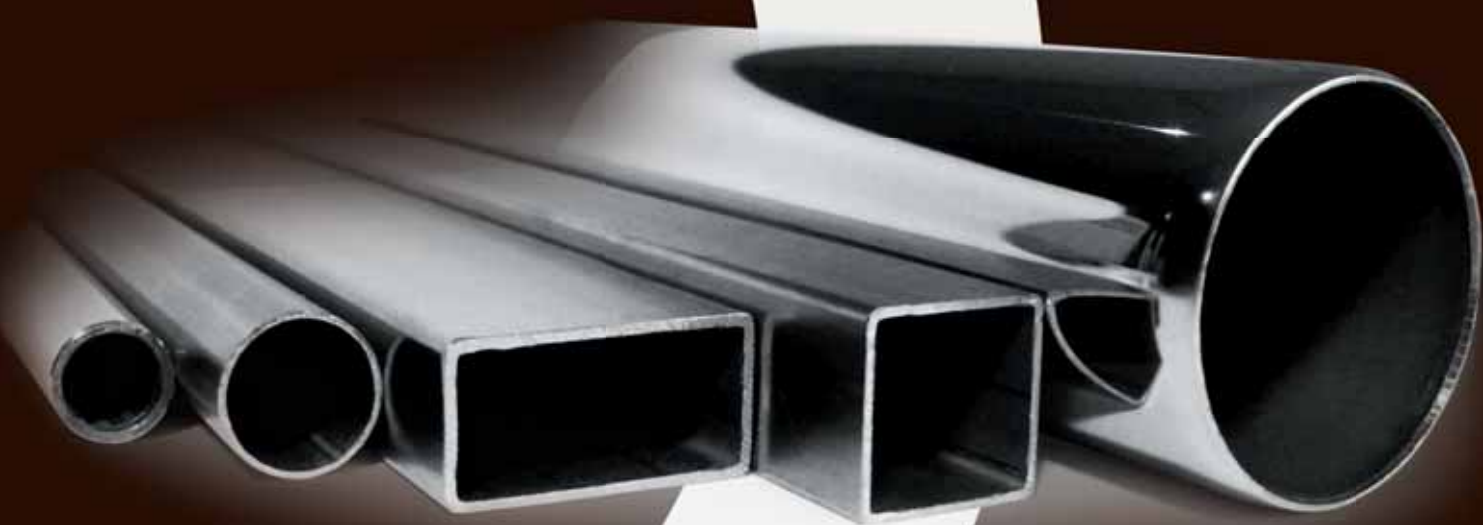


**PRODUCTION OF  
WELDED STAINLESS TUBES**



**Techn  Tube**

**PC+** Made in Russia

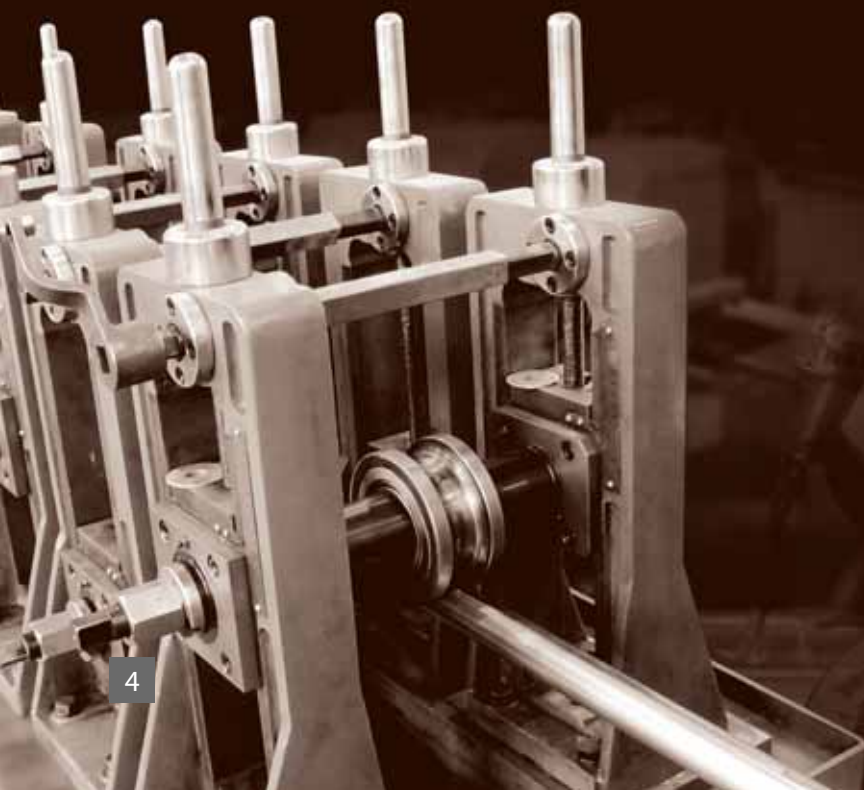
## Main manufacturing standards:

