

## USSR STATE STANDARD

## SEAMLESS COLD-FORMED STEEL PIPES

GOST  
8734-75\*.

Range of sizes

In place of  
GOST 8734-58

Period of validity set by Decree No. 2604, dated 13.10.75 of the State Committee for Standards under the USSR Council of Ministers

from 01.01 1977.  
until 01.01 1982.

**Failure to comply with this Standard will result in legal proceedings**

1. External diameter, wall thickness and estimated weight of pipes shall comply with the values stipulated in table 1.

2. Pipes shall be subdivided into the following groups depending on the ratio of external diameter ( $D_e$ ) to the wall thickness ( $s$ ):

extra thin-walled with  $D_e/s$  over 40 and pipe 20 mm or less in diameter with 0.5 mm thick wall and thicker;

thin-walled with  $D_e/s$  from 12.5 to 40 and pipe 20 mm or less in diameter with a wall of 1.5 mm thick;

thick-walled with  $D_e/s$  from 6 to 12.5;

extra thick-walled with  $D_e/s$  less than 6.

3. Pipes with the following lengths shall be produced:

with non-standard lengths from 1.5 to 11.5 m;

with standard lengths from 4.5 to 9 m with +10 mm maximum deviations of length;

lengths, multiples of standard lengths from 1.5 to 9 m with the allowance for every cut of 5 mm (if another allowance has not been stipulated in the order) and with the maximum deviations for the total length not exceeding the values coordinated for the pipes of standard lengths. No more than 5% of the pipes of non-standard lengths no shorter than 2.5 m shall be allowed in every batch of pipes of standard lengths.

4. Maximum deviations of external diameter and wall thickness of the pipes shall not exceed the values stipulated in table 2.

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p. 2 GOST 8734-75

| External diameter, mm | Estimated weight of 1 m of pipe, kg |        |        |        |                    |        |       |
|-----------------------|-------------------------------------|--------|--------|--------|--------------------|--------|-------|
|                       | 0.3                                 | 0.4    | 0.5    | 0.6    | 0.8                | 1.0    | 1.2   |
|                       | <b>Extra thin-walled</b>            |        |        |        | <b>Thin-walled</b> |        |       |
| 5                     | 0.0348                              | 0.0454 | 0.0555 | 0.0651 | 0.0829             | 0.0986 | 0.112 |
| 6                     | 0.0422                              | 0.0552 | 0.0678 | 0.0799 | 0.103              | 0.123  | 0.142 |
| 7                     | 0.0496                              | 0.0651 | 0.0801 | 0.0947 | 0.122              | 0.148  | 0.172 |
| 8                     | 0.0570                              | 0.0750 | 0.0925 | 0.110  | 0.142              | 0.173  | 0.201 |
| 9                     | 0.0644                              | 0.0847 | 0.105  | 0.124  | 0.162              | 0.197  | 0.231 |
| 10                    | 0.0718                              | 0.0947 | 0.117  | 0.139  | 0.182              | 0.222  | 0.260 |
| 11                    | 0.0792                              | 0.105  | 0.129  | 0.154  | 0.201              | 0.247  | 0.290 |
| 12                    | 0.0866                              | 0.114  | 0.142  | 0.169  | 0.221              | 0.271  | 0.320 |
| 13                    | 0.0940                              | 0.124  | 0.154  | 0.184  | 0.241              | 0.296  | 0.349 |
| 14                    | 0.101                               | 0.134  | 0.166  | 0.198  | 0.260              | 0.321  | 0.379 |
| 15                    | 0.109                               | 0.144  | 0.179  | 0.213  | 0.280              | 0.345  | 0.408 |
| 16                    | 0.116                               | 0.154  | 0.191  | 0.228  | 0.300              | 0.370  | 0.438 |
| 17                    | 0.124                               | 0.164  | 0.203  | 0.243  | 0.320              | 0.395  | 0.468 |
| 18                    | 0.131                               | 0.174  | 0.216  | 0.258  | 0.339              | 0.419  | 0.497 |
| 19                    | 0.138                               | 0.183  | 0.228  | 0.272  | 0.359              | 0.444  | 0.527 |
| 20                    | 0.146                               | 0.193  | 0.240  | 0.287  | 0.375              | 0.469  | 0.556 |
| 21                    | –                                   | 0.203  | 0.253  | 0.302  | 0.399              | 0.493  | 0.586 |
| 22                    | –                                   | 0.213  | 0.265  | 0.317  | 0.418              | 0.518  | 0.616 |
| 23                    | –                                   | 0.223  | 0.277  | 0.331  | 0.438              | 0.543  | 0.645 |
| 24                    | –                                   | 0.233  | 0.290  | 0.346  | 0.458              | 0.567  | 0.675 |
| 25                    | –                                   | 0.243  | 0.302  | 0.361  | 0.477              | 0.592  | 0.704 |
| 26                    | –                                   | 0.253  | 0.314  | 0.376  | 0.497              | 0.617  | 0.734 |
| 27                    | –                                   | 0.262  | 0.327  | 0.391  | 0.517              | 0.641  | 0.764 |
| 28                    | –                                   | 0.272  | 0.339  | 0.405  | 0.537              | 0.666  | 0.793 |
| 30                    | –                                   | 0.292  | 0.364  | 0.435  | 0.576              | 0.715  | 0.852 |
| 32                    | –                                   | 0.312  | 0.388  | 0.465  | 0.616              | 0.764  | 0.911 |
| 34                    | –                                   | 0.331  | 0.413  | 0.494  | 0.655              | 0.814  | 0.971 |
| 35                    | –                                   | 0.341  | 0.425  | 0.509  | 0.675              | 0.838  | 1.000 |
| 36                    | –                                   | 0.351  | 0.438  | 0.524  | 0.694              | 0.863  | 1.030 |
| 38                    | –                                   | 0.371  | 0.462  | 0.553  | 0.734              | 0.912  | 1.089 |
| 40                    | –                                   | 0.391  | 0.487  | 0.583  | 0.773              | 0.962  | 1.148 |

