

**BLAZE**

BS 1387 ERW Steel Pipe

Description:

Electric Resistance Welded (ERW) BS 1387 Steel Pipe is manufactured by rolling steel strip into a cylindrical shape and electrically welding the longitudinal seam. The weld is heat-treated after welding to eliminate untempered martensite, ensuring enhanced strength and durability. Weld flash is removed from both the internal and external surfaces, providing a smooth finish and improved flow characteristics.

Manufactured in accordance with ISO 65 / BS 1387:1985 / EN 10255, ERW steel pipes are available in Light, Medium and Heavy series. They are suitable for potable water supply, hot and cold water systems, fire protection pipelines, HVAC installations and other general piping applications. Threaded pipes conforming to BS 21 are also available upon request.



Specifications :

Size	1/2 " to 6" (DN15 to DN150)
Working Pressure	20 Bar (300 psi)
Certification	ISO
Standard	BS 1387 / EN 10255 L2
Finish	Galvanized / Black / Red
Applications	Fire Standpipe, Fire Sprinkler Branch Pipe



Technical Specification - Class A :

Size			Thickness	Mass for Plain End	Mass for Threaded & Socketed	Test Pressure
Inch	DN	OD(mm)	T(mm)	kg/m	kg/m	MPa
1/2"	15	21.3	2.0	0.95	0.96	5.0
3/4"	20	26.9	2.3	1.38	1.39	5.0
1"	25	33.7	2.6	1.98	2.00	5.0
1-1/4"	32	42.4	2.6	2.54	2.57	5.0
1-1/2"	40	48.3	2.9	3.23	3.27	5.0
2"	50	60.3	2.9	4.08	4.15	5.0
2-1/2"	65	76.1	3.2	5.71	5.83	5.0
3"	80	88.9	3.2	6.72	6.89	5.0
4"	100	114.3	3.6	9.75	10.00	5.0

*Dimension and mass comply with ISO 65 / EN10255 M / BS 1387:1985.

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Technical Specification - Class B :

Size			Thickness	Mass for Plain End	Mass for Threaded & Socketed	Test Pressure
Inch	DN	OD(mm)	T(mm)	kg/m	kg/m	MPa
1/2"	15	21.3	2.6	1.21	1.22	5.0
3/4"	20	26.9	2.6	1.56	1.57	5.0
1"	25	33.7	3.2	2.41	2.43	5.0
1-1/4"	32	42.4	3.2	3.10	3.13	5.0
1-1/2"	40	48.3	3.2	3.57	3.61	5.0
2"	50	60.3	3.6	5.03	5.10	5.0
2-1/2"	65	76.1	3.6	6.43	6.55	5.0
3"	80	88.9	4.0	8.37	8.54	5.0
4"	100	114.3	4.5	12.20	12.50	5.0
5"	125	139.7	5.0	16.60	17.10	5.0
6"	150	165.1	5.0	19.70	20.30	5.0

*Dimension and mass comply with ISO 65 / EN10255 M / BS 1387:1985.

Technical Specification - Class C :

Size			Thickness	Mass for Plain End	Mass for Threaded & Socketed	Test Pressure
Inch	DN	OD(mm)	T(mm)	kg/m	kg/m	MPa
1/2"	15	21.3	3.2	1.44	1.45	5.0
3/4"	20	26.9	3.2	1.87	1.88	5.0
1"	25	33.7	4.0	2.94	2.96	5.0
1-1/4"	32	42.4	4.0	3.80	3.83	5.0
1-1/2"	40	48.3	4.0	4.38	4.42	5.0
2"	50	60.3	4.5	6.19	6.26	5.0
2-1/2"	65	76.1	4.5	7.93	8.05	5.0
3"	80	88.9	5.0	10.30	10.50	5.0
4"	100	114.3	5.4	14.50	14.80	5.0
5"	125	139.7	5.4	17.90	18.40	5.0
6"	150	165.1	5.4	21.30	21.90	5.0

*Dimension and mass comply with ISO 65 / EN10255 M / BS 1387:1985.

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Permissible Dimensional Variations for Light Duty Pipes :

Size			OD Tolerance	Min T.	Remark
Inch	DN	OD(mm)	mm	mm	
1/2"	15	21.3	21.0 ~ 21.4	1.8	- All dimensional tolerances are as per EN 10255 L2 and BS 1387. - Outside diameter tolerances are specified in BS 1387 Table 3. - The minimum wall thickness is permitted to be 8% below nominal, and although no maximum wall thickness is defined, the mass tolerance restricts any excessive increase.
3/4"	20	26.9	26.4 ~ 26.9	2.1	
1"	25	33.7	33.2 ~ 33.8	2.4	
1-1/4"	32	42.4	41.9 ~ 42.5	2.4	
1-1/2"	40	48.3	47.8 ~ 48.4	2.7	
2"	50	60.3	59.6 ~ 60.2	2.7	
2-1/2"	65	76.1	75.2 ~ 76.0	2.9	
3"	80	88.9	87.9 ~ 88.7	2.9	
4"	100	114.3	113.0 ~ 113.9	3.3	

Note :

1. For exact length, length tolerance is -0.0mm / +6.0mm.
2. For each pipe, the weight (mass) tolerance is -8% / +10%.
3. For $\geq 150\text{m}$ quantity of one size, the average weight (mass) tolerance is $\pm 4\%$.

Permissible Dimensional Variations for Medium / Heavy Duty Pipes :

Size			OD Tolerance	Min T		Remark
Inch	DN	OD(mm)	mm	mm	mm	
1/2"	15	21.3	21.1~21.7	2.3	2.9	- Dimensional tolerances are in accordance with BS 1387 and EN 10255 Heavy & Medium series. - Outside diameter tolerances follow BS 1387 Tables 4 and 5. - The minimum wall thickness may be up to 10% below the nominal value, while no maximum wall thickness is defined in BS 1387; any increase is instead restricted by the applicable mass tolerance. - Blaze additionally applies EN 10255 H&M guidance, permitting up to +10% on wall thickness within mass-controlled limits.
3/4"	20	26.9	26.6~27.2	2.3	2.9	
1"	25	33.7	33.4~34.2	2.9	3.6	
1-1/4"	32	42.4	42.1~42.9	2.9	3.6	
1-1/2"	40	48.3	48.0~48.8	2.9	3.6	
2"	50	60.3	59.8~60.8	3.2	4.1	
2-1/2"	65	76.1	75.4~76.6	3.2	4.1	
3"	80	88.9	88.1~89.5	3.6	4.5	
4"	100	114.3	113.3~114.9	4.1	4.9	
5"	125	139.7	138.7~140.6	4.5	4.9	
6"	150	165.1	164.1~166.1	4.5	4.9	

Note :

1. For exact length, length tolerance is -0.0mm / +6.0mm.
2. For each pipe, the weight (mass) tolerance is -8% / +10%.
3. For $\geq 150\text{m}$ quantity of one size, the average weight (mass) tolerance is $\pm 4\%$.