

EN 10255 seamless steel tube

EN 10255 seamless steel tube from TPMC is manufactured by piercing solid billets using the advanced PQF process, ensuring a uniform, seamless structure with exceptional strength and reliability.

Our TPMC tube is ideal for welding or threading and suitable for conveying water, gas, air, as well as for general structural applications.



- Certificate: ISO
- Standard: EN 10255 S195T seamless (S)
- Length: 6m / 5.8m / 11.8m / 12m / 20ft, etc.
- End: Plain: square cut
Beveled: 30° angle (+5°/-0°)
Roll-grooved: per ISO 6182-12
Threaded (NPT): per ASME B1.20.1
Threaded (BSPT): per ISO 7-1 / BS 21
- Surface: FBE / polyester resin powder
Water-based red or black paint
Hot-dip galvanized / duplex coating
Plastic lining (PE, UPVC, etc.)

Available sizes for Heavy series tube

Outside diameter			Wall thickness		Weight	Test pressure	Ref. No.
NPS	DN	OD (mm)	Series	T (mm)	kg/m	MPa	
1/2"	15	21.3	Heavy	3.2	1.44	5.0	P2601-H (ISO)
3/4"	20	26.9	Heavy	3.2	1.87	5.0	P2602-H (ISO)
1"	25	33.7	Heavy	4.0	2.93	5.0	P2603-H (ISO)
1-1/4"	32	42.4	Heavy	4.0	3.79	5.0	P2604-H (ISO)
1-1/2"	40	48.3	Heavy	4.0	4.37	5.0	P2605-H (ISO)
2"	50	60.3	Heavy	4.5	6.19	5.0	P2606-H (ISO)
2-1/2"	65	76.1	Heavy	4.5	7.93	5.0	P2607-H (ISO)
3"	80	88.9	Heavy	5.0	10.30	5.0	P2608-H (ISO)
4"	100	114.3	Heavy	5.4	14.50	5.0	P2609-H (ISO)
5"	125	139.7	Heavy	5.4	17.90	5.0	P2610-H (ISO)
6"	150	165.1	Heavy	5.4	21.30	5.0	P2611-H (ISO)

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Available sizes for Medium series tube

Outside diameter			Wall thickness		Weight	Test pressure	Ref. No.
NPS	DN	OD (mm)	Series	T (mm)	kg/m	MPa	
1/2"	15	21.3	Medium	2.6	1.21	5.0	P2601-M (ISO)
3/4"	20	26.9	Medium	2.6	1.56	5.0	P2602-M (ISO)
1"	25	33.7	Medium	3.2	2.41	5.0	P2603-M (ISO)
1-1/4"	32	42.4	Medium	3.2	3.10	5.0	P2604-M (ISO)
1-1/2"	40	48.3	Medium	3.2	3.56	5.0	P2605-M (ISO)
2"	50	60.3	Medium	3.6	5.03	5.0	P2606-M (ISO)
2-1/2"	65	76.1	Medium	3.6	6.42	5.0	P2607-M (ISO)
3"	80	88.9	Medium	4.0	8.36	5.0	P2608-M (ISO)
4"	100	114.3	Medium	4.5	12.20	5.0	P2609-M (ISO)
5"	125	139.7	Medium	5.0	16.60	5.0	P2610-M (ISO)
6"	150	165.1	Medium	5.0	19.80	5.0	P2611-M (ISO)

Available sizes for Type L tube

Outside diameter			Wall thickness		Weight	Test pressure	Ref. No.
NPS	DN	OD (mm)	Series	T (mm)	kg/m	MPa	
1/2"	15	21.3	Type L	2.3	1.08	5.0	P2601-L (ISO)
3/4"	20	26.9	Type L	2.3	1.40	5.0	P2602-L (ISO)
1"	25	33.7	Type L	2.9	2.20	5.0	P2603-L (ISO)
1-1/4"	32	42.4	Type L	2.9	2.82	5.0	P2604-L (ISO)
1-1/2"	40	48.3	Type L	2.9	3.25	5.0	P2605-L (ISO)
2"	50	60.3	Type L	3.2	4.51	5.0	P2606-L (ISO)
2-1/2"	65	76.1	Type L	3.2	5.75	5.0	P2607-L (ISO)
3"	80	88.9	Type L	3.2	6.76	5.0	P2608-L (ISO)
4"	100	114.3	Type L	3.6	9.83	5.0	P2609-L (ISO)
5"	125	139.7	Type L	4.5	15.00	5.0	P2610-L (ISO)
6"	150	165.1	Type L	4.5	17.80	5.0	P2611-L (ISO)