Table 1

with wall thickness of, mm

| 1.4                | 1.5   | 1.6                 | 1.8   | 2.0                       | 2.2   | 2.5   |
|--------------------|-------|---------------------|-------|---------------------------|-------|-------|
| <b>Thin-walled</b> |       | <b>Thick-walled</b> |       | <b>Extra-thick-walled</b> |       |       |
| 0.124              | 0.129 | –                   | –     | –                         | –     | –     |
| 0.159              | 0.166 | 0.174               | 0.186 | 0.197                     | –     | –     |
| 0.193              | 0.208 | 0.213               | 0.231 | 0.247                     | 0.260 | 0.277 |
| 0.228              | 0.240 | 0.253               | 0.275 | 0.296                     | 0.315 | 0.339 |
| 0.262              | 0.277 | 0.292               | 0.320 | 0.345                     | 0.369 | 0.401 |
| 0.297              | 0.314 | 0.332               | 0.364 | 0.395                     | 0.426 | 0.462 |
| 0.331              | 0.351 | 0.371               | 0.408 | 0.444                     | 0.477 | 0.524 |
| 0.366              | 0.388 | 0.410               | 0.453 | 0.493                     | 0.532 | 0.586 |
| 0.401              | 0.425 | 0.450               | 0.497 | 0.543                     | 0.586 | 0.647 |
| 0.435              | 0.462 | 0.489               | 0.542 | 0.592                     | 0.640 | 0.709 |
| 0.470              | 0.499 | 0.529               | 0.586 | 0.641                     | 0.694 | 0.771 |
| 0.504              | 0.536 | 0.568               | 0.630 | 0.691                     | 0.749 | 0.832 |
| 0.539              | 0.573 | 0.608               | 0.675 | 0.740                     | 0.803 | 0.894 |
| 0.573              | 0.610 | 0.647               | 0.719 | 0.789                     | 0.857 | 0.956 |
| 0.608              | 0.647 | 0.687               | 0.764 | 0.838                     | 0.911 | 1.017 |
| 0.642              | 0.684 | 0.726               | 0.808 | 0.888                     | 0.966 | 1.079 |
| 0.677              | 0.721 | 0.765               | 0.852 | 0.937                     | 1.020 | 1.141 |
| 0.711              | 0.758 | 0.805               | 0.897 | 0.986                     | 1.074 | 1.202 |
| 0.746              | 0.795 | 0.844               | 0.941 | 1.036                     | 1.129 | 1.264 |
| 0.780              | 0.832 | 0.884               | 0.985 | 1.085                     | 1.183 | 1.326 |
| 0.815              | 0.869 | 0.923               | 1.030 | 1.134                     | 1.237 | 1.387 |
| 0.849              | 0.906 | 0.963               | 1.074 | 1.184                     | 1.291 | 1.449 |
| 0.884              | 0.943 | 1.002               | 1.119 | 1.233                     | 1.346 | 1.511 |
| 0.918              | 0.980 | 1.042               | 1.163 | 1.282                     | 1.400 | 1.572 |
| 0.987              | 1.054 | 1.121               | 1.252 | 1.381                     | 1.508 | 1.695 |
| 1.056              | 1.128 | 1.200               | 1.341 | 1.480                     | 1.617 | 1.819 |
| 1.126              | 1.202 | 1.278               | 1.429 | 1.578                     | 1.725 | 1.942 |
| 1.160              | 1.239 | 1.318               | 1.474 | 1.628                     | 1.780 | 2.004 |
| 1.195              | 1.276 | 1.357               | 1.518 | 1.677                     | 1.834 | 2.065 |
| 1.264              | 1.350 | 1.436               | 1.607 | 1.776                     | 1.942 | 2.189 |
| 1.333              | 1.424 | 1.515               | 1.696 | 1.874                     | 2.051 | 2.312 |

p. 4 GOST 8734 –75

| External diameter, mm | Estimated weight of 1 m of pipe, kg. |       |       |       |       |   |
|-----------------------|--------------------------------------|-------|-------|-------|-------|---|
|                       | 2.8                                  | 3.0   | 3.2   | 3.5   | 4.0   |   |
| Extra thick-walled    |                                      |       |       |       |       |   |
| 5                     | –                                    | –     | –     | –     | –     | – |
| 6                     | –                                    | –     | –     | –     | –     | – |
| 7                     | –                                    | –     | –     | –     | –     | – |
| 8                     | –                                    | –     | –     | –     | –     | – |
| 9                     | –                                    | –     | –     | –     | –     | – |
| 10                    | 0.497                                | 0.518 | 0.537 | 0.561 | –     | – |
| 11                    | 0.566                                | 0.592 | 0.616 | 0.647 | –     | – |
| 12                    | 0.635                                | 0.666 | 0.694 | 0.734 | –     | – |
| 13                    | 0.704                                | 0.740 | 0.773 | 0.820 | 0.888 | – |
| 14                    | 0.773                                | 0.814 | 0.852 | 0.906 | 0.986 | – |
| 15                    | 0.842                                | 0.888 | 0.931 | 0.993 | 1.085 | – |
| 16                    | 0.911                                | 0.962 | 1.010 | 1.079 | 1.184 | – |
| 17                    | 0.981                                | 1.036 | 1.089 | 1.165 | 1.282 | – |
| 18                    | 1.050                                | 1.110 | 1.168 | 1.252 | 1.381 | – |
| 19                    | 1.119                                | 1.184 | 1.247 | 1.338 | 1.480 | – |
| 20                    | 1.188                                | 1.258 | 1.326 | 1.424 | 1.578 | – |
| 21                    | 1.257                                | 1.332 | 1.405 | 1.511 | 1.677 | – |
| 22                    | 1.326                                | 1.406 | 1.484 | 1.597 | 1.776 | – |
| 23                    | 1.395                                | 1.480 | 1.563 | 1.683 | 1.874 | – |
| 24                    | 1.464                                | 1.554 | 1.641 | 1.769 | 1.973 | – |
| 25                    | 1.533                                | 1.628 | 1.720 | 1.856 | 2.072 | – |
| 26                    | 1.602                                | 1.702 | 1.800 | 1.942 | 2.170 | – |
| 27                    | 1.671                                | 1.776 | 1.878 | 2.028 | 2.269 | – |
| 28                    | 1.740                                | 1.850 | 1.957 | 2.115 | 2.368 | – |
| 30                    | 1.878                                | 1.998 | 2.115 | 2.287 | 2.565 | – |
| 32                    | 2.016                                | 2.146 | 2.273 | 2.460 | 2.762 | – |
| 34                    | 2.154                                | 2.294 | 2.430 | 2.633 | 2.959 | – |
| 35                    | 2.223                                | 2.367 | 2.510 | 2.719 | 3.058 | – |
| 36                    | 2.293                                | 2.441 | 2.588 | 2.805 | 3.157 | – |
| 38                    | 2.431                                | 2.589 | 2.746 | 2.978 | 3.354 | – |
| 40                    | 2.569                                | 2.737 | 2.904 | 3.150 | 3.551 | – |

