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# SEAMLESS HOT-WORKED STEEL PIPES

RANGE OF SIZES

GOST 8732-78

(CMEA Standard 1481-781)

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**Official Edition**

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USSR STATE STANDARD

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## SEAMLESSHOT-WORKED STEEL PIPES

Range of Sizes

GOST

8732-78

(CMEA Standard

1481-78)

OKP (All-Union Product Classification Code) 13 1200, 13 1700, 13 1900

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Validity term from 01.01.79until 01.01.94

1. This Standard applies to hot-worked seamless steel pipes of general purpose, manufactured by outside diameter, wall thickness and length.

(Amended Wording, Amendment No. 1, 2)

2. The dimensions and mass of 1 m of pipes shall meet those given in tab. 1.

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Official Edition



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| Outside diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |      |      |      |      |      |      |      |      |       |       |       |       |       |       |
|----------------------|-------------------------------------------------|------|------|------|------|------|------|------|------|-------|-------|-------|-------|-------|-------|
|                      | 2.5                                             | 2.6* | 2.8  | 3    | 3.2* | 3.5  | 4    | 4.5  | 5    | 5.5   | 6     | (6.5) | 7     | (7.5) | 8     |
| 20*                  | 1.08                                            | 1.12 | 1.19 | 1.26 | 1.33 | 1.42 | 1.58 | -    | -    | -     | -     | -     | -     | -     | -     |
| 21.3*                | 1.16                                            | 1.20 | 1.22 | 1.35 | 1.43 | 1.54 | 1.71 | -    | -    | -     | -     | -     | -     | -     | -     |
| 22*                  | 1.20                                            | 1.24 | 1.33 | 1.41 | 1.48 | 1.60 | 1.78 | -    | -    | -     | -     | -     | -     | -     | -     |
| 25                   | 1.39                                            | 1.44 | 1.53 | 1.63 | 1.72 | 1.86 | 2.07 | 2.28 | 2.47 | 2.65  | 2.81  | 2.97  | 3.11  | 3.24  | 3.35  |
| 26.9*                | 1.50                                            | 1.56 | 1.66 | 1.77 | 1.87 | 2.02 | 2.25 | 2.49 | 2.70 | 2.90  | 3.09  | 3.27  | 3.43  | 3.59  | 3.83  |
| 28                   | 1.57                                            | 1.63 | 1.74 | 1.85 | 1.96 | 2.11 | 2.37 | 2.62 | 2.84 | 3.05  | 3.26  | 3.45  | 3.63  | 3.79  | 3.95  |
| 30*                  | 1.70                                            | 1.76 | 1.88 | 2.00 | 2.12 | 2.29 | 2.57 | 2.83 | 3.08 | 3.32  | 3.55  | 3.77  | 3.97  | 4.16  | 4.34  |
| 31.8*                | 1.81                                            | 1.86 | 2.00 | 2.13 | 2.26 | 2.44 | 2.74 | 3.03 | 3.30 | 3.57  | 3.82  | 4.05  | 4.28  | 4.49  | 4.69  |
| 32                   | 1.82                                            | 1.88 | 2.02 | 2.15 | 2.27 | 2.46 | 2.76 | 3.05 | 3.33 | 3.59  | 3.85  | 4.09  | 4.32  | 4.53  | 4.74  |
| 33.7*                | 1.92                                            | 1.99 | 2.13 | 2.27 | 2.41 | 2.61 | 2.93 | 3.24 | 3.54 | 3.82  | 4.10  | 4.36  | 4.61  | 4.84  | 5.07  |
| 35*                  | 2.00                                            | 2.08 | 2.22 | 2.37 | 2.51 | 2.72 | 3.06 | 3.39 | 3.70 | 4.00  | 4.29  | 4.57  | 4.83  | 5.09  | 5.33  |
| 38                   | 2.19                                            | 2.27 | 2.43 | 2.59 | 2.75 | 2.98 | 3.35 | 3.72 | 4.07 | 4.41  | 4.74  | 5.05  | 5.35  | 5.64  | 5.92  |
| 40*                  | 2.31                                            | 2.40 | 2.55 | 2.74 | 2.90 | 3.15 | 3.55 | 3.94 | 4.32 | 4.68  | 5.03  | 5.37  | 5.70  | 6.01  | 6.31  |
| 42                   | 2.44                                            | 2.53 | 2.71 | 2.89 | 3.06 | 3.32 | 3.75 | 4.16 | 4.56 | 4.95  | 5.33  | 5.69  | 6.01  | 6.38  | 6.71  |
| 42.4*                | 2.46                                            | 2.55 | 2.73 | 2.91 | 3.09 | 3.36 | 3.79 | 4.20 | 4.61 | 5.00  | 5.38  | 5.75  | 6.11  | 6.45  | 6.79  |
| 44.5*                | 2.59                                            | 2.69 | 2.88 | 3.07 | 3.26 | 3.54 | 4.00 | 4.44 | 4.87 | 5.29  | 5.70  | 6.09  | 6.47  | 6.84  | 7.20  |
| 45                   | 2.62                                            | 2.72 | 2.91 | 3.11 | 3.30 | 3.58 | 4.04 | 4.49 | 4.93 | 5.36  | 5.77  | 6.17  | 6.56  | 6.94  | 7.30  |
| 48.3*                | 2.82                                            | 2.93 | 3.14 | 3.35 | 3.58 | 3.87 | 4.37 | 4.86 | 5.34 | 5.80  | 6.26  | 6.70  | 7.13  | 7.54  | 7.95  |
| 50                   | 2.93                                            | 3.04 | 3.26 | 3.48 | 3.69 | 4.01 | 4.54 | 5.05 | 5.55 | 6.04  | 6.51  | 6.97  | 7.42  | 7.86  | 8.29  |
| 51*                  | -                                               | -    | -    | 3.55 | 3.77 | 4.10 | 4.64 | 5.16 | 5.67 | 6.17  | 6.65  | 7.13  | 7.60  | 8.04  | 8.48  |
| 54                   | -                                               | -    | -    | 3.77 | 4.01 | 4.36 | 4.93 | 5.49 | 6.04 | 6.58  | 7.10  | 7.61  | 8.11  | 8.60  | 9.08  |
| 57                   | -                                               | -    | -    | 4.00 | 4.25 | 4.62 | 5.23 | 5.83 | 6.41 | 6.99  | 7.55  | 8.10  | 8.63  | 9.16  | 9.67  |
| 60*                  | -                                               | -    | -    | 4.22 | 4.48 | 4.88 | 5.52 | 6.16 | 6.78 | 7.39  | 7.99  | 8.58  | 9.15  | 9.71  | 10.26 |
| 60.3*                | -                                               | -    | -    | 4.24 | 4.50 | 4.90 | 5.55 | 6.19 | 6.82 | 7.43  | 8.03  | 8.62  | 9.20  | 9.76  | 10.32 |
| 63.5                 | -                                               | -    | -    | 4.48 | 4.76 | 5.18 | 5.87 | 6.55 | 7.21 | 7.87  | 8.51  | 9.14  | 9.75  | 10.36 | 10.95 |
| 68                   | -                                               | -    | -    | 4.81 | 5.11 | 5.57 | 6.31 | 7.05 | 7.77 | 8.48  | 9.17  | 9.86  | 10.53 | 11.19 | 11.84 |
| 70                   | -                                               | -    | -    | 4.96 | 5.27 | 5.74 | 6.51 | 7.27 | 8.02 | 8.75  | 9.47  | 10.18 | 10.88 | 11.56 | 12.23 |
| 73                   | -                                               | -    | -    | 5.18 | 5.51 | 6.00 | 6.81 | 7.60 | 8.39 | 9.16  | 9.91  | 10.66 | 11.39 | 12.12 | 12.82 |
| 76                   | -                                               | -    | -    | 5.40 | 5.74 | 6.26 | 7.10 | 7.94 | 8.76 | 9.56  | 10.36 | 11.14 | 11.91 | 12.67 | 13.42 |
| 82.5*                | -                                               | -    | -    | -    | -    | 6.82 | 7.74 | 8.66 | 9.56 | 10.44 | 11.32 | 12.18 | 13.03 | 13.87 | 14.70 |

