Stainless Steel Tubular Products
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Weights
All weights shown in this publication are for guidance only. They are calculated using nominal dimensions and scientifically recognised densities. Please note that in practice, the actual weight can vary significantly from the theoretical weight due to variations in manufacturing tolerances and compositions.

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Aalco is the UK’s largest independent multi-metals stockholder. Customers from every sector of the UK manufacturing and engineering industries, whether small local businesses or large multinational corporations, benefit from a cost-effective single source for all their metals requirements.

Aalco – delivering customer service and investing in capability:

- An inventory that includes aluminium, stainless steel, copper, brass, bronze and nickel alloys in all semi-finished forms
- Comprehensive processing services providing items cut and/or finished to customer requirements
- Eighteen locations bringing local service to every corner of the UK
- Ongoing investment in technology and logistics to ensure on-time delivery

No order is too large or too small and Aalco offers a responsive and competitive service for supplying anything from single item orders to major JIT contracts, tailoring this service to individual needs.

Whatever your requirement, in whatever quantity, your local Aalco service centre is ready and willing to satisfy your needs. For a quotation, for further information, more extensive technical information, advice on product selection or to place an order, please contact your local Aalco service centre or refer to the web site www.aalco.co.uk.

Service
The most comprehensive stock range; the highest investment in processing equipment; local service centres nationwide; helpful, friendly, knowledgeable staff and the industry’s biggest fleet of delivery vehicles – it all adds up to unbeatable service.

Aalco has maintained market leadership over many years through an absolute dedication to customer service – a service level that is continuously monitored and improved through key performance indicators.

That’s why, for reliable, on-time delivery of exactly what you want, when and where you need it, whether it’s a small one-off item or a complex JIT contract, Aalco is the essential first choice.

People
Exceptional customer service starts with people. Aalco develops and retains high quality personnel using a variety of ‘in house’ courses which cover both skills training, product knowledge and teamwork.

Every Aalco service centre has a dedicated team of people working together to provide an unbeatable service to customers in their region. Customers can expect to receive a quick and informed response to any enquiries for material or for information.

Quality
Aalco takes great care when selecting manufacturing sources for its products and every mill we use is measured against a series of predetermined quality control requirements. All products supplied by Aalco conform to the relevant BS or international standards. Certification can be supplied on request.

Aalco service centres operate a quality manual designed to ISO9001/2008 requirements. Many vendor approvals and bespoke quality control systems are operated through individual Aalco service centres.
Stock Range

**Tube**
Seamless to ASTM A269, imperial sizes from 1/8” O/D x 24swg to 4” O/D x 1/4” wall in grade 316L
Seamless to ASTM A269, grades 304L & 316L, in metric sizes 6mm O/D x 0.5mm wall to 38mm O/D x 4mm wall
Decorative – Round, Square, Rectangular
Structural – Square and Rectangular up to 250mm
Hygienic (see below)
Welded Metric Nominal Internal Diameter (see below)

**Pipe**
Seamless and Welded to ASTM A312 from 1/8” to 24” in grades 304L & 316L

**Flanges**
ASTM A182 / ANSI B16.5
BS 10 Table E, Grade 316L
BS 4504 / EN 1092 Raised Face, 16 Bar
Backing Flanges in Aluminium and Coated Mild Steel

**Fittings**
Butt Weld Fittings, Seamless and Welded, to ASTM A403 in grades 304L & 316L including elbows, tees & reducers
BSP Screwed Fittings, grade 316 from 1/8” to 3”
Hygienic fittings (see below)
Welded Metric Nominal Internal Diameter (see below)

**Hygienic Tube and Fittings**
Grades 304L & 316L 1/8” O/D to 4” O/D:
Tube – As Welded & Descaled, Annealed & Polished or Bright Annealed
Bends, Fitted Bends, Tees, Reducers, Clamps & Tube Hangers
Unions – RJT, IDF & DIN

