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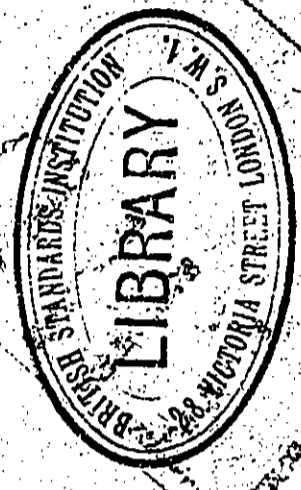
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BRITISH STANDARD 1387 : 1947

*Sup. by 1951 issue*

# STEEL TUBES AND TUBULARS

SUITABLE FOR SCREWING  
TO B.S. 21 PIPE THREADS



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BRITISH STANDARDS INSTITUTION

Incorporated by Royal Charter

28, VICTORIA STREET, LONDON, S.W.1

Telegrams: Standards, Sowest, London Telephone: Abbey 3333

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THE BRITISH STANDARD, having been approved by the Mechanical Engineering Industry Standards Committee and endorsed by the chairman of the Engineering Divisional Council, was published by the authority of the General Council on 11th July 1947

First published (as B.S. 1387), February, 1938.

First revision (as war emergency B.S. 789A), October, 1940.  
Second revision July 1947

The Institution desires to call attention to the fact that this British Standard does not purport to include all the necessary provisions of a contract.

In order to keep abreast of progress in the industries concerned, British Standards are subject to periodic review. Suggestions for improvements will be recorded in due course brought to the notice of the committee charged with the revision of the standards to which they refer.

A complete list of British Standards, numbering over one thousand, indexed and cross-indexed for reference, together with an abstract of each standard will be found in the Institution's Yearbook, price 2s. 0d. post free.

This British Standard requires reference to the following :

B.S. 21 Pipe threads.

B.S. 427 Diamond pyramid hardness numbers

B.S. 729 Testing of the zinc coating on galvanized articles.

*British Standards are revised, when necessary, either by the issue of amendment slips or revised editions. It is important that users of British Standards should ascertain that they are in possession of the latest amendments or edition.*

*Users wishing to be kept informed of any alteration to this standard should notify Publications Sales Department of the Institution, giving the number and title of the standard.*

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## CO-OPERATING ORGANIZATIONS

The Mechanical Industry Committee under whose supervision this British Standard was prepared consists of representatives from the following Government departments and scientific and industrial organizations:

- \* Admiralty
- \* Crown Agents for the Colonies
- \* Department of Scientific and Industrial Research
- \* High Commissioner for India
- \* Home Office
- \* Ministry of Transport
- \* Ministry of Works
- \* War Office
- \* Agricultural and Road Machinery Manufacturers' Association
- \* Association of Consulting Engineers
- \* British Chemical Plant Manufacturers' Association
- \* British Electrical and Allied Manufacturers' Association
- \* British Engineers' Association
- \* British Iron and Steel Federation
- \* British Marine Oil Engine Manufacturers' Association
- \* Engineering Insurance Companies
- \* Institute of Marine Engineers
- \* Institute of Petroleum
- \* Institution of Automobile Engineers
- \* Institution of Civil Engineers
- \* Institution of Gas Engineers
- \* Institution of Heating and Ventilating Engineers
- \* Institution of Mechanical Engineers
- \* Institution of Production Engineers
- \* Locomotive Manufacturers' Association
- \* Machine Tool Trades Association
- \* Railway Companies of Great Britain

The Government departments and scientific and industrial organizations marked with an asterisk in the above list, committee entrusted with the preparation of this British Standard:

- British Corporation Register of Shipping and Aircraft
- Gas List Tube and Fittings Association
- Institute of Naval Architects
- Institute of Plumbers
- Institute of Refrigeration
- Institution of Chemical Engineers
- Institution of Municipal and County Engineers
- Institution of Sanitary Engineers
- Institution of Water Engineers
- London County Council
- Lloyds Register of Shipping and Aircraft
- Metropolitan Water Board
- National Association of Coke and Bye-Product Plant Owners
- National Association of Heating, Ventilating and Domestic Engineering Employers
- Royal Sanitary Institute
- Society of Chemical Industries
- Wrought Fitting Makers' Association
- Manufacturers of Steel Tubes

BRITISH STANDARD SPECIFICATION FOR  
STEEL TUBES AND TUBULARS

SUITABLE FOR SCREWING TO B.S. 21, PIPE THREADS

## FOREWORD

The British Standard for steel tubes and tubulars was first issued in 1938 as B.S. 789.

This standard provided for three classes of tubes designated gas (light), water (medium) and steam (heavy) qualities.

In 1940, at the request of the Ministry of Supply and to meet the urgent need for the utmost economy in the consumption of steel, a war emergency edition of B.S. 789 was issued, designated B.S. 789A, providing for two qualities of tube known respectively as 'light weight' (one gauge lighter than gas weight in B.S. 789 : 1938) and 'heavy weight' (the same gauge as water weight in B.S. 789 : 1938).

The present standard has been prepared to meet the needs of post-war industry, and replaces B.S. 789 and B.S. 789A. It differs from B.S. 789 and B.S. 789A in certain respects, the principal ones being as follows:

It covers three thicknesses of tube, namely:

*Class 'A'* A new light-weight tube.  
*Class 'B'* A tube of the same thickness as the gas (light) tube of B.S. 789 : 1938.

*Class 'C'* A tube of the same thickness as the steam (heavy) tube of B.S. 789 : 1938.

In order to prevent confusion in nomenclature with tubes made to B.S. 789 and B.S. 789A, reference to 'light' or 'heavy' weight or quality, or to 'steam' quality tubes should be avoided, and the tubes should be described by the number of the present standard and by the class of tube.

Further to prevent confusion with tubes made to B.S. 789 and 789A, new identification colours have been adopted, which are set out in clause 14 of the standard.

The weights given in table 2 are based on the mean of the maximum and minimum outside diameters of the tubes. These weights differ slightly from those given in B.S. 789 since the weights in that specification were based on the approximate outside diameters.

The random lengths now specified differ from those given in B.S. 789 and 789A, due to improved manufacturing processes.

See Amend. No. 2.