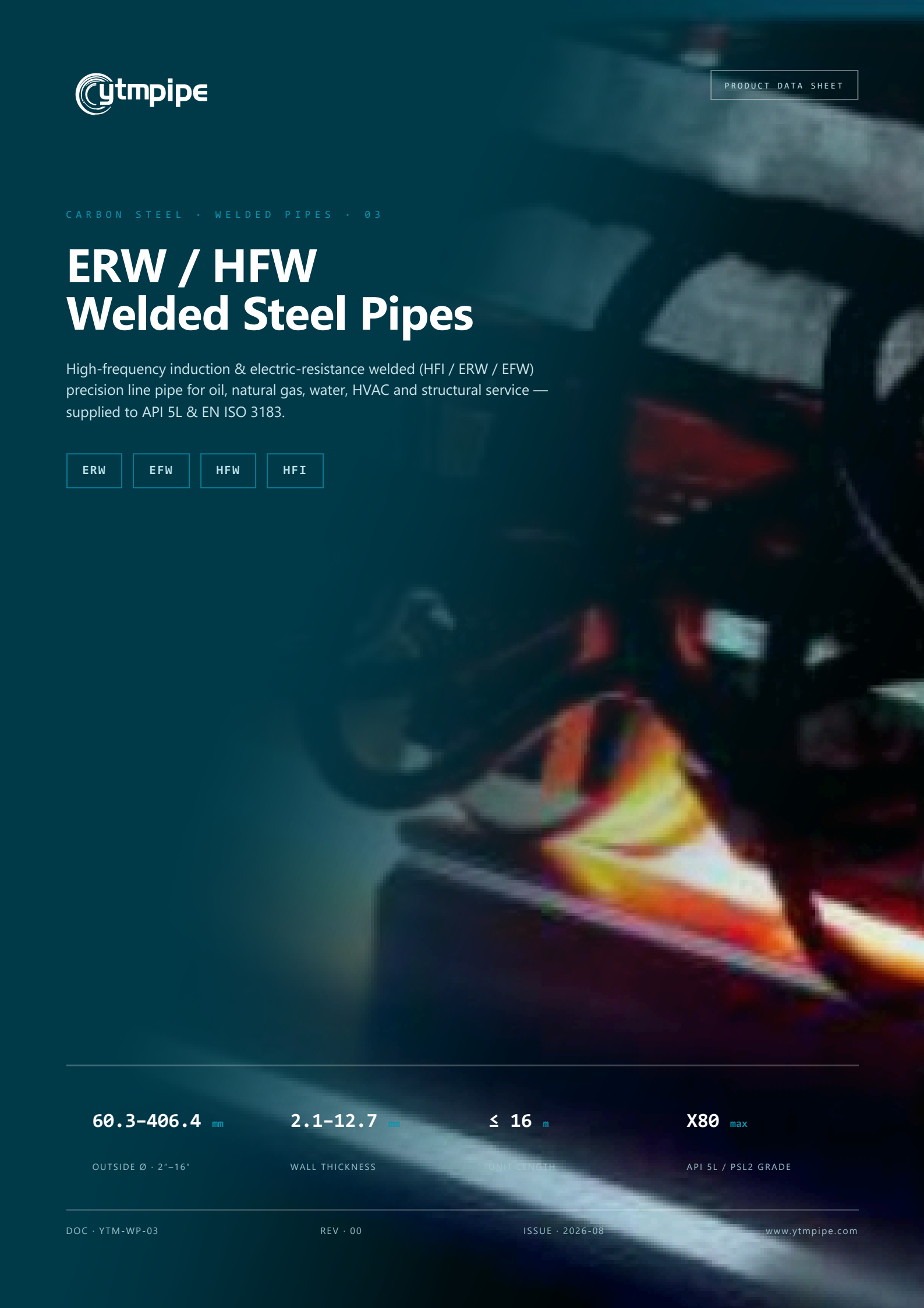
PRODUCT DATA SHEET

CARBON STEEL · WELDED PIPES · 03

ERW / HFW Welded Steel Pipes

High-frequency induction & electric-resistance welded (HFI / ERW / EFW) precision line pipe for oil, natural gas, water, HVAC and structural service — supplied to API 5L & EN ISO 3183.

