

CARBON STEEL · SEAMLESS PIPES · 05

Cold-Drawn Seamless Tubes / CDS

Cold-drawn / cold-rolled seamless precision steel tube — tight dimensional tolerances and fine surface finish for heat-exchanger, boiler, hydraulic and precision mechanical applications, to ASTM A179/A192/A210 and EN 10305-1.

CDS

CRS

CDW

SMLS

4-168 mm

OUTSIDE Ø · 1/8"–6"

0.5–20 mm

WALL THICKNESS

EN 10305 -1

PRECISION CLASS

+C·+LC
+SR etc

DELIVERY CONDITION

Cold-Drawn Seamless Precision Tubes

— 01 / OVERVIEW

Cold-drawn seamless (CDS) tube is a hot-finished seamless hollow drawn through a die over a mandrel while cold. Cold-drawing delivers **close dimensional tolerances**, a smooth bright bore and improved mechanical properties — the requirements for heat-transfer, hydraulic and precision mechanical service, where hot-finished tolerances are too coarse.

FIELDS OF APPLICATION

- ◆ Heat-exchanger & condenser tubes
- ◆ Boiler, economizer & superheater tubes
- ◆ Hydraulic & pneumatic cylinder tubes
- ◆ Precision mechanical & automotive components
- ◆ Instrumentation, fuel & injection lines
- ◆ Bearing, roller & structural precision tube

PRODUCT RANGE

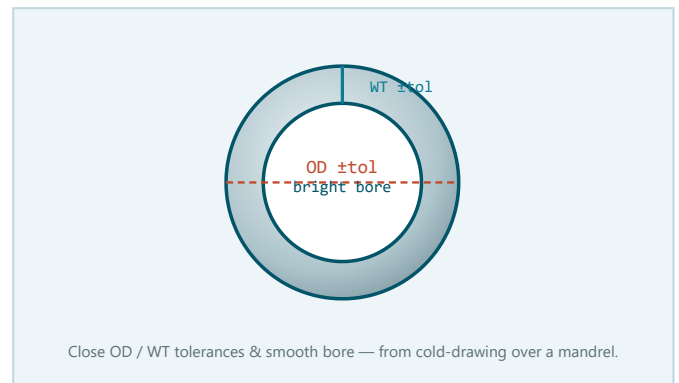
Outside diameter	4 – 168 mm · NPS 1/8"–6"
Wall thickness	0.5 – 20 mm
Tolerance	EN 10305-1 class (Annex)
Length	cut-to-length / random
Finish	bright annealed / pickled

Precision small-bore tube — tighter OD/WT tolerances than hot-rolled seamless (HRS).
Always cite the required tolerance class.

MATERIAL GRADES

Standard	Grades supplied
ASTM A179	Low-carbon cold-drawn — heat-exchanger & condenser tube
ASTM A192	Seamless carbon-steel boiler tube — high pressure
ASTM A210	Grade A-1 · Grade C — superheater & boiler tube
EN 10305-1	E235 · E355 (+C · +LC · +SR · +A · +N conditions)
EN 10216-2	P235GH · P265GH (elevated temperature)

PRECISION COLD-DRAWN WALL



STANDARDS

EN 10305-1	ASTM A179	ASTM A192	ASTM A210	EN 10216-2
ASME SA-179/192/210				

QUALITY & CERTIFICATION

ISO 9001:2015	PED 2014/68/EU	EN 10204 3.1
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Delivery Condition & Testing

— 02 / TECHNICAL

DELIVERY CONDITIONS — EN 10305-1

Code	Condition
+C	Cold-finished / as-drawn (hard)
+LC	Light cold-finished (soft)
+SR	Cold-finished, stress-relieved
+A	Annealed (soft)
+N	Normalized

State the delivery condition — it fixes strength, hardness and formability. Surface: bright annealed or pickled.

PIPE / TUBE ENDS



Precision tube is normally supplied plain / square cut-to-length; bevel on request.

TOLERANCES

OD / WT	EN 10305-1 tol. class
ASTM	close OD / WT per spec
Straightness	per class / on request

NON-DESTRUCTIVE TESTS

- ◆ Hydrostatic test
- ◆ Eddy-current test (boiler tube)
- ◆ Ultrasonic test (option)
- ◆ Visual & dimensional

MECHANICAL & LABORATORY TESTS

- ◆ Tensile test
- ◆ Flattening test
- ◆ Flaring test
- ◆ Drift-expanding test
- ◆ Hardness test
- ◆ Reverse-bend (A179)
- ◆ Chemical analysis
- ◆ Grain size / metallography

INSPECTION CERTIFICATES

MTC · EN 10204 3.1

3.2 on request

ISO/IEC 17025 lab

WHY COLD-DRAWN

- ◆ Close OD / WT tolerances
- ◆ Smooth bright bore — better heat transfer & flow
- ◆ Higher strength from cold work
- ◆ Consistent for automated assembly

Dimensional Availability

— 03 / SIZE CHART

CDS PRECISION TUBE — OUTSIDE DIAMETER × WALL THICKNESS

CDS precision tube · OD × wall thickness (mm)															
OD mm	0.5	0.8	1	1.5	2	2.5	3	4	5	6	8	10	12.5	16	20
6															
10															
12															
16															
20															
25															
30															
38															
50															
63															
76															
101.6															
114.3															
139.7															
168.3															

Standard availability

On request — consult mill

Indicative envelope · intermediate sizes to order. WT/OD combinations limited by drawing ratio.

HOW TO ORDER

1 · Product	CDS precision tube
2 · OD × wall	e.g. 25.0 × 2.0 mm
3 · Grade / standard	e.g. ASTM A179
4 · Delivery condition	e.g. EN 10305-1 +SR
5 · Tolerance class	cite class / Annex
6 · Length	cut-to-length ± tol
7 · Certification	EN 10204 3.1

WORKED EXAMPLE

CDS · 25.0 × 2.0 mm

ASTM A179 (heat-exchanger)

EN 10305-1 +SR · bright

Cut-to-length 6000 mm

MTC EN 10204 3.1

Reads as: a cold-drawn seamless heat-exchanger tube, 25.0 mm OD × 2.0 mm wall, in ASTM A179, supplied stress-relieved with a bright surface, cut to 6 m length, with a 3.1 mill test certificate.



GET A QUOTATION

HEAD OFFICE

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PRODUCT REFERENCE

YTM-CS-05 · Cold-Drawn Seamless (CDS)

STANDARDS & CERTIFICATION

ASTM A179	ASTM A192	ASTM A210	EN 10305-1	EN 10216-2	ISO 9001:2015	PED 2014/68/EU	EN 10204 3.1
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