DOCKWEILER
TUBE SYSTEMS IN STAINLESS STEEL

ULTRON

Material	Seamless or welded stainless steel tube, depending on outer diameter (see dimensions). TP316L / 1.4404 / 1.4435
Dimensions	Stock dimensions: Imperial: 1/8″ (3.18 x 0.56 mm)* to 6″ (152.40 x 2.77 mm) Metric: 3.00 x 0.50 mm* to 35.00 x 1.50 mm Further dimensions on demand: ISO: 13.50 x 1.60 mm to 219.10 x 2.60 mm
Technical terms of delivery	
Tubes	According to ASTM A 269 / A 632 / DIN EN 10217-7 / DIN EN 10216-5
Length	5900 - 6090 mm (max. 10% short lengths possible)
Fittings	Tube components: Prematerial according to ASTM A 269 / A 632 / DIN EN 10217-7 / DIN EN 10216-5 Machined components: Prematerial according to ASTM A 479 / EN 10088-3 / DIN 17440
Tolerances	According to ASTM A 269 / A 632 or DIN EN ISO 1127 / D4/T3
Weld ends	Tubes and fittings are prepared for orbital welding
Surface options	
Tubes and Fittings	Inner surface: Ra ≤ 0.13 µm, Ra ≤ 0.18 µm, Ra ≤ 0.25 µm (5 µin, 7 µin, 10 µin) Outer surface: Ra ≤ 0.80 µm (32 µin)
Fittings	Inner and outer surface roughness of the cold worked area is not defined Specified roughness of total surface available on request
Inner surface treatment	
Tubes	Electropolishing procedure Spec. HE 175 8VN
Fittings	Electropolishing procedure Spec. HE 111 8VN
Hardness	Max. 180 HV 5/90 HRB
Test procedures	• Verification of basic test certificate • Verification of dimensions • Visual inspection • Roughness measurements • Conductivity test (DI water) • TOC-measurement of DI water • Particle measurements • REM • XPS/ESCA • Auger analysis (AES) • Endoscopic inspection of welded bright finished tubes before electropolishing
Marking	
Tubes	Permanently marked
Fittings	Needle marking
Information	• Heat number • DOCKWEILER • DW number • Material • Dimensions
Documentation	Inspection certificate (3.1) according to DIN EN 10204 for the prematerial
Packing and delivery	Tubes and fittings filled with N_2 (99.9948%), closed with PA/PE squares and PE caps, bagged in polythene PE (vacuum) with yellow sticker „ULTRON" – double bagged in polythene PE available. Delivery in tubular container or wooden crate, fittings in strong cardboard box with shock absorbing filler.

*For dimensions OD < 5.00 mm roughness is not defined. Length: 2950 ± 50 mm.

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Dockweiler AG
An der Autobahn 10/20 · D-19306 Neustadt-Glewe · Germany · Tel. +49 (0)38757 58-0 · Fax +49 (0)38757 58-222 · e-mail: info@dockweiler.com · www.dockweiler.com