ERW | EFW | HFW | HFI



60.3–406.4 mm	2.1–12.7 mm	≤ 16 m	X80 max
OUTSIDE Ø · 2"–16"	WALL THICKNESS	UNIT LENGTH	API 5L / PSL2 GRADE

ERW / HFW Welded Steel Pipes

Electric-resistance / high-frequency welded pipe is formed from steel strip and joined by a longitudinal **HFI/ERW seam** — no filler metal — then the internal and external weld bead is trimmed flush. The process gives **precise dimensional tolerances** and high-capacity output, making it the economical choice for medium-diameter transmission, distribution and structural applications.

FIELDS OF APPLICATION

- Oil, natural gas & water transmission / distribution lines
- Flammable & non-flammable fluid conveyance
- Liquid hydrocarbon & pressured-air lines
- Heating, cooling & ventilation (HVAC) piping
- Steel structures & construction elements
- High-temperature water & energy plants
- General engineering & industrial use

PRODUCT RANGE

Outside diameter	**60.3 – 406.4 mm · 2”–16”**
Wall thickness	**2.1 – 12.7 mm · 0.083”–0.500”**
Unit length	**up to 16 m**
Weld type	**HFI / ERW longitudinal**
Intermediate Ø	**76.1 · 139.7 · 159.0 · 165.1 mm**
GOST sizes	**325 · 377 · 426 mm**

HEADLINE CAPABILITY

16″	±0.5%	100%
MAX DIAMETER	TIGHT Ø TOLERANCE	ONLINE WELD NDT

PRODUCTION STANDARDS

EN ISO 3183:2019 · API 5L · EN 10217-1 · EN 10219-1 · EN 10224 · ISO 3183 · DIN 1626 · AWWA C200 · GOST 20295 · TS EN 10217-1

General-purpose / galvanized & threaded ERW water pipe also to TS EN 10255+A1, EN 10224, ASTM A53 / DIN 2440, DIN 2441, BS 1387, ISO 65.

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

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
ASTM A53	Grade A · Grade B
EN 10217-1	P235TR1 · P235TR2 · P265TR2
EN 10224	L235 · L275 · L360
ISO 3183	L245NB · L290NB · L360NB
EN 10219-1	S235JRH · S275J0H · S275J2H · S355J0H · S355J2H · S355K2H · S275MH · S355MH · S420MH
GOST 20295	K34 · K38 · K42 · K50 · K52 · K55

Specifications subject to change without notice · © 2026 YTM Pipe

Coating, Ends & Testing

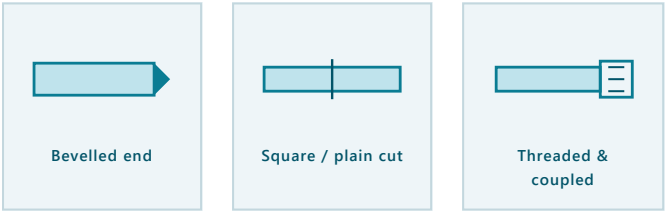
SURFACE PREPARATION & FINISH

Finish	Standard
Hot-dip galvanized	EN 10240 · DIN 2444 · ASTM A53/A90
Primer coated / protective oil	on request
Blast cleaning grade	ISO 8501-1 · 8502-3 · 8503-1
Threading & coupling	TS 10255 · DIN 2999 · ISO 7-1 · BS 21

EXTERNAL COATING & INTERNAL LINING

System	Standard
3-layer PE / PP	EN ISO 21809-1 · DIN 30670/30678
Fusion Bonded Epoxy (FBE)	AWWA C213
Liquid epoxy (ext / int)	AWWA C210 · EN 10289
Flow-coat epoxy (int)	EN 10301
Cement mortar lining	AWWA C205 · EN 10298
Bitumen / coal-tar	DIN 30673 · BS 534

PIPE END PREPARATION



Also: welded-joint and spigot & socket ends. Internal and external weld flash removed for a smooth bore.