Table 1(cont.)

[illegible]

Table 1(cont.)

| Outside diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |      |     |   |      |     |   |     |   |     |   |
|----------------------|-------------------------------------------------|------|-----|---|------|-----|---|-----|---|-----|---|
|                      | 2.5                                             | 2.6* | 2.8 | 3 | 3.2* | 3.5 | 4 | 4.5 | 5 | 5.5 | 6 |
| 402                  | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| 406*                 | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| 426                  | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| 450                  | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| 457*                 | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| (465)                | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| 480                  | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| 500                  | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| 508*                 | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| 530                  | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |
| (550)                | -                                               | -    | -   | - | -    | -   | - | -   | - | -   | - |

Table 1(cont.)

| Outside diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |   |       |    |    |    |      |    |      |    |    |
|----------------------|-------------------------------------------------|---|-------|----|----|----|------|----|------|----|----|
|                      | (8.5)                                           | 9 | (9.5) | 10 | 11 | 12 | (13) | 14 | (15) | 16 | 17 |
| 20*                  | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 21.3*                | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 22*                  | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 25                   | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 26.9*                | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 28                   | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 30*                  | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 31.8*                | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 32                   | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |
| 33.7*                | -                                               | - | -     | -  | -  | -  | -    | -  | -    | -  | -  |

Table 1 (cont.)

