PRODUCT DATA SHEET

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	1.6–60 mm	≤ 16 m	A106 A/B/C
OUTSIDE Ø · ⅛"–26"	WALL · SCH 5–XXS	UNIT LENGTH	WORKHORSE GRADE

Hot-Rolled Seamless Pipes

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

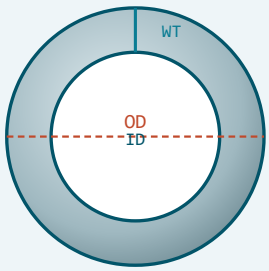
- High-temperature & high-pressure process piping
- Steam, boiler & superheater lines
- Oil & gas gathering, process & refinery piping
- Petrochemical & power-generation plant
- Hydraulic lines & mechanical / structural use
- General pressure piping to ASME B31.x

PRODUCT RANGE

Nominal size	**NPS ⅛"–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.

SEAMLESS WALL — NO WELD



Homogeneous seamless wall — uniform strength through 360°, no HAZ, no weld inspection required.

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

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)

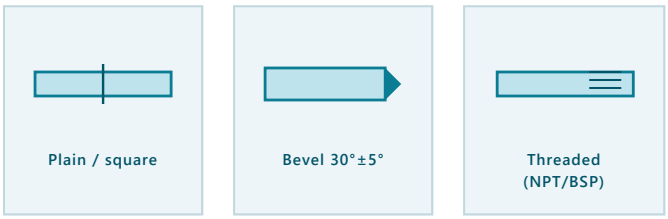
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Finish, Ends & Testing

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)	AWWA 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)
- Eddy-current testing (ET)
- Ultrasonic testing (UT)
- Visual & dimensional check

MECHANICAL & LABORATORY TESTS

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

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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, ρ 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.

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GET A QUOTATION

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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

This data sheet is provided for guidance only. Dimensions, masses, grades, tolerances and availability are indicative and follow the cited standards; binding values are those of the current standard edition and the order acknowledgement / mill certificate. Unit masses are calculated (nominal). © 2026 YTM Pipe. Document YTM-CS-04 Rev.00 · Issue 2026-08.