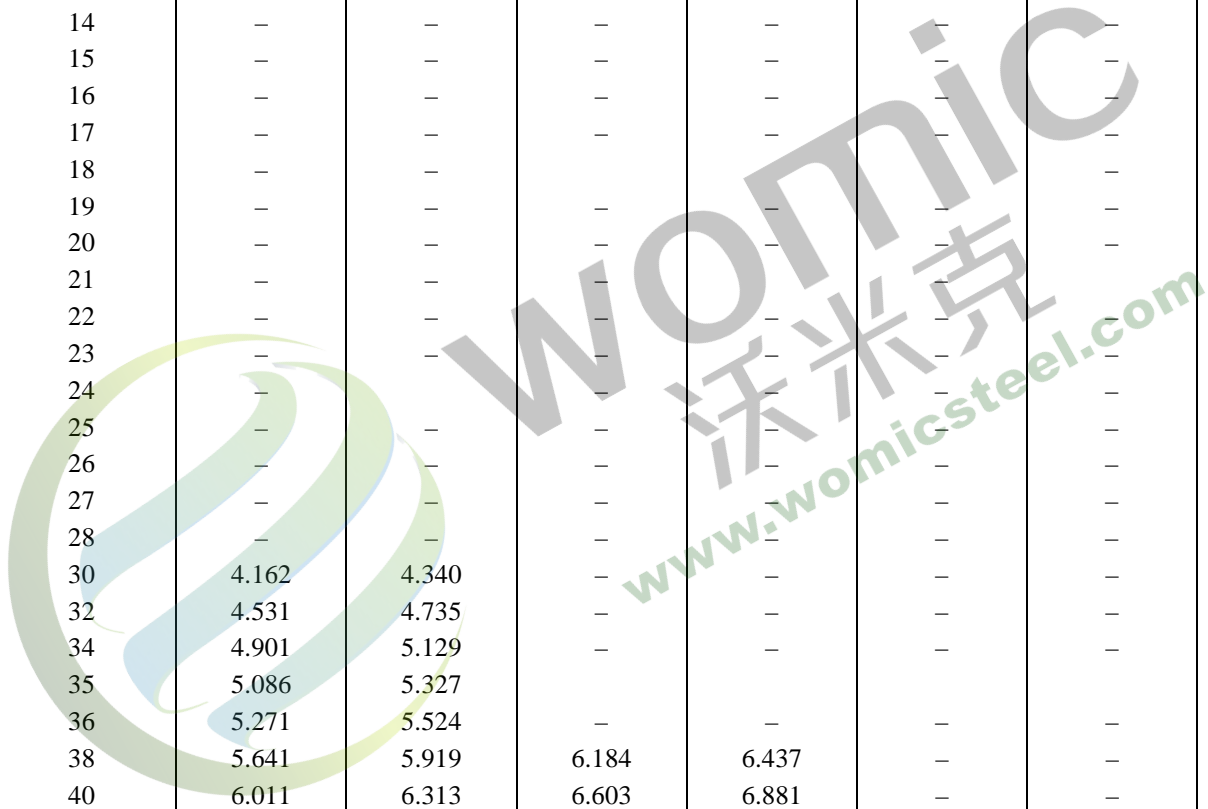
Table 1 (cont.)

| with wall thickness of, mm |       |       |       |       |       |
|----------------------------|-------|-------|-------|-------|-------|
| 4.5                        | 5.0   | 5.5   | 6.0   | 6.5   | 7.0   |
| <b>thick-walled</b>        |       |       |       |       |       |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| -                          | -     | -     | -     | -     | -     |
| 1.276                      | 1.356 | -     | -     | -     | -     |
| 1.387                      | 1.480 | -     | -     | -     | -     |
| 1.498                      | 1.603 | -     | -     | -     | -     |
| 1.609                      | 1.726 | -     | -     | -     | -     |
| 1.720                      | 1.850 | 1.967 | 2.072 | -     | -     |
| 1.831                      | 1.973 | 2.102 | 2.220 | -     | -     |
| 1.942                      | 2.096 | 2.238 | 2.368 | -     | -     |
| 2.053                      | 2.220 | 2.374 | 2.515 | -     | -     |
| 2.164                      | 2.343 | 2.509 | 2.663 | 2.805 | -     |
| 2.275                      | 2.466 | 2.645 | 2.811 | 2.965 | 3.107 |
| 2.386                      | 2.589 | 2.781 | 2.959 | 3.125 | 3.280 |
| 2.497                      | 2.713 | 2.916 | 3.107 | 3.286 | 3.453 |
| 2.608                      | 2.836 | 3.052 | 3.255 | 3.446 | 3.625 |
| 2.830                      | 3.083 | 3.323 | 3.551 | 3.767 | 3.971 |
| 3.052                      | 3.329 | 3.594 | 3.847 | 4.087 | 4.316 |
| 3.274                      | 3.576 | 3.866 | 4.143 | 4.408 | 4.661 |
| 3.385                      | 3.699 | 4.001 | 4.291 | 4.568 | 4.834 |
| 3.496                      | 3.822 | 4.137 | 4.439 | 4.728 | 5.006 |
| 3.718                      | 4.069 | 4.408 | 4.735 | 5.049 | 5.352 |
| 3.940                      | 4.316 | 4.680 | 5.031 | 5.369 | 5.697 |

p. 6 GOST 8734-75

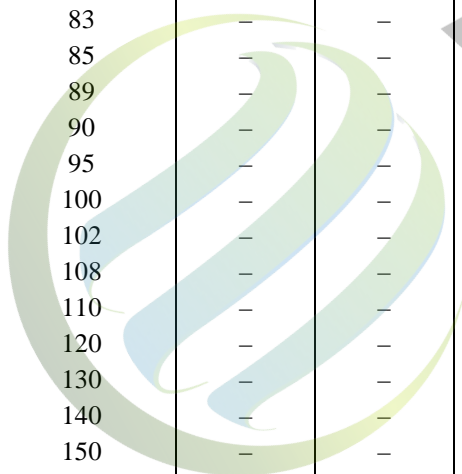
| External diameter, mm | Estimated weight of 1 m of pipe, kg, |       |       |       |     |    |
|-----------------------|--------------------------------------|-------|-------|-------|-----|----|
|                       | 7.5                                  | 8.0   | 8.5   | 8.0   | 9.5 | 10 |
|                       | <b>Extra thick-walled</b>            |       |       |       |     |    |
| 5                     | -                                    | -     | -     | -     | -   | -  |
| 6                     | -                                    | -     | -     | -     | -   | -  |
| 7                     | -                                    | -     | -     | -     | -   | -  |
| 8                     | -                                    | -     | -     | -     | -   | -  |
| 9                     | -                                    | -     | -     | -     | -   | -  |
| 10                    | -                                    | -     | -     | -     | -   | -  |
| 11                    | -                                    | -     | -     | -     | -   | -  |
| 12                    | -                                    | -     | -     | -     | -   | -  |
| 13                    | -                                    | -     | -     | -     | -   | -  |
| 14                    | -                                    | -     | -     | -     | -   | -  |
| 15                    | -                                    | -     | -     | -     | -   | -  |
| 16                    | -                                    | -     | -     | -     | -   | -  |
| 17                    | -                                    | -     | -     | -     | -   | -  |
| 18                    | -                                    | -     | -     | -     | -   | -  |
| 19                    | -                                    | -     | -     | -     | -   | -  |
| 20                    | -                                    | -     | -     | -     | -   | -  |
| 21                    | -                                    | -     | -     | -     | -   | -  |
| 22                    | -                                    | -     | -     | -     | -   | -  |
| 23                    | -                                    | -     | -     | -     | -   | -  |
| 24                    | -                                    | -     | -     | -     | -   | -  |
| 25                    | -                                    | -     | -     | -     | -   | -  |
| 26                    | -                                    | -     | -     | -     | -   | -  |
| 27                    | -                                    | -     | -     | -     | -   | -  |
| 28                    | -                                    | -     | -     | -     | -   | -  |
| 30                    | 4.162                                | 4.340 | -     | -     | -   | -  |
| 32                    | 4.531                                | 4.735 | -     | -     | -   | -  |
| 34                    | 4.901                                | 5.129 | -     | -     | -   | -  |
| 35                    | 5.086                                | 5.327 | -     | -     | -   | -  |
| 36                    | 5.271                                | 5.524 | -     | -     | -   | -  |
| 38                    | 5.641                                | 5.919 | 6.184 | 6.437 | -   | -  |
| 40                    | 6.011                                | 6.313 | 6.603 | 6.881 | -   | -  |