| Outside diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |       |       |       |       |       |       |       |       |       |       |       |
|----------------------|-------------------------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
|                      | (8.5)                                           | 9     | (9.5) | 10    | 11    | 12    | (13)  | 14    | (15)  | 16    | 17    | 18    |
| 35*                  | -                                               | -     | -     | -     | -     | -     | -     | -     | -     | -     | -     | -     |
| 38                   | -                                               | -     | -     | -     | -     | -     | -     | -     | -     | -     | -     | -     |
| 40*                  | -                                               | -     | -     | -     | -     | -     | -     | -     | -     | -     | -     | -     |
| 42                   | 7.02                                            | 7.32  | 7.61  | 7.89  | -     | -     | -     | -     | -     | -     | -     | -     |
| 42.4*                | 7.10                                            | 7.41  | 7.71  | 7.99  | -     | -     | -     | -     | -     | -     | -     | -     |
| 44.5*                | 7.54                                            | 7.88  | 8.20  | 8.51  | -     | -     | -     | -     | -     | -     | -     | -     |
| 45                   | 7.65                                            | 7.99  | 8.32  | 8.63  | -     | -     | -     | -     | -     | -     | -     | -     |
| 48.3*                | 8.34                                            | 8.72  | 9.09  | 9.44  | -     | -     | -     | -     | -     | -     | -     | -     |
| 50                   | 8.70                                            | 9.11  | 9.49  | 9.87  | -     | -     | -     | -     | -     | -     | -     | -     |
| 51*                  | 8.91                                            | 9.32  | 9.72  | 10.11 | -     | -     | -     | -     | -     | -     | -     | -     |
| 54                   | 9.54                                            | 9.99  | 10.43 | 10.85 | 11.67 | -     | -     | -     | -     | -     | -     | -     |
| 57                   | 10.17                                           | 10.65 | 11.13 | 11.59 | 12.48 | 13.32 | 14.11 | -     | -     | -     | -     | -     |
| 60                   | 10.80                                           | 11.32 | 11.83 | 12.33 | 13.29 | 14.21 | 15.07 | 15.88 | -     | -     | -     | -     |
| 60.3*                | 10.86                                           | 11.38 | 11.90 | 12.40 | 13.37 | 14.29 | 15.16 | 15.98 | -     | -     | -     | -     |
| 63.5                 | 11.53                                           | 12.10 | 12.65 | 13.19 | 14.24 | 15.24 | 16.19 | 17.09 | -     | -     | -     | -     |
| 68                   | 12.47                                           | 13.10 | 13.71 | 14.30 | 15.46 | 16.57 | 17.63 | 18.64 | 19.61 | 20.52 | -     | -     |
| 70                   | 12.89                                           | 13.54 | 14.17 | 14.80 | 16.01 | 17.16 | 18.27 | 19.33 | 20.35 | 21.31 | -     | -     |
| 73                   | 13.52                                           | 14.21 | 14.88 | 15.54 | 16.82 | 18.05 | 19.24 | 20.37 | 21.46 | 22.49 | 23.48 | 24.42 |
| 76                   | 14.15                                           | 14.87 | 15.58 | 16.28 | 17.63 | 18.94 | 20.20 | 21.41 | 22.57 | 23.68 | 24.74 | 25.75 |
| 82.5*                | 15.51                                           | 16.31 | 17.10 | 17.88 | 19.40 | 20.86 | 22.28 | 23.65 | 24.97 | 26.24 | 27.46 | 28.63 |
| 83                   | 15.62                                           | 16.43 | 17.22 | 18.00 | 19.53 | 21.01 | 22.44 | 23.82 | 25.16 | 26.11 | 27.67 | 28.85 |
| 89                   | 16.88                                           | 17.76 | 18.63 | 19.48 | 21.16 | 22.70 | 24.37 | 25.90 | 27.37 | 28.81 | 30.19 | 31.52 |
| 95                   | 18.13                                           | 19.09 | 20.03 | 20.96 | 22.79 | 24.56 | 26.29 | 27.97 | 29.59 | 31.17 | 32.70 | 34.18 |
| 102                  | 19.60                                           | 20.64 | 21.67 | 22.69 | 24.69 | 26.63 | 28.53 | 30.38 | 32.18 | 33.93 | 35.64 | 37.29 |
| 104*                 | 20.02                                           | 21.09 | 22.14 | 23.18 | 25.23 | 27.23 | 29.17 | 31.07 | 32.92 | 34.72 | 36.47 | 38.18 |
| 108                  | 20.86                                           | 21.97 | 23.08 | 24.17 | 26.31 | 28.41 | 30.46 | 32.46 | 34.40 | 36.30 | 38.15 | 39.95 |
| 114                  | 22.12                                           | 23.31 | 24.48 | 25.65 | 27.94 | 30.19 | 32.38 | 34.53 | 36.62 | 38.67 | 40.67 | 42.62 |
| 121                  | 23.58                                           | 24.86 | 26.12 | 27.37 | 29.84 | 32.26 | 34.62 | 36.94 | 39.21 | 41.63 | 43.60 | 45.72 |
| 127                  | 24.84                                           | 26.19 | 27.53 | 28.85 | 31.47 | 34.03 | 36.55 | 39.01 | 41.43 | 43.80 | 46.12 | 48.39 |
| 133                  | 26.10                                           | 27.52 | 28.93 | 30.33 | 33.10 | 35.81 | 38.47 | 41.09 | 43.65 | 46.17 | 48.63 | 51.05 |

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Table 1 (cont.)