- **Process tubes for fluids.** Manufacturing standard: DIN 11850, EN 10217-7, EN DIN 10357, EN 10312, AD 2000 W2/W10, PED 97/23.
- **Tubes for mechanical applications.** Manufacturing standard: EN 10217-7, EN 10296
- **Tubes for heat treatment.** Manufacturing standard: EN 10217-7, ASTM A249, EN 10296, AD 2000 W2/W10, PED 97/23.
- **Construction and ornamental round tubes and box sections.** Manufacturing standard: ASTM A554, EN 10296.
- **Round tubes for automotive industry.** Manufacturing standard: EN 10296, ASTM A554

## Techno Tube manufacture capacities currently include:

- 6 tube-welding mills with TIG welding and 2 Laser mill.
- Tubes polishing workshop.
- Longitudinal cutting machine, with machined rolled thickness of 0.8 mm to 6 mm.
- Metal lathe CNC for repair, modernization and production parts of equipment and tools.
- Blade recovery (sharpen saw)
- Laboratory

Overall capacity of 14 thousands tons per year.



Techno Tube manufactures certified welded stainless steel tubes, including tubes for applications in the food industry, chemistry and pharmaceuticals, oil and gas, heat exchangers and other mechanical applications.

#### SIZE OF TUBES:

- Round tubes from 12 till 104 mm
- Square tubes from 10x10 till 80x80 mm
- Rectangular tubes from 20x10 till 100x60 mm

#### WALL THICKNESS:

from 0,5 till 5 mm

#### SURFACE QUALITY:

- matte
- ground
- mirror
- annealed

#### GRADE:

- TP 304
- TP 321
- TP 316L
- TP 316Ti
- TP 430
- TP 409
- TP 439
- TP 201
- TP 202
- TP 904L
- Alloy 75

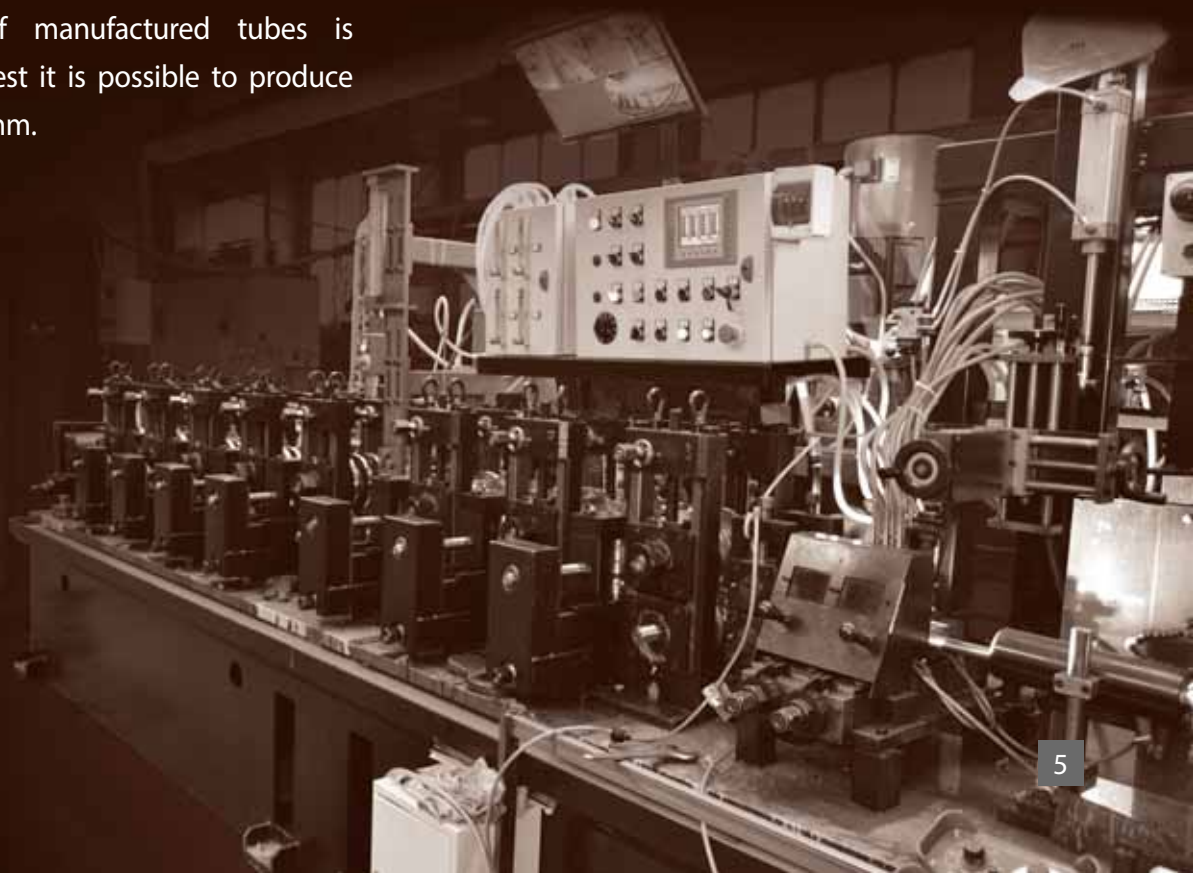
Standard length of manufactured tubes is 6000 mm. On request it is possible to produce from 3000 to 12000 mm.

