

Material	TP316L, the chemical compositions in accordance to Table DT-3 ASME BPE
Chemical Composition in weights%	C max. 0.035 Cr = 16.00 – 18.00 Mn max. 2.00 Mo = 2.00 – 3.00 further materials on request
	Ni = 10.00 – 15.00 P max. 0.040 Si max 0.75 S = 0.005 – 0.017
Dimensions	1/4" x 0.035 (6.35 x 0.89 mm) to 6" x 0.109 (152.40 x 2.77 mm)
Technical terms of delivery	According to ASTM A 269 / A 270, DIN EN 10217-7 / DIN EN 10216-5 5900 - 6090 mm (max. 10% short lengths possible) Tube components: Prematerial according to ASTM A 269 / A 270, DIN EN 10217-7 / 10216-5 Machined components: Prematerial according to ASTM A 479, DIN EN 10088-3, DIN 17440 According to ASTM A 269 / A 270 (pharmaceutical tubes) or DIN EN ISO 1127 - D4/T3 Tubes and fittings are prepared for orbital welding
Tolerances Ends	
Tolerances	
Tubes Fittings	According to ASTM A269 and A270, S2 and DIN EN ISO 1127/ D4/T3 According to ASME BPE, section DT
Surface options	
Tubes and fittings	inner surface: As per ASME BPE, section SF, Table SF3 mechanically polished Ra max µin µm SF1 20 0.51 Outer surface: Tubes and Fittings Ra ≤ 0.80 µm (32 µin) mechanically polished and electropolished Ra max µin µm SF4 15 0.38
Inner surface treatment	
Tubes Fittings	Electropolishing procedure Spec. HE 175 4VN Electropolishing procedure Spec. HE 111 4VN
Hardness	max.180 HV 5/90 HRB
Test procedures	<ul style="list-style-type: none"> • Verification of basic test certificate • Verification of dimensions • Visual control • Roughness measurements • Endoscopic inspection of bright finished tubes
Marking	<ul style="list-style-type: none"> - Dockweiler - ASME BPE - Surface symbol as per ASME BPE, section SF - Dockweiler no. (batch no.) - Heat number - Material type - Dimension
Documentation	Certified Test Report (3.1) as per DIN EN 10204 and ASTM A450 for the prematerial
Packaging and Delivery	Ends are closed with PE/PA foils and PE caps. Tubes and fittings are individually sealed in PE foil, marked with a white sticker „Dockweiler BPE“, electropolished parts with white sticker „Dockweiler BPE ep“. Delivery of tubes in tubular container or wooden crate, of fittings in strong cardboard box or wooden crate with shock absorbing filler.