

# HAELOK® TECHNICAL DATA STAINLESS STEEL (XX).

## PIPES & TEMPERATURE

### Approved pipe tolerances and corresponding standards

#### Inch pipe outside diameter

DN	Size	Nominal outer-ø according to standard		Permissible wall thickness	
		OD1 <sub>nom</sub>	OD2 <sub>nom</sub>	s <sub>min</sub>	s <sub>max</sub>
8	¼"	13.50	13.72	1.60	2.30
10	⅜"	17.20	17.15	1.60	2.77
15	½"	21.30	21.26	1.60	2.77
20	¾"	26.90	26.67	2.11	3.91
25	1"	33.70	33.41	2.60	4.55
32	1 ¼"	42.40	42.16	2.60	5.08
40	1 ½"	48.30	48.26	2.60	5.08
50	2"	60.30	60.33	2.60	5.54
65	2 ½"	76.10	73.03	2.30	5.00
80	3"	88.90	88.90	2.30	5.54
100	4"	114.30	114.30	2.60	5.54

#### Metric tube outside diameter

d	Nominal outer-ø according to standard		Permissible wall thickness	
	OD1 <sub>nom</sub>	& OD2 <sub>nom</sub>	s <sub>min</sub>	s <sub>max</sub>
10	10		1.0	2
12	12		1.50	2
15	15		1.50	3
16	16		1.50	3
18	18		1.50	3
20	20		1.50	3
22	22		1.50	3
25	25		1.50	3
28	28		1.50	3
30	30		1.50	3
35	35		2.00	3
38	38		2.00	4
42	42		2.00	4

### MATCHING PIPE SPECIFICATIONS STAINLESS STEEL (XX) Tolerances D3 and T3

OD1 EN 10217-7, EN 10216-5, EN ISO 1127  
OD2 ASTM A268, A269

In case you want to use other pipes with our system contact our sales department (sales@haelok.com).

### Applicable tubes

HAELOK fittings are applicable for stainless steel pipes. Seamless or welded.

The pipe surface must be clean and without grooves or strong scoring. (Grooves > 0.1 mm are not allowed)

Loose rolling skin, scale and rust must be removed.

Hot-rolled tubes or tubes with scaly surfaces are not permitted.

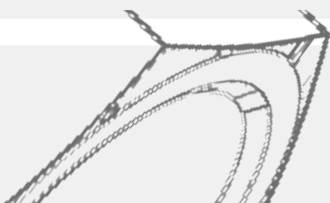
Pipe hardness: Maximum values of 90 (Rockwell B) are permissible.

Temperature range is from -190°C to +400°C, depending on the material used. At raised temperatures the maximum working pressure must be reduced according to the table.

### Temperature ranges

Temp C°	Edelstahl (XX)
50	4%
100	12%
150	15%
200	20%
250	25%
300	30%
350	33%
400	35%

Flow coefficients are available on request.



All figures in mm; others are specifically marked.  
Subject to misprints and technical changes.

Status of Product Information:  
2023-07

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## PRESSURE

### Applications and burst pressure testing of our fittings

#### Inch tube outside diameter

DN	Size	OD	PN (nominal pressure) Safety factor 2	PN (IACS) Safety factor 4	s (wall thickness)	Burst pressure test
8	¼"	13.5	600 bar	300 bar	1.8	1137 bar
10	⅜"	17.2	400 bar	200 bar	1.8	800 bar
15	½"	21.3	400 bar	200 bar	2.0	800 bar
20	¾"	26.9	400 bar	200 bar	2.3	800 bar
25	1"	33.7	400 bar	200 bar	2.6	800 bar
32	1 ¼"	42.4	300 bar	150 bar	2.6	600 bar
40	1 ½"	48.3	300 bar	150 bar	2.6	600 bar
50	2"	60.3	300 bar	150 bar	2.6	600 bar
65	2 ½"	76.1	125 bar	n.a.	3.2	250 bar
80	3"	88.9	125 bar	n.a.	3.2	250 bar
100	4"	114.3	125 bar	n.a.	3.6	250 bar

#### Metric tube outside diameter

Size	OD	PN (nominal pressure) Safety factor 2	PN (IACS) Safety factor 4	s (wall thickness)	Burst pressure test
12	12	600 bar	300 bar	1.5	1137 bar
15	15	400 bar	200 bar	1.5	800 bar
16	16	400 bar	200 bar	1.5	800 bar
18	18	400 bar	200 bar	1.5	800 bar
20	20	400 bar	200 bar	2	800 bar
22	22	400 bar	200 bar	2	800 bar
25	25	400 bar	200 bar	2.5	800 bar
28	28	400 bar	200 bar	2.5	800 bar
30	30	400 bar	200 bar	3	800 bar
35	35	300 bar	150 bar	3	600 bar
38	38	300 bar	150 bar	3	600 bar
42	42	300 bar	150 bar	3	600 bar