

ANNEXURE A
PRODUCT MANUAL FOR
Steel Tubes for Structural Purposes
According to IS 1161:2014

GROUPING GUIDELINES

Group	Nominal Bore (mm)	Grouping
1	From 15 to upto 80 ✓	Samples covering combination of the minimum and maximum Nominal Bore and minimum and maximum wall thickness of tubes shall be drawn to cover all sizes within the group.
2	From 80 to upto 175	-do-
3	From 175 to upto 500	-do-
4	From 500 to upto 750	-do-
5	From 750 to upto and including 1200	-do-

Separate samples from each group for each process of manufacture (HFW, HFS, CDS, ERW, HFIW) are required to be drawn.

If the above samples drawn within each group are of grade having higher YS, grades having lower YS can also be covered within that group.

It shall, however, be ensured that the applicant/licensee has got complete manufacturing as well as testing facilities for the sizes/classes/grades/types of tubes required to be covered in the licence.

During the operation of the licence, samples of all varieties covered shall be drawn in rotation.