PRODUCT DATA SHEET

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	4.0–25.4 mm	≤ 18.5 m	X80 max
OUTSIDE Ø · 8"–140"	WALL THICKNESS	UNIT LENGTH	API 5L / PSL2 GRADE

Spiral Welded Steel Pipes

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.

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.

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

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Coating, Ends & Testing

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



Bevelled end



Square / plain cut



Spigot & socket

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

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Dimensional Availability

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″	S	S	S	S	S	S	S	S	S	S	S	S	R	R	R	R	R	R	R	R
273.1	10″	S	S	S	S	S	S	S	S	S	S	S	S	S	R	R	R	R	R	R	R
323.9	12″	R	S	S	S	S	S	S	S	S	S	S	S	S	S	R	R	R	R	R	R
406.4	16″	R	S	S	S	S	S	S	S	S	S	S	S	S	S	S	R	R	R	R	R
508	20″	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S	S	R	R	R	R
610	24″	R	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S	S	R	R	R
711	28″	R	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	R	R
813	32″	R	R	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	R
914	36″	R	R	R	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S
1016	40″	R	R	R	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S
1219	48″	R	R	R	R	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S	S
1422	56″	R	R	R	R	R	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S
1626	64″	R	R	R	R	R	R	R	S	S	S	S	S	S	S	S	S	S	S	S	S
2032	80″	R	R	R	R	R	R	R	R	R	S	S	S	S	S	S	S	S	S	S	S
2540	100″	R	R	R	R	R	R	R	R	R	R	R	S	S	S	S	S	S	S	S	S
3048	120″	R	R	R	R	R	R	R	R	R	R	R	R	S	S	S	S	S	S	S	S
3556	140″	R	R	R	R	R	R	R	R	R	R	R	R	R	S	S	S	S	S	S	S

S = Standard availability · R = 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.

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GET A QUOTATION

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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

This data sheet is provided for guidance only. Dimensions, grades, tolerances and availability are indicative and may be revised without notice; binding values are those confirmed on the order acknowledgement and the mill certificate. Products are manufactured and inspected to the referenced international standards. © 2026 YTM Pipe. Document YTM-WP-02 Rev.00 · Issue 2026-08.