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Available sizes for Type L1 tube

Outside diameter			Wall thickness		Weight	Test pressure	Ref. No.
NPS	DN	OD (mm)	Series	T (mm)	kg/m	MPa	
1/2"	15	21.3	Type L1	2.3	1.08	5.0	P2601-L1 (ISO)
3/4"	20	26.9	Type L1	2.3	1.39	5.0	P2602-L1 (ISO)
1"	25	33.7	Type L1	2.9	2.20	5.0	P2603-L1 (ISO)
1-1/4"	32	42.4	Type L1	2.9	2.82	5.0	P2604-L1 (ISO)
1-1/2"	40	48.3	Type L1	2.9	3.24	5.0	P2605-L1 (ISO)
2"	50	60.3	Type L1	3.2	4.49	5.0	P2606-L1 (ISO)
2-1/2"	65	76.1	Type L1	3.2	5.73	5.0	P2607-L1 (ISO)
3"	80	88.9	Type L1	3.6	7.55	5.0	P2608-L1 (ISO)
4"	100	114.3	Type L1	4.0	10.80	5.0	P2609-L1 (ISO)

Available sizes for Type L2 tube

Outside diameter			Wall thickness		Weight	Test pressure	Ref. No.
NPS	DN	OD (mm)	Series	T (mm)	kg/m	MPa	
1/2"	15	21.3	Type L2	2.0	0.95	5.0	P2601-L2 (ISO)
3/4"	20	26.9	Type L2	2.3	1.38	5.0	P2602-L2 (ISO)
1"	25	33.7	Type L2	2.6	1.98	5.0	P2603-L2 (ISO)
1-1/4"	32	42.4	Type L2	2.6	2.54	5.0	P2604-L2 (ISO)
1-1/2"	40	48.3	Type L2	2.9	3.23	5.0	P2605-L2 (ISO)
2"	50	60.3	Type L2	2.9	4.08	5.0	P2606-L2 (ISO)
2-1/2"	65	76.1	Type L2	3.2	5.71	5.0	P2607-L2 (ISO)
3"	80	88.9	Type L2	3.2	6.72	5.0	P2608-L2 (ISO)
4"	100	114.3	Type L2	3.6	9.75	5.0	P2609-L2 (ISO)

Chemical composition (%) per EN 10255 S195T seamless

C	Mn	P	S
≤ 0.20	≤ 1.40	≤ 0.035	≤ 0.030

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Mechanical properties per EN 10255 S195T seamless

Upper yield strength ReH (MPa)	Tensile strength Rm (MPa)	Elongation A (%)
≥ 195	320 ~ 520	≥ 20



Standard requirements

- Heat treatment: Type L cold formed tubes shall be heat treated. Others may be at manufacturer's discretion.
- Tensile test: Tensile, yield, and elongation tested per standard.
- Bend test: Bare tubes ≤ DN 50, cold bent 90° around specified former, no cracks.
- Flattening test: Not required.

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Leak tightness test

- Each tube (before threading, if applicable) shall be hydrostatically tested at a minimum pressure of 50 bar, held for at least 5 seconds with no leakage.
- At the manufacturer's discretion, an electromagnetic test is alternative in accordance with EN 10246-1, including eddy current or magnetic flux leakage method.



Dimensional tolerances

- Outside diameter: As per Table 2 (M/H series) and Annex B (Types L, L1, L2).
- Wall thickness: $\pm 12.5\%$; the $+12.5\%$ (upper) limit does not apply if the actual bundle weight does not exceed the theoretical weight by more than $+7.5\%$.
- Cut length: Exact length (e.g. 6 m), $+6 \text{ mm} / -0 \text{ mm}$ (or as agreed).
- Weight: Not separately stated; controlled via wall thickness tolerance (with $+7.5\%$ bundle weight relaxation on upper wall deviation).



Other quality assurance

- Straightness: $\geq \text{DN}25$, deviation $\leq 0.002 \times L$ (tube length).
- Coating inspection: DFT and adhesion (see TPMC PA11-PA51).
- Marking: Legibly marked per standard (see TPMC PA71).
- Packaging: End protection, bundling, and shipping marks (see TPMC PA81).
- Test certificate: Issued by TPMC with full traceability to MTC/MTR.