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| External diameter, mm | Estimated weight f 1 m of pipe, kg |     |     |     |     |       |       |                    |
|-----------------------|------------------------------------|-----|-----|-----|-----|-------|-------|--------------------|
|                       | 0.3                                | 0.4 | 0.5 | 0.6 | 0.8 | 1.0   | 1.2   |                    |
|                       | <b>Extra thin-walled</b>           |     |     |     |     |       |       | <b>Thin-walled</b> |
| 42                    | –                                  | –   | –   | –   | –   | 1.011 | 1.207 |                    |
| 45                    | –                                  | –   | –   | –   | –   | 1.085 | 1.296 |                    |
| 48                    | –                                  | –   | –   | –   | –   | 1.159 | 1.385 |                    |
| 50                    | –                                  | –   | –   | –   | –   | 1.208 | 1.444 |                    |
| 51                    | –                                  | –   | –   | –   | –   | 1.233 | 1.474 |                    |
| 53                    | –                                  | –   | –   | –   | –   | 1.282 | 1.533 |                    |
| 54                    | –                                  | –   | –   | –   | –   | 1.307 | 1.563 |                    |
| 56                    | –                                  | –   | –   | –   | –   | 1.356 | 1.622 |                    |
| 57                    | –                                  | –   | –   | –   | –   | 1.381 | 1.651 |                    |
| 60                    | –                                  | –   | –   | –   | –   | 1.455 | 1.740 |                    |
| 63                    | –                                  | –   | –   | –   | –   | 1.529 | 1.829 |                    |
| 65                    | –                                  | –   | –   | –   | –   | 1.578 | 1.888 |                    |
| 68                    | –                                  | –   | –   | –   | –   | 1.652 | 1.977 |                    |
| 70                    | –                                  | –   | –   | –   | –   | 1.702 | 2.036 |                    |
| 73                    | –                                  | –   | –   | –   | –   | 1.776 | 2.125 |                    |
| 75                    | –                                  | –   | –   | –   | –   | 1.825 | 2.184 |                    |
| 76                    | –                                  | –   | –   | –   | –   | 1.850 | 2.214 |                    |
| 80                    | –                                  | –   | –   | –   | –   | –     | 2.331 |                    |
| 83                    | –                                  | –   | –   | –   | –   | –     | 2.420 |                    |
| 85                    | –                                  | –   | –   | –   | –   | –     | 2.480 |                    |
| 89                    | –                                  | –   | –   | –   | –   | –     | 2.598 |                    |
| 90                    | –                                  | –   | –   | –   | –   | –     | 2.628 |                    |
| 95                    | –                                  | –   | –   | –   | –   | –     | 2.776 |                    |
| 100                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 102                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 108                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 110                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 120                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 130                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 140                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 150                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 160                   | –                                  | –   | –   | –   | –   | –     | –     |                    |
| 170                   | –                                  | –   | –   | –   | –   | –     | –     |                    |



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Table 1 (cont.)

with wall thickness of, mm

| 1.4                | 1.5   | 1.6   | 1.8   | 2.0   | 2.2   | 2.5    |
|--------------------|-------|-------|-------|-------|-------|--------|
| <b>Thin-walled</b> |       |       |       |       |       |        |
| 1.402              | 1.498 | 1.594 | 1.785 | 1.973 | 2.159 | 2.435  |
| 1.505              | 1.609 | 1.712 | 1.918 | 2.121 | 2.322 | 2.620  |
| 1.609              | 1.720 | 1.831 | 2.051 | 2.269 | 2.435 | 2.805  |
| 1.678              | 1.794 | 1.910 | 2.140 | 2.368 | 2.594 | 2.929  |
| 1.712              | 1.831 | 1.949 | 2.184 | 2.417 | 2.648 | 2.990  |
| 1.782              | 1.905 | 2.028 | 2.273 | 2.515 | 2.756 | 3.114  |
| 1.816              | 1.942 | 2.068 | 2.317 | 2.565 | 2.810 | 3.175  |
| 1.885              | 2.016 | 2.147 | 2.406 | 2.663 | 2.919 | 3.298  |
| 1.920              | 2.053 | 2.186 | 2.450 | 2.713 | 2.973 | 3.360  |
| 2.023              | 2.164 | 2.304 | 2.584 | 2.861 | 3.136 | 3.545  |
| 2.127              | 2.275 | 2.423 | 2.717 | 3.009 | 3.499 | 3.730  |
| 2.196              | 2.349 | 2.502 | 2.806 | 3.107 | 3.407 | 3.853  |
| 2.299              | 2.460 | 2.620 | 2.939 | 3.255 | 3.570 | 4.038  |
| 2.368              | 2.534 | 2.699 | 3.027 | 3.354 | 3.673 | 4.162  |
| 2.472              | 2.645 | 2.817 | 3.161 | 3.502 | 3.841 | 4.347  |
| 2.541              | 2.719 | 2.896 | 3.249 | 3.601 | 3.930 | 4.470  |
| 2.576              | 2.756 | 2.936 | 3.294 | 3.650 | 4.004 | 4.532  |
| 2.714              | 2.904 | 3.094 | 2.471 | 3.847 | 4.221 | 4.778  |
| 2.817              | 3.015 | 3.212 | 3.605 | 3.995 | 4.383 | 4.963  |
| 2.886              | 3.089 | 3.291 | 3.693 | 4.094 | 4.492 | 5.086  |
| 3.024              | 3.237 | 3.449 | 3.871 | 4.291 | 4.709 | 5.333  |
| 3.059              | 3.274 | 3.488 | 3.915 | 4.340 | 4.763 | 5.395  |
| 3.232              | 3.459 | 3.685 | 4.137 | 4.587 | 5.034 | 5.703  |
| —                  | 3.644 | 3.883 | 4.359 | 4.834 | 5.306 | 6.011  |
| —                  | 3.718 | 3.962 | 4.448 | 4.933 | 5.414 | 6.135  |
| —                  | 3.940 | 4.198 | 4.714 | 5.228 | 5.740 | 6.504  |
| —                  | 4.014 | 4.277 | 4.803 | 5.327 | 6.849 | 6.628  |
| —                  | 4.384 | 4.672 | 5.247 | 5.820 | 6.391 | 7.244  |
| —                  | 4.754 | 5.066 | 5.691 | 6.313 | 6.934 | 7.861  |
| —                  | —     | 5.461 | 6.135 | 6.807 | 7.476 | 8.477  |
| —                  | —     | —     | 6.579 | 7.300 | 8.019 | 9.094  |
| —                  | —     | —     | —     | 7.793 | 8.561 | 9.710  |
| —                  | —     | —     | —     | 8.286 | 9.104 | 10.327 |