**Metric – Welded Nominal Internal Diameter (ND)**
From 18mm O/D x 1.5mm wall to 910mm O/D x 5mm wall
Grades 1.4432 (316L High Molybdenum) & 1.4307 (304L)
Tube, Elbows, Tees, Reducers, Collars, End Caps, Tube Clamps & Clips
Backing Flanges in Aluminium & Coated Mild Steel

Further information is provided by these publications, available either from your local Service Centre or at www.aalco.co.uk

<table>
<thead>
<tr>
<th><strong>Product Guide</strong></th>
<th><strong>Stocklist</strong></th>
<th><strong>Metric</strong></th>
<th><strong>Handrail</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Technical information on applications, uses and specifications for stainless steel, aluminium, copper, brass and bronze.</td>
<td>A guide to the Aalco standard stock range in stainless steel, aluminium, copper, brass and bronze.</td>
<td>A guide to the range of light-walled nominal diameter metric stainless steel tubular products used in water treatment, pulp &amp; paper and other industries.</td>
<td>A guide to the Aalco range of stainless steel handrail/ balustrade systems comprising tube and slotted tube plus associated fittings.</td>
</tr>
</tbody>
</table>
BSP fittings are a family of fittings used to connect up threaded pipe and equipment.

- They are manufactured from pipe, bar, hollow bar, castings or forgings.
- The pipe to be threaded must have a wall thickness of Schedule 40S minimum.
- The fittings are used in non-critical, low pressure applications where welding is not possible or required. They therefore provide a relatively low cost method of connection.
- BSP fittings are usually fitted with a sealant (paste or tape such as PTFE) and are considered to be permanent pipe-work.

- Low Pressure BSP Fittings are rated at 150lb and are made to wrought iron specification BS 1740.
- BSP fittings are made only in type 316.
- They are provided with a Certificate of Conformity only, and not a full Test Certificate.
- Sizes 1/8 to 3 inch are the most commonly used and thus the most readily available.
- External MALE threads are tapered and Internal FEMALE threads are parallel. The threads are cut to BS21: Part 1: 1985 and are called Whitworth Threads – See below.
BSP Fittings
Sizes/Specifications

Dimensions

<table>
<thead>
<tr>
<th>Nominal Size of Outlet</th>
<th>D Min O/D</th>
<th>E Min O/D of body behind external thread</th>
<th>d Min I/D of body behind internal thread</th>
<th>No. of threads per inch</th>
</tr>
</thead>
<tbody>
<tr>
<td>in mm</td>
<td>mm</td>
<td>mm</td>
<td>mm</td>
<td></td>
</tr>
<tr>
<td>¼ 6</td>
<td>15.0</td>
<td>9.8</td>
<td>8.6</td>
<td>28</td>
</tr>
<tr>
<td>¼ 8</td>
<td>18.5</td>
<td>13.3</td>
<td>11.4</td>
<td>19</td>
</tr>
<tr>
<td>½ 10</td>
<td>22.0</td>
<td>16.8</td>
<td>15.0</td>
<td>19</td>
</tr>
<tr>
<td>¾ 15</td>
<td>27.0</td>
<td>21.1</td>
<td>18.6</td>
<td>14</td>
</tr>
<tr>
<td>1¼ 20</td>
<td>32.5</td>
<td>26.6</td>
<td>24.1</td>
<td>14</td>
</tr>
<tr>
<td>1 25</td>
<td>39.5</td>
<td>33.4</td>
<td>30.3</td>
<td>11</td>
</tr>
<tr>
<td>1¼ 32</td>
<td>49.0</td>
<td>42.1</td>
<td>39.0</td>
<td>11</td>
</tr>
<tr>
<td>1½ 40</td>
<td>56.0</td>
<td>48.0</td>
<td>44.8</td>
<td>11</td>
</tr>
<tr>
<td>2 50</td>
<td>68.0</td>
<td>59.8</td>
<td>56.7</td>
<td>11</td>
</tr>
<tr>
<td>2¼ 65</td>
<td>84.0</td>
<td>75.4</td>
<td>72.2</td>
<td>11</td>
</tr>
<tr>
<td>3 75</td>
<td>98.0</td>
<td>88.1</td>
<td>84.9</td>
<td>11</td>
</tr>
<tr>
<td>4 100</td>
<td>124.0</td>
<td>113.3</td>
<td>110.1</td>
<td>11</td>
</tr>
<tr>
<td>5 125</td>
<td>151.0</td>
<td>138.7</td>
<td>135.5</td>
<td>11</td>
</tr>
<tr>
<td>6 150</td>
<td>178.0</td>
<td>164.1</td>
<td>160.9</td>
<td>11</td>
</tr>
</tbody>
</table>