| Outside diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |        |        |        |        |        |        |        |        |        |        |        |
|----------------------|-------------------------------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
|                      | (8.5)                                           | 9      | (9.5)  | 10     | 11     | 12     | (13)   | 14     | (15)   | 16     | 17     | 18     |
| 140                  | 27.57                                           | 29.08  | 30.57  | 32.06  | 35.00  | 37.88  | 40.72  | 43.50  | 46.24  | 48.93  | 51.57  | 54.13  |
| 146                  | 28.82                                           | 30.41  | 31.98  | 33.54  | 36.62  | 39.66  | 42.64  | 45.57  | 48.46  | 51.30  | 54.08  | 56.82  |
| 152                  | 30.08                                           | 31.74  | 33.39  | 35.02  | 38.25  | 41.43  | 44.56  | 47.65  | 50.68  | 53.66  | 56.60  | 59.48  |
| 159                  | 31.55                                           | 33.29  | 35.03  | 36.75  | 40.15  | 43.50  | 46.81  | 50.06  | 53.27  | 56.43  | 59.53  | 62.59  |
| 165*                 | 32.80                                           | 34.62  | 36.43  | 38.22  | 41.78  | 45.29  | 48.73  | 52.19  | 55.49  | 58.79  | 62.04  | 65.25  |
| 168                  | 33.44                                           | 35.29  | 37.13  | 38.97  | 42.59  | 46.17  | 49.69  | 53.17  | 56.60  | 59.98  | 63.31  | 66.59  |
| 178*                 | 35.53                                           | 37.51  | 39.47  | 41.43  | 45.30  | 49.13  | 52.90  | 56.62  | 60.30  | 63.92  | 67.49  | 71.02  |
| 180                  | 35.95                                           | 37.95  | 39.95  | 41.93  | 45.85  | 49.72  | 53.54  | 57.31  | 61.04  | 64.71  | 68.34  | 71.91  |
| 194                  | 38.89                                           | 41.06  | 43.23  | 45.38  | 49.64  | 53.86  | 58.03  | 62.15  | 66.22  | 70.24  | 74.21  | 78.13  |
| 203                  | 40.77                                           | 43.06  | 45.33  | 47.60  | 52.09  | 56.52  | 60.91  | 65.25  | 69.55  | 73.79  | 77.98  | 82.12  |
| 219                  | 44.13                                           | 46.61  | 49.08  | 51.54  | 56.43  | 61.26  | 66.04  | 70.78  | 75.46  | 80.10  | 84.69  | 89.23  |
| 245                  | 49.58                                           | 52.38  | 55.17  | 57.95  | 63.48  | 68.95  | 74.38  | 79.76  | 85.08  | 90.36  | 95.59  | 100.77 |
| 273                  | 55.45                                           | 58.60  | 61.73  | 64.86  | 71.07  | 77.24  | 83.36  | 89.42  | 95.44  | 101.41 | 107.33 | 113.20 |
| 299                  | 60.90                                           | 64.37  | 67.83  | 71.27  | 78.13  | 84.93  | 91.69  | 98.40  | 105.06 | 111.67 | 118.23 | 124.74 |
| 324*                 | 66.13                                           | 69.91  | 73.68  | 77.44  | 84.91  | 92.33  | 99.71  | 107.03 | 114.31 | 121.53 | 128.70 | 135.83 |
| 325                  | 66.35                                           | 70.14  | 73.92  | 77.68  | 85.18  | 92.63  | 100.03 | 107.38 | 114.68 | 121.93 | 129.13 | 136.28 |
| 351                  | 71.80                                           | 75.91  | 80.01  | 84.10  | 92.23  | 100.32 | 108.36 | 116.35 | 124.29 | 132.19 | 140.03 | 147.82 |
| 356*                 | -                                               | 77.02  | 81.17  | 85.33  | 93.59  | 101.80 | 109.97 | 118.08 | 126.14 | 134.16 | 142.11 | 150.04 |
| 377                  | -                                               | 81.68  | 86.10  | 90.51  | 99.29  | 108.02 | 116.70 | 125.33 | 133.91 | 142.45 | 150.93 | 159.36 |
| 402                  | -                                               | 87.23  | 91.96  | 96.67  | 106.07 | 115.42 | 124.71 | 133.96 | 143.16 | 152.31 | 161.41 | 170.46 |
| 406*                 | -                                               | 88.11  | 92.89  | 97.66  | 107.15 | 116.60 | 126.00 | 135.34 | 144.64 | 153.89 | 163.08 | 172.24 |
| 426                  | -                                               | 92.56  | 97.58  | 102.59 | 112.58 | 122.52 | 132.41 | 142.25 | 152.04 | 161.78 | 171.47 | 181.11 |
| 450                  | -                                               | 97.88  | 103.20 | 108.51 | 119.09 | 129.62 | 140.10 | 150.53 | 160.92 | 171.25 | 181.53 | 191.77 |
| 457*                 | -                                               | 99.43  | 104.83 | 110.24 | 120.99 | 131.69 | 142.35 | 152.94 | 163.51 | 174.00 | 184.46 | 194.86 |
| (465)                | -                                               | 101.21 | 106.72 | 112.72 | 123.16 | 134.06 | 144.91 | 155.71 | 166.46 | -      | -      | -      |
| 480                  | -                                               | 104.54 | 110.23 | 115.91 | 127.23 | 138.50 | 149.72 | 160.89 | 172.01 | -      | -      | -      |
| 500                  | -                                               | 108.98 | 114.92 | 120.84 | 132.65 | 144.42 | 156.13 | 167.80 | 179.41 | -      | -      | -      |
| 508*                 | -                                               | 110.75 | 116.78 | 122.81 | 134.82 | 146.77 | 158.69 | 170.55 | 182.36 | 194.12 | 205.84 | 217.50 |
| 530                  | -                                               | 115.64 | 121.95 | 128.24 | 140.79 | 153.30 | 165.75 | 178.16 | 190.51 | -      | -      | -      |
| (550)                | -                                               | 120.08 | 126.63 | 133.17 | 146.22 | 159.22 | 172.16 | 185.06 | 197.91 | -      | -      | -      |