We use only high-quality strips corresponding to the requirements of EN 10088-2.

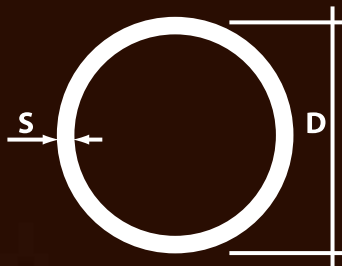
Standard and optional testing:

- Chemical composition
- Micrographic analysis
- Flattening test
- Expansion test
- Radial expansion test
- Leakage test
- Dimensional test
- Surface roughness measurement
- Intergranular corrosion test
- Non destructive eddy current weld test
- Pneumo leakage test

On request it is possible to produce bright annealed tubes for usage in the processing pipeline.



# Round stainless steel welded tubes



Grade: TP 304, 201, 202, 321, 316L, 316Ti, 430, 409, 439, 904L and Alloy 75

Manufacturing standard: EN 10217-7, EN 10296-2, ASTM A554, ASTM A312, ASTM A778, ASTM A268, ASTM A249, DIN 11850 (EN DIN 10357).

Surface quality: matte, ground, mirror, annealed

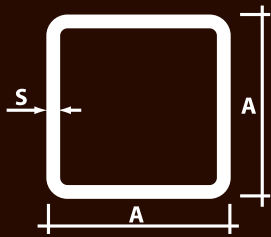
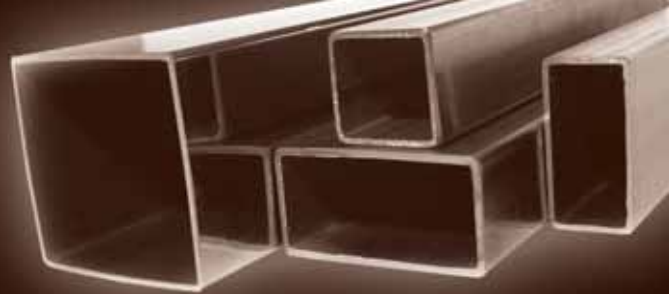
Length from 3000 to 12000 mm

Metric sizes of produced tubes. Weight in kg per 1 meter.