p. 10 GOST 8734-75

| External diameter, mm | Estimated weight of 1 m of pipe, kg |                    |        |        |                     |  |
|-----------------------|-------------------------------------|--------------------|--------|--------|---------------------|--|
|                       | 2.8                                 | 3.0                | 3.2    | 3.5    | 4.0                 |  |
|                       |                                     | <b>Thin-walled</b> |        |        | <b>Thick-walled</b> |  |
| 42                    | 2.707                               | 2.885              | 3.062  | 3.323  | 3.749               |  |
| 45                    | 2.914                               | 3.107              | 3.299  | 3.582  | 4.044               |  |
| 48                    | 3.121                               | 3.329              | 3.535  | 3.841  | 4.340               |  |
| 50                    | 3.259                               | 3.477              | 3.693  | 4.014  | 4.538               |  |
| 51                    | 3.328                               | 3.551              | 3.772  | 4.100  | 4.636               |  |
| 53                    | 3.466                               | 3.699              | 3.930  | 4.273  | 4.834               |  |
| 54                    | 3.535                               | 3.773              | 4.009  | 4.359  | 4.932               |  |
| 56                    | 3.674                               | 3.921              | 4.167  | 4.532  | 5.130               |  |
| 57                    | 3.743                               | 3.995              | 4.246  | 4.618  | 5.228               |  |
| 60                    | 3.950                               | 4.217              | 4.482  | 4.877  | 5.524               |  |
| 63                    | 4.157                               | 4.439              | 4.719  | 5.136  | 5.820               |  |
| 65                    | 4.295                               | 4.587              | 4.877  | 5.308  | 6.017               |  |
| 68                    | 4.502                               | 4.809              | 5.113  | 5.567  | 6.313               |  |
| 70                    | 4.640                               | 4.957              | 5.271  | 5.740  | 6.511               |  |
| 73                    | 4.847                               | 5.179              | 5.508  | 5.999  | 6.807               |  |
| 75                    | 4.986                               | 5.327              | 5.666  | 6.172  | 7.004               |  |
| 76                    | 5.055                               | 5.401              | 5.745  | 6.258  | 7.103               |  |
| 80                    | 5.331                               | 5.697              | 6.060  | 6.603  | 7.497               |  |
| 83                    | 5.538                               | 5.919              | 6.298  | 6.862  | 7.793               |  |
| 85                    | 5.676                               | 6.067              | 6.455  | 7.035  | 7.990               |  |
| 89                    | 5.952                               | 6.363              | 6.771  | 7.380  | 8.385               |  |
| 90                    | 6.021                               | 6.437              | 6.850  | 7.466  | 8.484               |  |
| 95                    | 6.367                               | 6.867              | 7.244  | 7.898  | 8.977               |  |
| 100                   | 6.712                               | 7.176              | 7.639  | 8.329  | 9.470               |  |
| 102                   | 6.850                               | 7.324              | 7.797  | 8.502  | 9.667               |  |
| 108                   | 7.264                               | 7.768              | 8.270  | 9.020  | 10.259              |  |
| 110                   | 7.402                               | 7.916              | 9.428  | 9.193  | 10.456              |  |
| 120                   | 8.093                               | 8.656              | 9.217  | 10.056 | 11.443              |  |
| 130                   | 8.783                               | 9.396              | 10.007 | 10.919 | 12.429              |  |
| 140                   | 9.474                               | 10.136             | 10.796 | 11.782 | 13.416              |  |
| 150                   | 10.164                              | 10.876             | 11.584 | 12.645 | 14.402              |  |
| 160                   | 10.855                              | 11.616             | 12.374 | 13.508 | 15.389              |  |
| 170                   | 11.546                              | 12.355             | 13.163 | 14.371 | 16.375              |  |

Extra thin-walled

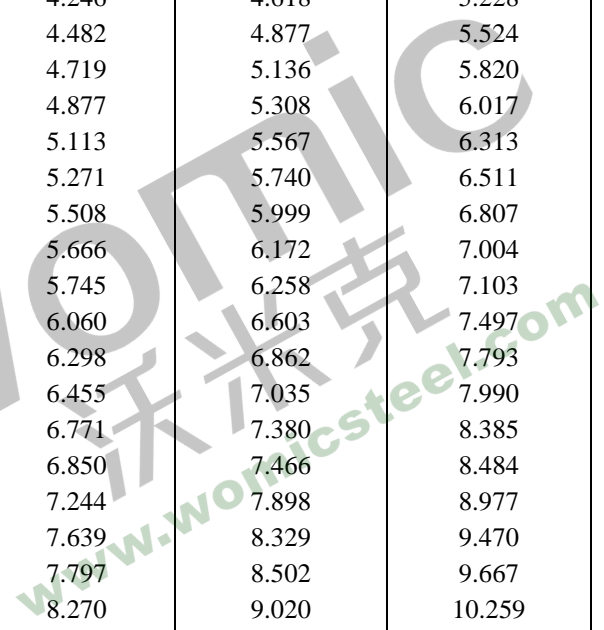


Table 1 (cont.)

| with wall thickness of, mm |        |        |        |        |        |
|----------------------------|--------|--------|--------|--------|--------|
| 4.5                        | 5.0    | 5.5    | 6.0    | 6.5    | 7.0    |
| <b>Thick-walled</b>        |        |        |        |        |        |
| 4.162                      | 4.562  | 4.951  | 5.327  | 5.690  | 6.042  |
| 4.495                      | 4.932  | 5.358  | 5.771  | 6.171  | 6.560  |
| 4.827                      | 5.302  | 5.765  | 6.215  | 6.652  | 7.078  |
| 5.049                      | 5.549  | 6.036  | 6.511  | 6.972  | 7.423  |
| 5.160                      | 5.672  | 6.172  | 6.659  | 7.132  | 7.596  |
| 5.382                      | 5.919  | 6.443  | 6.955  | 7.453  | 7.941  |
| 5.493                      | 6.042  | 6.578  | 7.103  | 7.613  | 8.114  |
| 5.715                      | 6.289  | 6.850  | 7.398  | 7.934  | 8.459  |
| 5.826                      | 6.412  | 6.985  | 7.546  | 8.095  | 8.632  |
| 6.159                      | 6.782  | 7.392  | 7.990  | 8.575  | 9.149  |
| 6.492                      | 7.152  | 7.799  | 8.434  | 9.056  | 9.667  |
| 6.714                      | 7.398  | 8.070  | 8.730  | 9.377  | 10.013 |
| 7.047                      | 7.768  | 8.477  | 9.174  | 9.857  | 10.530 |
| 7.269                      | 8.015  | 8.749  | 9.470  | 10.178 | 10.876 |
| 7.602                      | 8.385  | 9.156  | 9.914  | 10.659 | 11.394 |
| 7.824                      | 8.631  | 9.427  | 10.210 | 10.980 | 11.739 |
| 7.935                      | 8.755  | 9.562  | 10.358 | 11.140 | 11.911 |
| 8.379                      | 9.248  | 10.105 | 10.950 | 11.781 | 12.602 |
| 8.712                      | 9.618  | 10.512 | 11.394 | 12.263 | 13.120 |
| 8.934                      | 9.865  | 10.783 | 11.690 | 12.584 | 13.465 |
| 9.378                      | 10.358 | 11.326 | 12.281 | 13.225 | 14.156 |
| 9.489                      | 10.481 | 11.461 | 12.429 | 13.385 | 14.328 |
| 10.043                     | 11.098 | 12.140 | 13.169 | 14.187 | 15.191 |
| 10.598                     | 11.714 | 12.818 | 13.909 | 14.988 | 16.055 |
| 10.820                     | 11.961 | 13.089 | 14.205 | 15.308 | 16.400 |
| 11.486                     | 12.701 | 13.903 | 15.093 | 16.269 | 17.436 |
| 11.708                     | 12.947 | 14.174 | 15.389 | 16.590 | 17.781 |
| 12.818                     | 14.180 | 15.531 | 16.868 | 18.193 | 19.507 |
| 13.928                     | 15.413 | 16.887 | 18.348 | 19.796 | 21.233 |
| 15.037                     | 16.646 | 18.243 | 19.828 | 21.400 | 22.960 |
| 16.147                     | 17.880 | 19.600 | 21.308 | 23.003 | 24.686 |
| 17.257                     | 19.113 | 20.956 | 22.787 | 24.606 | 26.412 |
| 18.367                     | 20.346 | 22.312 | 24.267 | 26.209 | 28.139 |