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*Table 1 (cont.)*

| Outside diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |    |    |      |    |      |    |    |    |      |      |    |
|----------------------|-------------------------------------------------|----|----|------|----|------|----|----|----|------|------|----|
|                      | (19)                                            | 20 | 22 | (24) | 25 | (26) | 28 | 30 | 32 | (34) | (36) | 36 |
| 20*                  | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 21.3*                | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 22*                  | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 25                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 26.9*                | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 28                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 30*                  | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 31.8*                | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 32                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 33.7*                | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 35*                  | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 38                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 40*                  | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 42                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 42.4*                | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 44.5*                | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 45                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 48.3*                | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 50                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 51*                  | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 54                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 57                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 60                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 60.3*                | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 63.5                 | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 68                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 70                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 73                   | -                                               | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 76                   | 25.30                                           | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 82.5*                | 26.71                                           | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
| 83                   | 29.75                                           | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |
|                      | 29.99                                           | -  | -  | -    | -  | -    | -  | -  | -  | -    | -    | -  |

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Table 1 (cont.)

| Outside diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |        |        |        |        |        |        |        |        |        |        |        |
|----------------------|-------------------------------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
|                      | (19)                                            | 20     | 22     | (24)   | 25     | (26)   | 28     | 30     | 32     | (34)   | (35)   | 36     |
| 89                   | 32.80                                           | 34.03  | 36.35  | 38.47  | -      | -      | -      | -      | -      | -      | -      | -      |
| 95                   | 35.61                                           | 36.99  | 39.61  | 42.02  | -      | -      | -      | -      | -      | -      | -      | -      |
| 102                  | 38.89                                           | 40.45  | 43.40  | 46.17  | -      | -      | -      | -      | -      | -      | -      | -      |
| 104*                 | 39.82                                           | 41.43  | 44.49  | 47.35  | -      | -      | -      | -      | -      | -      | -      | -      |
| 108                  | 41.70                                           | 43.40  | 46.66  | 49.72  | 51.17  | 52.58  | 55.24  | -      | -      | -      | -      | -      |
| 114                  | 44.51                                           | 46.36  | 49.92  | 53.27  | 54.87  | 56.43  | 59.39  | -      | -      | -      | -      | -      |
| 121                  | 47.79                                           | 49.82  | 53.71  | 57.41  | 59.19  | 60.91  | 64.22  | -      | -      | -      | -      | -      |
| 127                  | 50.61                                           | 52.78  | 56.97  | 60.96  | 62.89  | 64.76  | 68.36  | 71.77  | -      | -      | -      | -      |
| 133                  | 53.42                                           | 55.74  | 60.22  | 64.51  | 66.58  | 68.61  | 72.51  | 76.20  | 79.71  | -      | -      | -      |
| 140                  | 56.70                                           | 59.19  | 64.02  | 68.66  | 70.90  | 73.10  | 77.34  | 81.38  | 85.23  | 88.88  | 90.63  | 92.33  |
| 146                  | 59.51                                           | 62.15  | 67.28  | 72.21  | 74.60  | 76.94  | 81.48  | 85.82  | 89.97  | 93.91  | 95.81  | 97.66  |
| 152                  | 62.32                                           | 65.11  | 71.53  | 75.76  | 78.30  | 80.79  | 85.63  | 90.26  | 94.70  | 98.94  | 100.99 | 102.99 |
| 159                  | 65.60                                           | 68.56  | 74.33  | 79.90  | 82.62  | 85.28  | 90.46  | 95.44  | 100.22 | 104.81 | 107.03 | 109.20 |
| 165*                 | 68.41                                           | 71.52  | 77.58  | 83.45  | 86.31  | 89.12  | 94.60  | 99.88  | 104.95 | 109.83 | 112.20 | 114.52 |
| 168                  | 69.82                                           | 73.00  | 79.21  | 85.23  | 88.16  | 91.05  | 96.67  | 102.10 | 107.33 | 112.36 | 114.80 | 117.19 |
| 178*                 | 74.50                                           | 77.93  | 84.64  | 91.14  | 94.33  | 97.46  | 103.58 | 109.50 | 115.21 | 120.73 | 123.42 | 126.06 |
| 180                  | 75.44                                           | 78.92  | 85.72  | 92.33  | 95.56  | 98.75  | 104.96 | 110.98 | 116.80 | 122.42 | 125.16 | 127.85 |
| 194                  | 82.00                                           | 85.82  | 93.32  | 100.62 | 104.20 | 107.72 | 114.63 | 121.34 | 127.85 | 134.16 | 137.24 | 140.28 |
| 203                  | 86.22                                           | 90.26  | 98.20  | 105.95 | 109.74 | 113.49 | 120.84 | 127.99 | 134.95 | 141.71 | 145.01 | 148.27 |
| 219                  | 93.71                                           | 98.15  | 106.88 | 115.42 | 119.61 | 123.75 | 131.89 | 139.83 | 147.57 | 155.12 | 158.82 | 162.47 |
| 245                  | 105.90                                          | 110.98 | 120.99 | 130.80 | 135.64 | 140.42 | 149.84 | 159.07 | 168.09 | 176.92 | 181.26 | 185.55 |
| 273                  | 119.02                                          | 124.79 | 136.18 | 147.38 | 152.90 | 158.38 | 169.18 | 179.78 | 190.19 | 200.40 | 205.43 | 210.41 |
| 299                  | 131.20                                          | 137.61 | 150.29 | 162.77 | 168.93 | 175.05 | 187.13 | 199.02 | 210.71 | 222.20 | 227.87 | 233.50 |
| 324*                 | 142.90                                          | 149.94 | 163.85 | 177.55 | 184.34 | 191.06 | 204.39 | 217.51 | 230.42 | 243.15 | 249.44 | 255.67 |
| 325                  | 143.38                                          | 150.44 | 164.39 | 178.16 | 184.96 | 191.72 | 205.09 | 218.25 | 231.23 | 244.00 | 250.31 | 256.58 |
| 351                  | 155.57                                          | 163.26 | 178.50 | 193.54 | 200.99 | 208.39 | 223.04 | 237.49 | 251.74 | 265.80 | 272.76 | 279.66 |
| 356*                 | 157.90                                          | 165.72 | 181.21 | 196.49 | 204.07 | 211.58 | 226.49 | 241.19 | 255.67 | 269.98 | 277.05 | 284.08 |
| 377                  | 167.75                                          | 176.08 | 192.61 | 208.93 | 217.02 | 225.06 | 240.99 | 256.73 | 272.26 | 287.60 | 295.20 | 302.74 |
| 402                  | 179.46                                          | 188.41 | 206.17 | 223.73 | 232.43 | 241.09 | 258.26 | 275.22 | 291.99 | 308.56 | 316.78 | 324.94 |
| 406*                 | 181.32                                          | 190.39 | 208.34 | 226.08 | 234.90 | 243.64 | 261.02 | 278.18 | 295.13 | 311.90 | 320.21 | 328.47 |