Outside diameter, D mm	Wall thickness, S mm												
	0,5	0,6	0,7	0,8	1	1,2	1,5	2	2,5	3	4	5	
12	0,142	0,171	0,198	0,224	0,273	0,325	0,394						
14	0,166	0,201	0,233	0,264	0,326	0,385	0,470						
15	0,179	0,216	0,251	0,284	0,347	0,415	0,503						
16	0,191*	0,231*	0,268*	0,304*	0,376*	0,445*	0,545*	0,695*					
18	0,216*	0,261*	0,303*	0,344*	0,426*	0,505*	0,620*	0,801*					
20	0,240*	0,291*	0,338*	0,385*	0,476*	0,565*	0,695*	0,901*					
21,3	0,256	0,311	0,361	0,411	0,508	0,604	0,737	0,967					
22	0,265	0,322	0,373	0,425	0,518	0,625	0,770	1,002					
23	0,279	0,337	0,391	0,445	0,546	0,655	0,800	1,042					
25	0,302*	0,367*	0,426*	0,485*	0,601*	0,715*	0,883*	1,152*	1,409*	1,653*			
26,9					0,643	0,772	0,946	1,236	1,527	1,795			
28					0,676*	0,805*	0,995*	1,302*	1,582*	1,861*			
30					0,726	0,865	1,070	1,402	1,722	2,028			
32					0,776*	0,925*	1,146*	1,502*	1,830*	2,159*			
33					0,794*	0,956*	1,173*	1,539*	1,909*	2,254*			
33,7					0,812	0,977	1,200	1,570	1,953	2,306			
34					0,819	0,986	1,210	1,588	1,954	2,308			
35					0,851	1,016	1,258	1,653	2,035	2,404			
38					0,926	1,106	1,371	1,803	2,222	2,629	3,375		
40					0,977*	1,166*	1,446*	1,903*	2,348*	2,779*	3,606*		
42,4					1,037	1,238	1,536	2,023	2,498	2,960	3,847		
43					1,042	1,256	1,545	2,035	2,513				
45					1,102	1,316	1,634	2,153	2,620	3,155	4,070	4,964	
48,3					1,184	1,415	1,740	2,319	2,840	3,403	4,438	5,373	
50,8					1,247*	1,490*	1,852*	2,444*	3,024*	3,591*	4,646*	5,683*	
52					1,266*	1,526*	1,880*	2,504*	3,099*	3,681*	4,765*	5,832*	
53					1,291*	1,556*	1,917*	2,554*	3,161*	3,756*	4,864*	5,956*	
57					1,402	1,677	2,070	2,730	3,380	4,020			
60,3					1,485	1,776	2,209	2,920	3,590	4,270			
63,5					1,551	1,872	2,308	3,053	3,785	4,505	5,903	7,259	
70					1,712*	2,067*	2,573*	3,405*	4,226*	5,033*			
76,1					1,864*	2,251*	2,802*	3,711*	4,607*	5,491*	7,158*	8,823*	
80							2,922	3,872	4,809	5,733	7,545	9,307	
84							3,071	4,070*	5,057	6,031	7,942		
85							3,136	4,157	5,165	6,160	8,041		
88,9							3,254	4,313	5,361	6,396	8,428	10,411	
101,6							3,760	4,988	6,204	7,407	9,776	12,094	
103							3,779	5,013	6,236	7,446	9,828	12,161	
104							3,850	5,108	6,354	7,587	10,016	12,395	

\* - possible production for the food and dairy industry

## Square stainless steel welded tubes



Grade: TP 304, 201, 202, 321, 316L, 316Ti, 430, 409, 439, 904L and Alloy 75

Manufacturing standard: EN 10296-2, ASTM A554, DIN 2395

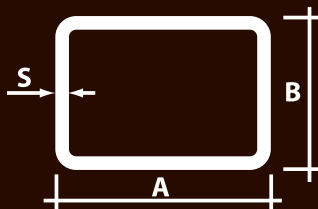
Surface quality: matte, ground, mirror.

Length from 3000 to 12000 mm

Metric sizes of produced tubes. Weight in kg per 1 meter.

External dimensions, A x B mm	Wall thickness, S mm							
	0,5	1	1,5	2	2,5	3	4	5
10x10	0,147	0,271	0,372					
15x15	0,226	0,453	0,661	0,767				
20x20	0,305	0,613	0,901	1,175				
25x25		0,772	1,140	1,495				
30x30		1,112	1,379	1,814	2,236			
35x35		1,091	1,618	2,132	2,635			
40x40		1,251	1,858	2,452	3,033	3,602		
50x50		1,535	2,336	3,090	3,831	4,559		
60x60		1,851	2,814	3,728	4,628	5,516		
70x70			3,216	4,243	5,248	6,229		
80x80			3,690	4,875	6,038	7,177	9,389	11,510

## Rectangular stainless steel welded tubes



Grade: TP 304, 201, 202, 321, 316L, 316Ti, 430, 409, 439, 904L and Alloy 75

Manufacturing standard: EN 10296-2, ASTM A554, DIN 2395

Surface quality: matte, ground, mirror.

Length from 3000 to 12000 mm

Metric sizes of produced tubes. Weight in kg per 1 meter.

External dimensions, A x B mm	Wall thickness, S mm							
	0,5	1	1,5	2	2,5	3	4	5
20x10	0,226	0,429	0,609	0,767				
20x25	0,344	0,666	0,965	1,241				
30x20		0,771	1,129	1,399				
40x20		0,931	1,379	1,814	2,088			
50x30		1,219	1,852	2,434	3,003	3,502		
60x40		1,535	2,336	3,090	3,668	4,559		
80x40		1,851	2,742	3,611	4,458	5,281		
80x60			3,216	4,243	5,248	6,229		
100x40			3,216	4,243	5,248	6,229		
100x50			3,453	4,559	5,643	6,703	8,757	10,720
100x60			3,690	4,880	6,038	7,177	9,389	11,510