NON-DESTRUCTIVE TESTS

- Eddy-current test
- Ultrasonic weld-seam test
- AUT online weld inspection
- First visual inspection
- Hydrostatic testing
- Digital X-ray weld inspection
- Pipe-end magnetic examination
- MPI + final visual & dimensional

Ultrasonic weld-seam test on 60.3–406.4 mm (2⅜"–13⅜").

DESTRUCTIVE & LABORATORY TESTS

- Flattening test
- Guided bend test
- Expanding test
- Tensile test
- Charpy V-notch impact
- Hardness test
- Macro & micro metallography
- DWTT & CTOD

INSPECTION CERTIFICATES

MTC · EN 10204 3.1 | ISO 9712 | ISO 11484 | ISO/IEC 17025 lab

WHY HFI / ERW

- Precise, repeatable dimensional tolerances
- Smooth flush weld — low flow resistance
- High-capacity, cost-efficient production
- Full-body & 100% online weld NDT

Specifications subject to change without notice · © 2026 YTM Pipe

Dimensional Availability

— 03 / SIZE CHART

HFW / ERW MANUFACTURING RANGE — OUTSIDE DIAMETER × WALL THICKNESS

HFW / ERW — manufacturing range

mm	inch	Wall thickness (mm)														
		2.1	2.6	3.2	3.6	4	4.5	5	5.6	6.4	7.1	7.9	8.7	9.5	10.3	11.1	12.7
60.3	2″	■	■	■	■	■	■	□	□	□	□	□	□	□	□	□	□
76.1	2½″	■	■	■	■	■	■	■	□	□	□	□	□	□	□	□	□
88.9	3″	□	■	■	■	■	■	■	■	□	□	□	□	□	□	□	□
114.3	4″	□	■	■	■	■	■	■	■	■	□	□	□	□	□	□	□
139.7	5″	□	□	■	■	■	■	■	■	■	■	□	□	□	□	□	□
165.1	6″	□	□	■	■	■	■	■	■	■	■	■	□	□	□	□	□
219.1	8″	□	□	□	■	■	■	■	■	■	■	■	■	■	□	□	□
273.1	10″	□	□	□	□	■	■	■	■	■	■	■	■	■	■	■	□
323.9	12″	□	□	□	□	□	■	■	■	■	■	■	■	■	■	■	■
355.6	14″	□	□	□	□	□	□	■	■	■	■	■	■	■	■	■	■
406.4	16″	□	□	□	□	□	□	□	■	■	■	■	■	■	■	■	■

■ Standard availability □ On request — consult mill

Intermediate & GOST diameters and other grades produced to order.

HOW TO ORDER

Specify the following when raising an enquiry or purchase order:

1 · Product	**HFW / ERW welded pipe**
2 · Outside Ø × wall	**e.g. 219.1 × 6.4 mm**
3 · Grade / standard	**e.g. API 5L X52 PSL1**
4 · Length	**e.g. 12 m · SRL/DRL**
5 · Ends	**bevel / plain / threaded**
6 · Finish / coating	**e.g. HDG or 3LPE ext**
7 · Certification	**EN 10204 3.1**

WORKED EXAMPLE

HFW · 219.1 × 6.4 mm
API 5L X52 PSL1 · 12 m
Bevelled ends
3LPE external coating
MTC EN 10204 3.1

Reads as: a high-frequency welded line pipe, 8″ outside diameter, 6.4 mm wall, in API 5L grade X52 PSL1, 12 m random length, bevelled ends, 3-layer polyethylene external coating, supplied with a 3.1 mill test certificate.

Specifications subject to change without notice · © 2026 YTM Pipe

GET A QUOTATION

HEAD OFFICE

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

TELEPHONE

+90 543 306 40 48 (Pbx) · +90 216 306 40 45

WHATSAPP

+90 543 306 40 48

WEB

www.ytmpipe.com

E-MAIL

sales@ytmpipe.com

PRODUCT REFERENCE

YTM-WP-03 · ERW / HFW Welded

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-03 Rev.00 · Issue 2026-08.