Table 1(cont.)

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Table 1 (cont.)

| Outside<br>diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |    |      |    |      |    |    |    |    |      |    |    |
|-------------------------|-------------------------------------------------|----|------|----|------|----|----|----|----|------|----|----|
|                         | (38)                                            | 40 | (42) | 45 | (48) | 50 | 56 | 60 | 63 | (65) | 70 | 75 |
| 40*                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 42                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 42.4*                   | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 44.5*                   | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 45                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 48.3*                   | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 50                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 51*                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 54                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 57                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 60                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 60.3*                   | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 63.5                    | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 68                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 70                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 73                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 76                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 82.5*                   | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 83                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 89                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 95                      | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 102                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 104*                    | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 108                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 114                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 121                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 127                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 133                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 140                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 146                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |
| 152                     | -                                               | -  | -    | -  | -    | -  | -  | -  | -  | -    | -  | -  |

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Table 1 (cont.)

| Outside diameter, mm | Mass of 1 m of pipes, kg, at wall thickness, mm |        |        |        |        |        |        |        |        |        |        |        |
|----------------------|-------------------------------------------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
|                      | (38)                                            | 40     | (42)   | 45     | (48)   | 50     | 56     | 60     | 63     | (65)   | 70     | 75     |
| 159                  | -                                               | -      | -      | -      | -      | -      | -      | -      | -      | -      | -      | -      |
| 165*                 | -                                               | -      | -      | -      | -      | -      | -      | -      | -      | -      | -      | -      |
| 168                  | 121.83                                          | 126.27 | 130.51 | 136.50 | -      | -      | -      | -      | -      | -      | -      | -      |
| 178*                 | 131.19                                          | 136.12 | 140.86 | 147.59 | -      | -      | -      | -      | -      | -      | -      | -      |
| 180                  | 133.07                                          | 138.10 | 142.94 | 149.82 | -      | -      | -      | -      | -      | -      | -      | -      |
| 194                  | 146.19                                          | 151.92 | 157.44 | 165.36 | -      | -      | -      | -      | -      | -      | -      | -      |
| 203                  | 154.63                                          | 160.79 | 166.76 | 175.34 | 183.48 | 188.66 | -      | -      | -      | -      | -      | -      |
| 219                  | 169.62                                          | 176.58 | 183.33 | 193.10 | 202.42 | 208.39 | -      | -      | -      | -      | -      | -      |
| 245                  | 193.99                                          | 202.22 | 210.26 | 221.95 | 233.20 | 240.45 | -      | -      | -      | -      | -      | -      |
| 273                  | 220.23                                          | 229.85 | 239.27 | 253.03 | 266.34 | 274.98 | -      | -      | -      | -      | -      | -      |
| 299                  | 244.59                                          | 255.49 | 266.20 | 281.88 | 297.12 | 307.04 | 335.59 | 353.65 | 366.67 | 375.10 | 395.32 | 414.31 |
| 324*                 | 268.00                                          | 280.14 | 292.07 | 309.61 | 326.69 | 337.84 | 370.10 | 390.61 | 405.48 | 415.15 | 438.45 | 460.52 |
| 325                  | 268.96                                          | 281.14 | 293.13 | 310.74 | 327.90 | 339.10 | 371.50 | 392.12 | 407.06 | 416.78 | 440.21 | 462.40 |
| 351                  | 293.32                                          | 306.79 | 320.06 | 338.59 | 358.68 | 371.16 | 407.41 | 430.59 | 447.46 | 458.46 | 485.09 | 510.49 |
| 356*                 | 297.99                                          | 311.70 | 325.22 | 345.12 | 364.57 | 377.30 | 414.29 | 437.96 | 455.20 | 466.44 | 493.69 | 519.71 |
| 377                  | 317.69                                          | 332.44 | 346.99 | 368.44 | 389.45 | 403.22 | 442.32 | 469.06 | 487.85 | 500.14 | 529.98 | 558.58 |
| 402                  | 341.12                                          | 357.10 | 372.88 | 396.19 | 419.05 | 434.04 | 477.84 | 506.05 | 526.70 | 540.21 | 573.13 | 604.82 |
| 406*                 | 344.84                                          | 361.02 | 377.00 | 400.60 | 423.76 | 438.95 | 483.34 | 511.94 | 532.88 | 546.59 | 580.00 | 612.18 |
| 426                  | 363.61                                          | 380.77 | 397.74 | 422.82 | 447.46 | 463.64 | 510.99 | 541.57 | 563.96 | 578.68 | 614.56 | 649.21 |
| 450                  | 386.10                                          | 404.45 | 422.60 | 449.46 | 475.87 | 493.23 | 544.13 | 577.08 | 601.27 | 617.15 | 656.00 | 693.60 |
| 457*                 | 392.64                                          | 411.33 | 429.82 | 457.20 | 484.12 | 501.83 | 553.76 | 587.40 | 612.11 | 628.34 | 668.04 | 706.51 |
| (465)                | 400.16                                          | 419.25 | 438.14 | 466.10 | 493.62 | 511.73 | 564.85 | 599.27 | 624.58 | 641.20 | 681.89 | 721.35 |
| 480                  | 414.21                                          | 436.04 | 453.67 | 482.75 | 511.38 | 530.22 | 585.56 | 621.47 | 647.88 | 665.25 | 707.78 | 749.09 |
| 500                  | 432.96                                          | 453.77 | 474.39 | 504.95 | 535.06 | 554.88 | 613.18 | 651.06 | 678.96 | 697.30 | 742.31 | 786.09 |
| 508*                 | 440.43                                          | 461.63 | 482.64 | 513.79 | 544.49 | 577.66 | 624.19 | 662.86 | 691.34 | 710.08 | 756.07 | 800.83 |
| 530                  | 461.07                                          | 483.37 | 505.46 | 538.28 | 570.57 | 591.88 | 654.61 | 695.45 | 725.57 | 745.39 | 794.10 | 841.57 |
| (550)                | 479.81                                          | 503.09 | 526.18 | 560.43 | 594.24 | 616.54 | 682.24 | 725.05 | 756.64 | 777.45 | 828.63 | 878.57 |