p. 12 GOST 8734-75

| External diameter,<br>mm | Estimated weight of 1 m of pipe, kg |        |        |        |        |        |
|--------------------------|-------------------------------------|--------|--------|--------|--------|--------|
|                          | 7.5                                 | 8.0    | 8.5    | 9.0    | 9.5    | 10     |
|                          | <b>Extra thick-walled</b>           |        |        |        |        |        |
| 42                       | 6.381                               | 6.708  | 7.023  | 7.324  | –      | –      |
| 45                       | 6.936                               | 7.300  | 7.651  | 7.990  | 8.317  | 8.632  |
| 48                       | 7.491                               | 7.892  | 8.280  | 8.656  | 9.020  | 9.371  |
| 50                       | 7.861                               | 8.286  | 8.699  | 9.110  | 9.489  | 9.865  |
| 51                       | 8.046                               | 8.484  | 8.909  | 9.322  | 9.723  | 10.111 |
| 53                       | 8.416                               | 8.878  | 9.328  | 9.766  | 10.191 | 10.604 |
| 54                       | 8.601                               | 9.075  | 9.538  | 9.988  | 10.426 | 10.851 |
| 56                       | 8.971                               | 9.470  | 9.957  | 10.432 | 10.894 | 11.345 |
| 57                       | 9.156                               | 9.667  | 10.167 | 10.654 | 11.128 | 11.591 |
| 60                       | 9.710                               | 10.259 | 10.796 | 11.320 | 11.831 | 12.331 |
| 63                       | 10.265                              | 10.851 | 11.424 | 11.985 | 12.534 | 13.070 |
| 65                       | 10.635                              | 11.246 | 11.844 | 12.429 | 13.003 | 13.564 |
| 68                       | 11.190                              | 11.838 | 12.473 | 13.095 | 13.706 | 14.304 |
| 70                       | 11.560                              | 12.232 | 12.892 | 13.539 | 14.174 | 14.797 |
| 73                       | 12.115                              | 12.824 | 13.521 | 14.205 | 14.877 | 15.537 |
| 75                       | 12.485                              | 13.219 | 13.940 | 14.649 | 15.345 | 16.030 |
| 76                       | 12.670                              | 13.416 | 14.150 | 14.871 | 15.580 | 16.276 |
| 80                       | 13.410                              | 14.205 | 14.988 | 15.759 | 16.517 | 17.263 |
| 83                       | 13.965                              | 14.797 | 15.617 | 16.425 | 17.220 | 18.003 |
| 85                       | 14.334                              | 15.191 | 16.036 | 16.868 | 17.688 | 18.496 |
| 89                       | 15.074                              | 15.981 | 16.875 | 17.756 | 18.626 | 19.483 |
| 90                       | 15.259                              | 16.178 | 17.084 | 17.978 | 18.860 | 19.729 |
| 95                       | 16.184                              | 17.164 | 18.132 | 19.088 | 20.031 | 20.962 |
| 100                      | 17.109                              | 18.151 | 19.180 | 20.198 | 21.203 | 22.192 |
| 102                      | 17.479                              | 18.545 | 19.600 | 20.642 | 21.671 | 22.689 |
| 108                      | 18.589                              | 19.729 | 20.857 | 21.973 | 23.077 | 24.168 |
| 110                      | 18.959                              | 20.124 | 21.277 | 22.417 | 23.546 | 24.662 |
| 120                      | 20.808                              | 22.097 | 23.373 | 24.637 | 25.888 | 27.128 |
| 130                      | 22.658                              | 24.070 | 25.469 | 26.856 | 28.231 | 29.504 |
| 140                      | 24.507                              | 26.043 | 27.565 | 29.076 | 30.574 | 32.060 |
| 150                      | 26.357                              | 28.016 | 29.662 | 31.295 | 32.917 | 34.526 |
| 160                      | 28.207                              | 29.988 | 31.758 | 33.515 | 35.260 | 36.992 |
| 170                      | 30.056                              | 31.961 | 33.854 | 35.733 | 37.603 | 39.458 |

Table 1 (cont.)

with wall thickness of, mm

| 11                        | 12     | 14     | 16     | 18     | 20     | 22     | 24     |
|---------------------------|--------|--------|--------|--------|--------|--------|--------|
| <b>Extra thick-walled</b> |        |        |        |        |        |        |        |
| –                         | –      | –      | –      | –      | –      | –      | –      |
| –                         | –      | –      | –      | –      | –      | –      | –      |
| –                         | –      | –      | –      | –      | –      | –      | –      |
| 10.580                    | 11.246 | –      | –      | –      | –      | –      | –      |
| 10.851                    | 11.542 | –      | –      | –      | –      | –      | –      |
| 11.394                    | 12.133 | –      | –      | –      | –      | –      | –      |
| 11.665                    | 12.429 | –      | –      | –      | –      | –      | –      |
| 12.207                    | 13.021 | –      | –      | –      | –      | –      | –      |
| 12.479                    | 13.317 | –      | –      | –      | –      | –      | –      |
| 13.293                    | 14.205 | –      | –      | –      | –      | –      | –      |
| 14.106                    | 15.093 | –      | –      | –      | –      | –      | –      |
| 14.649                    | 15.685 | –      | –      | –      | –      | –      | –      |
| 15.463                    | 16.573 | –      | –      | –      | –      | –      | –      |
| 16.005                    | 17.164 | –      | –      | –      | –      | –      | –      |
| 16.819                    | 18.052 | –      | –      | –      | –      | –      | –      |
| 17.362                    | 18.644 | –      | –      | –      | –      | –      | –      |
| 17.633                    | 18.940 | –      | –      | –      | –      | –      | –      |
| 18.718                    | 20.124 | –      | –      | –      | –      | –      | –      |
| 19.532                    | 21.012 | –      | –      | –      | –      | –      | –      |
| 20.074                    | 21.603 | –      | –      | –      | –      | –      | –      |
| 21.160                    | 22.787 | –      | –      | –      | –      | –      | –      |
| 21.431                    | 23.083 | –      | –      | –      | –      | –      | –      |
| 22.787                    | 24.563 | –      | –      | –      | –      | –      | –      |
| 24.144                    | 26.043 | 29.692 | 33.145 | 36.400 | –      | –      | –      |
| 24.686                    | 26.634 | 30.383 | 33.934 | 37.288 | –      | –      | –      |
| 26.314                    | 28.410 | 32.455 | 36.302 | 39.952 | –      | –      | –      |
| 26.856                    | 29.002 | 33.145 | 37.091 | 40.839 | 44.39  | 47.745 | –      |
| 29.569                    | 31.961 | 36.598 | 41.037 | 45.278 | 49.323 | 53.170 | –      |
| 32.282                    | 34.921 | 40.050 | 44.983 | 49.718 | 54.255 | 58.596 | –      |
| 34.995                    | 37.880 | 43.503 | 48.928 | 54.157 | 59.188 | 64.021 | –      |
| 37.707                    | 40.839 | 46.955 | 52.874 | 58.596 | 64.120 | 69.447 | –      |
| 40.420                    | 43.799 | 50.408 | 56.820 | 63.035 | 69.052 | 74.872 | –      |
| 43.133                    | 46.758 | 53.861 | 60.766 | 67.174 | 73.984 | 80.298 | 86.414 |

