

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ADDENDUM 1
TO
ISO
RECOMMENDATION
R 64-1958

STEEL TUBES – OUTSIDE DIAMETERS

OUTSIDE DIAMETERS LARGER THAN 419 mm (16.5 in)

1st EDITION

October 1969

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BRIEF HISTORY

Addendum 1, *Outside diameters larger than 419 mm (16.5 in)*, to ISO Recommendation R 64-1958, *Steel tubes – Outside diameters*, was drawn up by Technical Committee ISO/TC 5, *Pipes and fittings*, the Secretariat of which is held by l'Association Suisse de Normalisation (SNV).

In 1966, the ISO/TC 5 Secretariat suggested to Sub-Committee 1 the extension of ISO Recommendation R 64-1958 by the addition of outside diameters larger than 419 mm (16.5 in) and, in order to fill the gap between 419 mm and 1220 mm, the inclusion of the missing dimensions by taking those from ISO Recommendation R 336-1963.

Work on this question led to the adoption of a Draft ISO Recommendation.

In January 1968, this Draft ISO Recommendation (No. 1493) was submitted to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	India	South Africa, Rep. of
Belgium	Israel	Spain
Brazil	Italy	Sweden
Canada	Korea, Rep. of	Switzerland
Chile	Netherlands	Thailand
Colombia	New Zealand	Turkey
Denmark	Norway	U.A.R.
France	Poland	U.S.S.R.
Germany	Portugal	

Three Member Bodies opposed the approval of the Draft :

Czechoslovakia
Hungary
United Kingdom

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in October 1969, to accept it as ADDENDUM 1 to ISO Recommendation R 64-1958.

STEEL TUBES — OUTSIDE DIAMETERS

OUTSIDE DIAMETERS LARGER THAN 419 mm (16.5 in)

The dimensions in millimetres and in inches, given in the Table below, are considered to be "corresponding values", although some of them are not exactly equivalent. In all cases, however, these dimensions ensure practical interchangeability.

TABLE — Outside diameters, corresponding values

millimetres	inches
457.2	18
508	20
558.8	22
609.6	24
660.4	26
711.2	28
762	30
812.8	32
863.6	34
914.4	36
1016	40
1220	48
1420	55.9
1620	63.8
1820	71.7
2020	79.5
2220	87.4



ISO

Transformed

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

**ISO RECOMMENDATION
R 64**

**STEEL TUBES
OUTSIDE DIAMETERS**

1st EDITION

April 1958

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BRIEF HISTORY

The ISO Recommendation R 64, *Steel Tubes - Outside Diameters*, was drawn up by Technical Committee ISO/TC 5, *Pipes and Fittings*, the Secretariat of which is held by the Association Suisse de Normalisation (SNV).

At its first meeting, held in Zurich, in May 1951, the Technical Committee decided to take as basis for the standardization of outside diameters of steel tubes the work done by the former International Federation of the National Standardizing Associations (ISA), as well as existing standards, taking into consideration both the present state of steel tube manufacture and developments to be foreseen in the future. The study of the proposal was assigned to Sub-Committee ISO/TC 5/SC 1, *Gas List Tubes and other Steel Pipes*.

Sub-Committee 1 met in Zurich, in October 1951 and in May 1952, and set up a list of diameters based on tubes, which may be screwed, up to the outside diameter of 5 1/2 in (139.7 mm), as specified in ISO Recommendation R 7, and above this dimension, as specified in the American Standards ASA B2.1-1945, API 5A and API 5L.

The Sub-Committee continued its studies in Zurich, in November 1953, in Dusseldorf, in June 1954, in Paris, in November 1954, and, as a working group, in London, in February 1955, and prepared a first draft proposal. After several revisions, a new document was adopted by the Sub-Committee at its meeting in Rigi-Kaltbad, in July 1956, and by the Technical Committee, as a Draft ISO Recommendation.

On 10 April 1957, the Draft ISO Recommendation was sent out to all ISO Member Bodies and was approved by the following 23 Member Bodies (out of a total of 38):

*Australia	Finland	*Ireland	Spain
Austria	France	Israel	Sweden
Belgium	Germany	Italy	Switzerland
*Canada	*Greece	Netherlands	Union of
Czechoslovakia	Hungary	New Zealand	South Africa
Denmark	India	*Portugal	United Kingdom

One Committee Member, Norway, opposed the approval of the Draft.

Technical Committee ISO/TC 8, *Shipbuilding Details for Sea Navigation*, submitted comments which were considered in the final formulation of the Draft.

In April 1958, the ISO Council decided, by correspondence, to accept the Draft ISO Recommendation as an ISO RECOMMENDATION.

* These Member Bodies stated that they had no objection to the Draft being approved.

STEEL TUBES

OUTSIDE DIAMETERS

The dimensions in inches and in millimetres, given in the tables, are considered to be "corresponding values", although some of them are not exact equivalents. In all cases, however, the dimensions assure practicable interchangeability.

Outside diameters			
Corresponding values		Corresponding values	
Millimetres	Inches	Millimetres	Inches
10.2	$13/32$	82.5	$3 \frac{1}{4}$
12	$15/32$	88.9	$3 \frac{1}{2}$
13.5	$17/32$	101.6	4
16	$5/8$	108	$4 \frac{1}{4}$
17.2	$11/16^*$	114.3	$4 \frac{1}{2}$
19	$3/4$	127	5
20	$25/32$	133	$5 \frac{1}{4}$
21.3	$27/32$	139.7	$5 \frac{1}{2}$
25	—	141.3	$5 \frac{9}{16}$
25.4	1	152.4	6
26.9	$1 \frac{1}{16}$	159	$6 \frac{1}{4}$
30	$1 \frac{3}{16}$	165.1	$6 \frac{1}{2}$
31.8	$1 \frac{1}{4}$	168.3	$6 \frac{5}{8}$
33.7	$1 \frac{11}{32}^{**}$	177.8	7
38	$1 \frac{1}{2}$	193.7	$7 \frac{5}{8}$
42.4	$1 \frac{11}{16}^{***}$	219.1	$8 \frac{5}{8}$
44.5	$1 \frac{3}{4}$	244.5	$9 \frac{5}{8}$
48.3	$1 \frac{29}{32}$	267	$10 \frac{1}{2}$
51	2	273	$10 \frac{3}{4}$
54	$2 \frac{1}{8}$	298.5	$11 \frac{3}{4}$
57	$2 \frac{1}{4}$	323.9	$12 \frac{3}{4}$
60.3	$2 \frac{3}{8}$	355.6	14
63.5	$2 \frac{1}{2}$	368	$14 \frac{1}{2}$
70	$2 \frac{3}{4}$	406.4	16
73	$2 \frac{7}{8}$	419	$16 \frac{1}{2}$
76.1	3		

* Tolerance to be based on 0.677 in.

** Tolerance to be based on 1.327 in.

*** Tolerance to be based on 1.669 in.