## Notes:

Dimensions of pipes in brackets shall not be used when designing new equipment.

Mass of 1 m of pipes shall be calculated using formula  $M=0.02466 S(D_o-S)$ ,

Where  $D_o$  is the outside diameter of a pipe, mm;

$S$  is the wall thickness, mm.

The density of steel shall be taken equal to  $7.850 \text{ g/sm}^3$ .

3. Pipes, whose mass is limited by a broken heavy line, shall be produced upon agreement of the manufacturer with the customer.

4. Pipes with outside diameters and thickness of walls marked with an asterisk should be used in the contractual-legal relations on economic and scientific-technical cooperation.

**(Amended Wording, Amendment No. 2)**

3. By length the pipes shall be produced as:

unsized length - within the limits from 4 to 12.5 m;

sized length - within the limits of unsized length;

length multiple the sized one - within the limits of unsized length with an allowance of 5 mm per each cut;

approximate length within the limits of unsized length.

## Notes:

1. By the agreement of the manufacturer with the customer it is allowed to produce the pipes of length beyond the limits specified for pipes of unsized length.

2. For pipes with a wall thickness exceeding 16 mm the length of sized pipes shall be established by the agreement of the manufacturer with the customer.

3. Pipes of approximate length shall be produced at the customer's request.

**(Amended Wording, Amendment No. 1)**

4. The maximum deviations in length of pipes of sized length and of length multiple the sized one shall not exceed the following values: +10 mm - for length up to 6 m; +15 mm - for length more than 6 m or for outside diameter more than 152 mm;  $\pm 500$  mm - for approximate length.

**(Amended Wording, Amendment No. 1)**

5. The maximum deviations in outside diameter and wall thickness of pipes shall not exceed values specified in table 2 and 3.

Table 2

| Outside diameter, mm | Maximum deviations for pipes of accuracy of manufacture |              |
|----------------------|---------------------------------------------------------|--------------|
|                      | Increased                                               | standard     |
| Up to 50 incl.       | $\pm 0.5$ mm                                            | $\pm 0.5$ mm |
| Over 50 to 219 "     | $\pm 0.8$ %                                             | $\pm 1.0$ %  |
| Over 219             | $\pm 1.0$ %                                             | $\pm 1.25$ % |

Table 3

| Outside diameter, mm | Wall thickness, mm | Maximum deviations in wall thickness of pipes of accuracy of manufacture, % |                |
|----------------------|--------------------|-----------------------------------------------------------------------------|----------------|
|                      |                    | increased                                                                   | standard       |
| Up to 219            | Up to 15 incl.     | $\pm 12.5$                                                                  | +12.5<br>-15.0 |
|                      | Over 15 to 30      | +10.0<br>-12.5                                                              | $\pm 12.5$     |
|                      | 30 and more        | $\pm 10.0$                                                                  | +10.0<br>-12.5 |