| External diameter, mm    | Estimated weight of 1 m of pipe, kg |     |     |     |     |     |     |
|--------------------------|-------------------------------------|-----|-----|-----|-----|-----|-----|
|                          | 0.3                                 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 |
| <b>Extra thin-walled</b> |                                     |     |     |     |     |     |     |
| 180                      | -                                   | -   | -   | -   | -   | -   | -   |
| 190                      | -                                   | -   | -   | -   | -   | -   | -   |
| 200                      | -                                   | -   | -   | -   | -   | -   | -   |
| 210                      | -                                   | -   | -   | -   | -   | -   | -   |
| 220                      | -                                   | -   | -   | -   | -   | -   | -   |
| 240                      | -                                   | -   | -   | -   | -   | -   | -   |
| 250                      | -                                   | -   | -   | -   | -   | -   | -   |

| External diameter, mm    | Estimated weight of 1 m of pipe, kg |        |        |        |        |
|--------------------------|-------------------------------------|--------|--------|--------|--------|
|                          | 2.8                                 | 9.0    | 3.2    | 3.0    | 4.0    |
| <b>Extra thin-walled</b> |                                     |        |        |        |        |
| 180                      | 12.236                              | 13.095 | 13.952 | 15.235 | 17.362 |
| 190                      | 12.927                              | 13.835 | 14.742 | 16.098 | 18.348 |
| 200                      | -                                   | 14.575 | 15.531 | 16.961 | 19.335 |
| 210                      | -                                   | 15.315 | 16.320 | 17.824 | 20.321 |
| 220                      | -                                   | 16.055 | 17.109 | 18.687 | 21.308 |
| 240                      | -                                   | -      | -      | -      | -      |
| 250                      | -                                   | -      | -      | -      | -      |

| External diameter, mm | Estimated weight of 1 m of pipe, kg |        |        |        |        |        |
|-----------------------|-------------------------------------|--------|--------|--------|--------|--------|
|                       | 7.5                                 | 8.0    | 8.6    | 9.0    | 9.5    | 10     |
| <b>Thin-walled</b>    |                                     |        |        |        |        |        |
| 180                   | 31.906                              | 33.934 | 35.950 | 37.954 | 39.945 | 41.925 |
| 190                   | 33.755                              | 35.907 | 38.046 | 40.174 | 42.283 | 44.391 |
| 200                   | 35.605                              | 37.880 | 40.143 | 42.393 | 44.631 | 46.857 |
| 210                   | 37.455                              | 39.853 | 42.239 | 44.613 | 46.974 | 49.323 |
| 220                   | 39.304                              | 41.826 | 44.335 | 46.832 | 49.317 | 51.789 |
| 240                   | 43.003                              | 45.772 | 48.528 | 51.271 | 54.002 | 56.721 |
| 250                   | 44.853                              | 47.744 | 50.624 | 53.491 | 56.345 | 59.188 |

Notes:

1. Estimated weight of a 1 m length of pipe shall be calculated in kilograms using the formula:  
 $M=0.02466148 \times s (De-s)$ ,

where M – weight, kg, De is the external diameter, mm; s is the wall thickness, mm,

Steel density of 7.85 g/cm<sup>3</sup> shall be accepted as a reference value during determination of the estimated weight of 1 m of the pipe.

2. Production of pipes 4 mm in diameter with walls from 2.0 to 20 mm thick, and with the following dimensions: 29 × 5.5; 32 × 8.5; 33 × 1.5; 33 × 8.0; 39 × 3.0; 41 × 5.5; 43 × 8.0; 44 × 3.0; 46 × 6.0; 46 × 6.0; 55 × 9.0; 58 × 4.0, and 84 × 8.0 mm shall be allowed at the customer's request.

3. Pipes over 100 mm in diameter with the ratio De/s over 50 and pipes with lower De/s ratio which are delivered, shall be in accordance with specifications agreed with the customer.

**(Amended Wording – “Standards Detail Index” No. 9 1978).**

Table 1 (cont.)

| with wall thickness of, mm |     |     |     |       |       |        |
|----------------------------|-----|-----|-----|-------|-------|--------|
| 1.4                        | 1.5 | 1.6 | 1.8 | 2.0   | 2.2   | 2.5    |
| <b>Thin-walled</b>         |     |     |     |       |       |        |
| –                          | –   | –   | –   | 8.779 | 9.647 | 10.944 |
| –                          | –   | –   | –   | –     | –     | –      |
| –                          | –   | –   | –   | –     | –     | –      |
| –                          | –   | –   | –   | –     | –     | –      |
| –                          | –   | –   | –   | –     | –     | –      |

(cont.)

with wall thickness, mm

| 4.5                | 5.0    | 5.5    | 6.0    | 6.5    | 7.0    |
|--------------------|--------|--------|--------|--------|--------|
| <b>Thin-walled</b> |        |        |        |        |        |
| 19.476             | 21.579 | 23.669 | 25.747 | 27.812 | 29.865 |
| 20.586             | 22.812 | 25.025 | 27.226 | 29.415 | 31.591 |
| 21.696             | 24.045 | 26.382 | 28.706 | 31.018 | 33.318 |
| 22.806             | 25.278 | 27.738 | 30.186 | 32.621 | 35.044 |
| 23.915             | 26.511 | 29.094 | 31.665 | 34.224 | 36.770 |
| 26.1336            | 28.977 | 31.807 | 34.625 | 37.430 | 40.223 |
| 27.244             | 30.210 | 33.164 | 36.104 | 39.033 | 41.949 |

(cont.)

