PRODUCT DATA SHEET

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	0.5–20 mm	EN 10305 -1	+C·+LC +SR etc
OUTSIDE Ø · ⅛"–6"	WALL THICKNESS	PRECISION CLASS	DELIVERY CONDITION

Cold-Drawn Seamless Precision Tubes

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

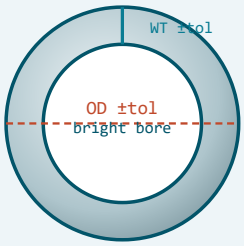
- Heat-exchanger & condenser tubes
- Boiler, economizer & superheater tubes
- Hydraulic & pneumatic cylinder tubes
- Precision mechanical & automotive components
- Instrumentation, fuel & injection lines
- Bearing, roller & structural precision tube

PRODUCT RANGE

Outside diameter	**4 – 168 mm · NPS ⅛”–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.

PRECISION COLD-DRAWN WALL



Close OD / WT tolerances & smooth bore — from cold-drawing over a mandrel.

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

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)

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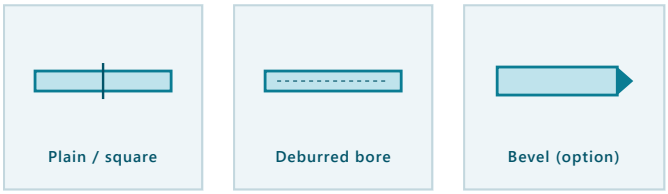
Delivery Condition & Testing

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

MECHANICAL & LABORATORY TESTS

- Tensile test
- Hardness test
- Flattening test
- Reverse-bend (A179)
- Flaring test
- Chemical analysis
- Drift-expanding test
- 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

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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.

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GET A QUOTATION

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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

This data sheet is provided for guidance only. Dimensions, tolerances, grades and availability are indicative and follow the cited standards; binding values are those of the current standard edition and the order acknowledgement / mill certificate. © 2026 YTM Pipe. Document YTM-CS-05 Rev.00 · Issue 2026-08.