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*Table 3(cont.)*

| Outside diameter,<br>mm | Wall thickness, mm | Maximum deviations in wall thickness of<br>pipes of accuracy of manufacture, % |          |
|-------------------------|--------------------|--------------------------------------------------------------------------------|----------|
|                         |                    | increased                                                                      | standard |
| Over 219                | Up to 15 incl.     | +12.5                                                                          | -15.0    |
|                         | Over 15 to 30      | ±12.5                                                                          | +10.0    |
|                         | 30 and more        | +10.0                                                                          | -12.5    |
|                         |                    | -12.5                                                                          |          |

6. By the agreement of the manufacturer with the customer pipes may be produced with combined maximum deviations, for example: in outside diameter of the increased accuracy in accordance with GOST 9567-75, and in wall thickness of standard accuracy and so on.

7. The ovality and wall thickness difference of pipes shall not extend the size of pipes beyond the maximum deviations in diameter and wall thickness.

8. The curvature of any section of a pipe on 1 m of length shall not exceed 1.5 mm - for pipes with wall thickness up to 20 mm; 2.0 mm - for pipes with wall thickness from 20 to 30 mm; 4.0 mm - for pipes with wall thickness more than 30 mm.

9. At the customer's request the pipes shall delivered by inside diameter and wall thickness, and also by outside and inside diameters and wall thickness difference.

The maximum deviations in inside diameter for pipes with a diameter of 70-203 mm, a wall thickness of 7-20 mm and ratio of diameter to wall thickness equal to or less than 10, shall not exceed the appropriate maximum deviations in outside diameter specified in table 2.

For the other dimensions of pipes the maximum deviations in inside diameter shall be established by the agreement of the manufacturer with the customer.

Example identification numbers

Pipe with an outside diameter of 70 mm, a wall thickness of 3.5 mm, a length multiple 1250 mm, standard accuracy of manufacture, from steel of grade 10, produced according to group B GOST 8731-74

$$Tpy6a = \frac{70 \times 3.5 \times 1250 \text{ } \kappa p. \text{ } \Gamma OCT \text{ } 8732 - 78}{B \text{ } 10 \text{ } \Gamma OCT \text{ } 8731 - 74}$$

Pipe with an outside diameter of 70 mm, a wall thickness of 3,5 mm, length 6000 mm (sized length), increased accuracy of manufacture, from steel of grade 40X, produced according to group B GOST 8731-74

$$Tpy6a = \frac{70 \times 3.5 \times 6000 \text{ } \Pi \text{ } \Gamma OCT \text{ } 8732 - 78}{B40X \text{ } \Gamma OCT \text{ } 8731 - 74}$$

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The same, unsized length, produced according to group Д GOST 8731-74

$$Tpy6a = \frac{70 \times 3.5 \Pi \text{ГОСТ } 8732 - 78}{Д \text{ГОСТ } 8731 - 74}$$

Pipe with an outside diameter of 219 mm, a wall thickness of 10 mm, unsized length of standard accuracy of manufacture, from steel of grade Ст4сп, category of steel **1**, produced according to group Б GOST 8731-74 of an ingot

$$Tpy6a = \frac{219 \times 10 \text{ГОСТ } 8732 - 78}{Б Ст4сп \text{ГОСТ } 8731 - 74} 4$$

Pipe with an inside diameter of 70 mm, a wall thickness of 3.5 mm, length 6 000 mm (sized length) with standard accuracy of manufacture, from steel of grade 10, produced according to group Б GOST 8731-74

$$Tpy6a = \frac{6H.70 \times 3.5 \times 6000 \text{ГОСТ } 8732 - 78}{Б 10 \text{ГОСТ } 8731 - 74}$$

Pipe with an outside diameter of 95 mm, an inside diameter of 76 mm, permitted wall thickness difference of unsized length, standard accuracy of manufacture, from steel of grade 10, produced according to group Б GOST 8731-74

$$Tpy6a = \frac{95 \times 6H. \times 76 \text{ГОСТ } 8732 - 78}{Б 10 \text{ГОСТ } 8731 - 74}$$

**(Amended Wording, Amendment No. 2)**

10. The technical requirements shall comply with GOST 8731-87,

## DETAILS

### 1. DEVELOPED AND INTRODUCED by the Ministry of Ferrous Metallurgy USSR

#### DEVELOPERS

A. A. Shevchenko, Dr. Sci. (Tech.); V. P. Sokurenko, Cand. Sci. (Tech.); V. N. Rovenskii

### 2. APPROVED AND INTRODUCED by Decree No. 757, dated 22.03.78, of the State Committee for Standards of the USSR Council of Ministers

### 3. IN PLACE OF GOST 8732-70

### 4. This Standard fully complies with CMEA Standard 1481-78

| Name of reference document, referred to | Clause |
|-----------------------------------------|--------|
| GOST 8731-87                            | 10     |
| GOST 9567-75                            | 6      |

### 6. REVISED EDITION (October, 1990) with Amendments No. 1, 2, approved in February, 1982, September, 1988 (IUS 5-82, 1-89)

### 7. Term extended by Decree No. 3367 dated 29.09.88 of Gosstandart USSR until 01.01.94

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