with wall thickness of, mm

| 11                 | 12     | 14     | 16     | 18                  | 20      | 22       | 24      |
|--------------------|--------|--------|--------|---------------------|---------|----------|---------|
| <b>Thin-walled</b> |        |        |        | <b>Thick-walled</b> |         |          |         |
| 45.846             | 49.718 | 57.313 | 64.712 | 74.913              | 78.917  | 85.723   | 92.333  |
| 48.558             | 52.677 | 60.766 | 68.658 | 76.352              | 83.849  | 91.149   | 98.251  |
| 51.271             | 55.636 | 64.218 | 72.603 | 80.791              | 88.781  | 96.574   | 104.170 |
| 53.984             | 58.596 | 67.671 | 76.549 | 85.230              | 93.714  | 102.000  | 110.089 |
| 56.697             | 61.555 | 71.124 | 80.495 | 89.669              | 98.646  | 1107.425 | 116.008 |
| 62.122             | 67.474 | 78.029 | 88.387 | 98.547              | 108.511 | 118.276  | 127.845 |
| 64.835             | 70.433 | 81.481 | 92.333 | 102.986             | 113.443 | 123.702  | 133.764 |

**p. 16 GOST 8734–755**

By the agreement between the customer and the manufacturer pipes may be produced with combined maximum deviations, for example, of increased accuracy in accordance with GOST 9567–75 for the external diameter, and of standard accuracy for the wall thickness, or with unilateral allowance for the dimensions. The value of the estimated weight shall be calculated as the mean arithmetic average of the sum of positive and negative maximum deviations stipulated in table 2.

Table 2

| Pipe dimensions                                   | Maximum deviations |
|---|--------------------|
| External diameter, mm:                            |                    |
| from 5 to 10 inclusive                            | ±0.15 mm           |
| over 10 to 30 inclusive                           | ±0.30 mm           |
| over 30 to 50 inclusive                           | ±0.40 mm           |
| over 50   | ±0.8%              |
| Wall thickness, mm:                               |                    |
| up to 1   | ±0.12 mm           |
| over 1 to 5 inclusive                             | ±10%               |
| over 1 to 2.5 with the diameter of 110 mm or more | ±12.5%             |
| over 5  | ±8%                |

6. External diameter and wall thickness shall be taken into account during production of pipes. External diameter and wall thickness, as well as external and internal diameters and variation in wall thickness shall be taken into account during production of pipes at the customer's request.

Maximum deviations for the internal diameter of the pipes shall not exceed respective maximum deviations of the external diameter.

Maximum deviations for the pipes with external diameters of 10 mm or less shall be established by agreement between the customer and the manufacturer.

7. Ovality and variation in wall thickness of pipes shall not take the dimensions of pipes over the maximum deviations for the external diameter and wall thickness respectively.

8. Curvature of any part of the pipe on 1 m of its length shall not exceed the following values:

- 3 mm – for pipes from 5 to 8 mm in diameter;
- 2 mm – for pipes from 8 to 10 mm in diameter;
- 1.5 mm – for pipes over 10 mm in diameter.

At the customer's request, curvature of pipes 20 to 90 mm in diameter shall not exceed 1 micron on 1 m of its length.

Note. Standards for curvature of the pipes with ratio of external diameter  $D_e$  to the wall thickness  $s$ , equal to 50 or more, produced without heat treatment, shall be established by agreement between the customer and the manufacturer.



9. The material of pipes and their technical requirements shall be in accordance with GOST 8733–74.

Examples of conventional designations:

A pipe with an external diameter of 70 mm, 2.0 mm thick wall, length multiple of 1 250 mm, from steel of grade 20, group Б chemical composition, in accordance with GOST 8733–74:

$$\text{Труба} \frac{70 \times 2120 \text{ кр } \text{ГОСТ } 8734 - 75}{\text{Б } 20 \text{ ГОСТ } 8733 - 74}$$

As above, 6 000 mm long (standard length), from steel of grade 20, group В mechanical properties and chemical composition, in accordance with group GOST 8733–74:

$$\text{Труба} \frac{70 \times 6000 \text{ ГОСТ } 8734 - 75}{\text{В } 20 \text{ ГОСТ } 8733 - 74}$$

As above, with combined maximum deviations (with the diameter of increased accuracy in accordance with GOST 9567–75, with wall of standard accuracy):

$$\text{Труба} \frac{70n \times 6000 \text{ кр } \text{ГОСТ } 8734 - 75}{\text{В } 20 \text{ ГОСТ } 8733 - 74}$$

As above, non–standard length, delivered with non–standardized mechanical properties and chemical composition, but with the indication of the values of hydraulic pressure) (in accordance with group Д) GOST 8733–74:

$$\text{Труба} \frac{70 \times 2 \text{ ГОСТ } 8734 - 75}{\text{Д } \text{ГОСТ } 8733 - 74}$$

As above, from steel of grade 10, delivered with mechanical properties being inspected by comparison with standard heat treated samples, and with the chemical composition (in accordance with group Г) GOST 8733–74:

$$\text{Труба} \frac{70 \times 2 \text{ ГОСТ } 8734 - 75}{\text{Г } 10 \text{ ГОСТ } 8733 - 74}$$

Pipe with internal diameter of 70 mm and 2.5 mm thick wall, of non–standard length, from steel of grade 40X, delivered in accordance with group В in accordance with GOST 8733–74:

$$\text{Труба} \frac{D_{BH} 70 \times 2.5 \text{ ГОСТ } 8734 - 75}{\text{В } 40 \text{ X } \text{ГОСТ } 8733 - 74}$$

**Amendment No. 2 GOST 8734–75 Seamless Cold–Formed Steel Pipes. Range of sizes**

**Date of introduction set by Decree No. 5143, dated 27.11.81 of the USSR State Committee for Standards**

**from 01.12.81**

The codes “OKP 13 4400, 13 5100” shall be put under the title of this Standard.

The designation “(CMEA Standard 1483–78)” shall be added to the cover sheet and to the first page.

Clause 1a shall be added to this Standard before clause 1:

“1a. This Standard fully complies with CMEA Standard 1483–78.”

Clause 4. Table 2. Standards: “from 5 to 10 mm” shall be replaced with “from 4 to 10 mm”;  $\pm 12.5\%$  shall be replaced with  $\pm 12\%$ .

Clause 5. The text “The value of the unilateral allowance shall not exceed the sum of the bilateral maximum deviations stipulated in table 2” shall be added after the text “unilateral allowance for the dimensions”.

Clause 8. Replace the standard “from 5 to 8 mm” with “from 4 to 8 mm”.

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**Amendment No. 3 GOST 8734–75 Seamless Cold–Formed Steel Pipes. Range of sizes**

**Date of introduction set by Decree No. 8923, dated 29.03.88 of the USSR State Committee for Standards**

**Date of Introduction 01.01.89**

Clause 3. The text “pipes shall be manufactured with standard lengths from 4 to 9 m with maximum deviations for the length of + 10 mm, shall be produced by the order of the foreign trade organizations” shall be added to the third paragraph;

last paragraph. The text: “No more than 5% of pipes of non–standard length no shorter than 2.5 m shall be allowed in each batch of pipes of standard length”.

(IUS No. 6 1988)



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