld seam — for high-temperature, high-pressure process, steam, oil & gas and structural service, to ASTM A106 / A53, API 5L and EN 10216.

HRS

HFS

SMLS

10.3–660 mm

OUTSIDE Ø · ½"–26"

1.6–60 mm

WALL · SCH 5–XXS

≤ 16 m

UNIT LENGTH

A106 A/B/C

WORKHORSE GRADE

Hot-Rolled Seamless Pipes

— 01 / OVERVIEW

Hot-rolled (hot-finished) seamless pipe is produced by piercing and hot-elongating a solid steel billet — forming a pipe with **no longitudinal weld** and a homogeneous wall. The absence of a seam gives uniform strength around the full circumference, making HRS the standard choice for **high-pressure and high-temperature** service where weld integrity is critical.

FIELDS OF APPLICATION

- High-temperature & high-pressure process piping
- Steam, boiler & superheater lines
- Oil & gas gathering, process & refinery piping
- Petrochemical & power-generation plant
- Hydraulic lines & mechanical / structural use
- General pressure piping to ASME B31.x

PRODUCT RANGE

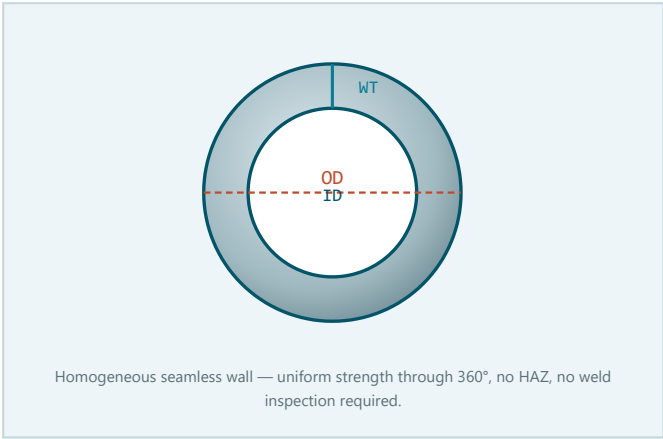
Nominal size	NPS ¼"-26" · DN 6-650
Outside diameter	10.3 – 660 mm
Wall / schedule	SCH 5 – XXS · 1.6-60 mm
Unit length	SRL/DRL 11-13 m · to 16 m
Service temp (A106)	-29 °C to +425 °C

For low-temperature / sub-zero service specify ASTM A333; for elevated-temperature creep range specify P265GH / 16Mo3.

MATERIAL GRADES

Standard	Grades supplied
ASTM A106	Grade A · Grade B · Grade C (seamless, high-temperature)
ASTM A53	Type S · Grade A · Grade B
API 5L	Gr B · X42 · X46 · X52 · X56 · X60 · X65 (PSL1 / PSL2)
EN 10216-1	P235TR1 · P235TR2 · P265TR1 · P265TR2
EN 10216-2	P235GH · P265GH · 16Mo3 (elevated temperature)
ASTM A333 / EN 10216-4	Gr 6 · P215NL · P265NL (low-temperature service)

SEAMLESS WALL – NO WELD



STANDARDS

ASTM A106	ASME B36.10M	ASTM A53	API 5L	EN 10216-1
EN 10216-2	EN 10220	ASTM A333 (LT)		

QUALITY & CERTIFICATION

ISO 9001:2015	PED 2014/68/EU	EN 10204 3.1	AD 2000-W
---------------	----------------	--------------	-----------

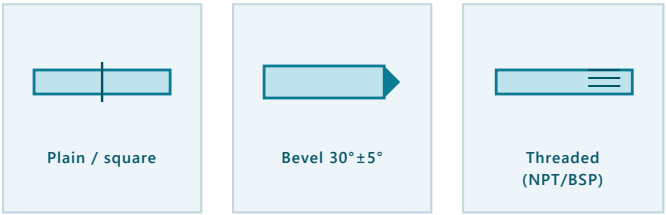
Finish, Ends & Testing

— 02 / TECHNICAL

SURFACE FINISH & COATING

Finish	Standard
Bare / mill finish	as-rolled
Varnish / anti-rust lacquer	on request
Hot-dip galvanized	ASTM A53 · EN 10240
3-layer PE / FBE (buried)	AWMA C213 · EN 10289

PIPE END PREPARATION



Bevel per ASME B16.25 / EN ISO 6761 for butt-welding. Threading to ASME B1.20.1 or ISO 7-1.