Threading requirements

Fittings manufactured to BS 1740 are threaded in accordance with BS 21:1985, Pipe threads for tubes and fittings where pressure-tight joints are made on the threads.

Internal Parallel Thread (Rₚ)

External Taper Thread (R)

Tolerances (BS 1740)

<table>
<thead>
<tr>
<th>Nominal Pipe Size</th>
<th>Length of Socket Unions ±mm</th>
<th>Length or Centre to Face Tolerances for Other Fittings ±mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>≤25</td>
<td>6</td>
<td>1.5</td>
</tr>
<tr>
<td>25 to 40</td>
<td>6</td>
<td>3.0</td>
</tr>
<tr>
<td>&gt;40 to 65</td>
<td>10</td>
<td>4.5</td>
</tr>
<tr>
<td>&gt;65 to 75</td>
<td>12</td>
<td>6.0</td>
</tr>
<tr>
<td>&gt;75 to 110</td>
<td>16</td>
<td>-</td>
</tr>
<tr>
<td>&gt;75 to 150</td>
<td>-</td>
<td>8.0</td>
</tr>
<tr>
<td>&gt;150</td>
<td>-</td>
<td>10.0</td>
</tr>
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</table>
www.aalco.co.uk

ABERDEEN
Tel 01224 854810
Fax 01224 871982
e-mail aberdeen@aalco.co.uk

AYLESBURY
Tel 01296 461700
Fax 01296 339923
e-mail aylesbury@aalco.co.uk

BELFAST
Tel 02890 838 838
Fax 02890 837 837
e-mail belfast@aalco.co.uk

BIRMINGHAM
Tel 0121 585 3600
Fax 0121 585 6864
e-mail birmingham@aalco.co.uk

CHEPSTOW
Tel 01291 638 638
Fax 01291 638 600
e-mail chepstow@aalco.co.uk

DYFED
Tel 01269 842044
Fax 01269 845276
e-mail dyfed@aalco.co.uk

ESSEX
Tel 01268 884200
Fax 01268 884220
e-mail essex@aalco.co.uk

GLASGOW
Tel 0141 646 3200
Fax 0141 646 3260
e-mail glasgow@aalco.co.uk

HULL
Tel 01482 626262
Fax 01482 626263
e-mail hull@aalco.co.uk

LEEDS
Tel 0113 276 3300
Fax 0113 276 0382
e-mail leeds@aalco.co.uk

LIVERPOOL
Tel 0151 207 3551
Fax 0151 207 2657
e-mail liverpool@aalco.co.uk

MANCHESTER
Tel 01204 863466
Fax 01204 863430
e-mail manchester@aalco.co.uk

NEWCASTLE
Tel 0191 491 1133
Fax 0191 491 1177
e-mail newcastle@aalco.co.uk

NOTTINGHAM
Tel 0115 988 2600
Fax 0115 988 2636
e-mail nottingham@aalco.co.uk

SOUTHAMPTON
Tel 023 8087 5200
Fax 023 8087 5275
e-mail southampton@aalco.co.uk

STOKE
Tel 01782 375700
Fax 01782 375701
e-mail stoke@aalco.co.uk

SWANLEY
Tel 01322 610900
Fax 01322 610910
e-mail swanley@aalco.co.uk

DUBLIN
Tel +353 1 6298 600
Fax +353 1 6299 200
e-mail: dublin@amari-dublin.com

CORK
Tel +353 21 4310 520
Fax +353 21 4310 519
e-mail: cork@amari-cork.com

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