TOLERANCES

OD & wall	ASME B36.10M / A106
EN dimensional	EN 10216 tables
Length	SRL / DRL / fixed

NON-DESTRUCTIVE TESTS

- ◆ Hydrostatic test (mill)
- ◆ Ultrasonic testing (UT)
- ◆ Eddy-current testing (ET)
- ◆ Visual & dimensional check

MECHANICAL & LABORATORY TESTS

- ◆ Tensile test
- ◆ Flattening test
- ◆ Flaring / bend test
- ◆ Charpy V-notch impact
- ◆ Hardness test
- ◆ Chemical analysis
- ◆ Grain size / metallography
- ◆ Hydrostatic per spec

INSPECTION CERTIFICATES

- MTC · EN 10204 3.1
- 3.2 on request
- ISO/IEC 17025 lab

WHY SEAMLESS

- ◆ No weld seam — uniform 360° strength
- ◆ No heat-affected zone to inspect
- ◆ Superior for high pressure & temperature
- ◆ Preferred for cyclic & critical service

Dimensions & Mass

— 03 / SIZE CHART

ASME B36.10M — SELECTED WALL THICKNESS & UNIT MASS

ASME B36.10M · seamless pipe dimensions & unit mass								
NPS	DN	OD mm	STD wall	STD kg/m	XS wall	XS kg/m	SCH160 wall	XXS wall
1/8"	6	10.3	1.73	0.37	2.41	0.47		
1/4"	8	13.7	2.24	0.63	3.02	0.80		
3/8"	10	17.1	2.31	0.84	3.2	1.10		
1/2"	15	21.3	2.77	1.27	3.73	1.62	4.78	7.47
3/4"	20	26.7	2.87	1.69	3.91	2.20	5.56	7.82
1"	25	33.4	3.38	2.50	4.55	3.24	6.35	9.09
1 1/4"	32	42.2	3.56	3.39	4.85	4.47	6.35	9.7
1 1/2"	40	48.3	3.68	4.05	5.08	5.41	7.14	10.15
2"	50	60.3	3.91	5.44	5.54	7.48	8.74	11.07
2 1/2"	65	73	5.16	8.63	7.01	11.4	9.53	14.02
3"	80	88.9	5.49	11.3	7.62	15.3	11.13	15.24
4"	100	114.3	6.02	16.1	8.56	22.3	13.49	17.12
5"	125	141.3	6.55	21.8	9.53	31.0	15.88	19.05
6"	150	168.3	7.11	28.3	10.97	42.6	18.26	21.95
8"	200	219.1	8.18	42.5	12.7	64.6	23.01	22.23
10"	250	273.1	9.27	60.3	12.7	81.6	28.58	25.4
12"	300	323.9	9.53	73.9	12.7	97.5	33.32	25.4
14"	350	355.6	9.53	81.3	12.7	107.4		
16"	400	406.4	9.53	93.3	12.7	123.3		
18"	450	457	9.53	105.2	12.7	139.2		
20"	500	508	9.53	117.2	12.7	155.1		
24"	600	610	9.53	141.1	12.7	187.1		
26"	650	660	9.53	152.9	12.7	202.7		

Wall in mm · unit mass in kg/m (steel, p 7.85). Full schedule range SCH 5S–XXS available per ASME B36.10M / EN 10216.

HOW TO ORDER

1 · Product	HRS seamless pipe
2 · NPS / DN × schedule	e.g. 6" SCH 80
3 · Grade / standard	e.g. ASTM A106 Gr B
4 · Length	e.g. DRL 11–13 m
5 · Ends	bevel / plain / threaded
6 · Finish	bare / varnish / galv.
7 · Certification	EN 10204 3.1

WORKED EXAMPLE

HRS · 6" (168.3 mm) · SCH 80
ASTM A106 Grade B
DRL 11–13 m · bevelled ends
Bare finish
MTC EN 10204 3.1

Reads as: a hot-rolled seamless pipe, NPS 6 / 168.3 mm OD, schedule 80 wall (10.97 mm), in ASTM A106 Grade B, double random length, bevelled ends for butt-welding, bare finish, with a 3.1 mill test certificate.



GET A QUOTATION

HEAD OFFICE

Soğanlık Yeni Mah. Atatürk Cad. No:6/1 Else Apt.
Daire: 9 (Kat: 8), 34880 Kartal / İSTANBUL · TÜRKİYE

TELEPHONE

+90 216 306 40 44 (Pbx) · +90 216 306 40 45

WHATSAPP

+90 535 269 0292

WEB

www.ytmpipe.com

E-MAIL

sales@ytmpipe.com

PRODUCT REFERENCE

YTM-CS-04 · Hot-Rolled Seamless (HRS)

STANDARDS & CERTIFICATION

ASTM A106	ASTM A53	API 5L	ASME B36.10M	EN 10216-1/-2	ISO 9001:2015	PED 2014/68/EU	EN 10204 3.1
-----------	----------	--------	--------------	---------------	---------------	----------------	--------------