

## Specification weldtron

For biotech and the pharma industry  
and for sensitive sectors of cosmetics and food  
industries

**weldtron**

**bf** bright finished  
**ep** electropolished



### 1. SURFACE QUALITIES

Tubes and fittings: Inner surface (bright finished)

● <b>weldtron   H3o</b>	<b>Ra<sub>avg.</sub> ≤ 0,80 µm / 32 µin</b>
Surface treatment:	<ul style="list-style-type: none"> <li>- Bright finished (bf) / H3o according to DIN 11866 / 11865 / 11864 / DIN 32676</li> <li>- Ra value for circumferential weld seam of fittings not defined</li> <li>- T-pieces according to DIN 11865, option "u".</li> <li>- Circular weld seams ground with specified Ra value on request</li> <li>- Cleaning and testing methods ASTM A 632, S3</li> </ul>

Tubes and fittings: Inner surface (electropolished)

● <b>weldtron   HE3o</b>	<b>Ra<sub>avg.</sub> ≤ 0.60 µm / 24 µin</b>
Surface treatment:	<ul style="list-style-type: none"> <li>- Electropolished (ep) / HE3o according to DIN 11866 / 11865 / 11864 / DIN 32676</li> <li>- Ra value for circumferential weld seam of formed parts not defined</li> <li>- T-pieces according to DIN 11865, option "u".</li> <li>- Circular weld seams ground with specified Ra value on request.</li> <li>- Cleaning and testing procedures according to Spec. doc. 8.4-40/3.2/3.3.2</li> <li>- Oil and grease-free in accordance with CGA G-4.1-2018 and ASTM G93 – level B</li> </ul>

### 2. MATERIALS

Austenitic stainless steel tubes and fittings in:

● <b>weldtron</b>	1.4435 / UNS S31603 (316L) acc. to Basler Norm 2 (BN2) 1.4404 / UNS S31603 (316L)
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Hardness equivalent to:	<ul style="list-style-type: none"> <li>- max. 180 HV* according to DIN EN ISO 6507-1</li> <li>- max. 90 HRB* according to DIN EN ISO 6508-1</li> </ul> <p>* comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)</p>
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### 3. DIMENSIONS

Imperial:	acc. to ASTM A269 / A270 / A632, ASME BPE and DIN 11866 Serie C	
OD x WT	1/4" to 6" (0.250 x 0.035 inch to 6.000 x 0.109 inch)	6,35 x 0,89 mm to 152,40 x 2,77 mm
ISO:	acc. to DIN EN ISO 1127 and DIN 11866 Serie B	
OD x WT	13,50 x 1,60 mm to 219,10 x 2,60 mm	
Metric:	acc. to DIN 11866 Series A	
OD x WT	6,00 x 1,00 mm to 154,00 x 2,00 mm	

Manufacturing process: Welded or seamless tubes

### 4. QUALITY AND TEST PROCEDURES

Verification of basic test certificate	Visual inspection	Endoscopic inspection of bright finished tubes
Verification of dimensions	Roughness measurements	Delta ferrite measurement 1.4435 BN2 / 316L

### 5. TECHNICAL TERMS OF DELIVERY

Tubes and fittings are prepared for orbital welding:

#### Tubes

Acc. to 11866, ASTM A 269 / A 270, DIN EN 10217-7 / 10216-5 with a length of 5900 - 6090 mm (max. 10% short lengths of min. 3000 mm possible).

For electropolished tubes with outer diameter ≤ 5.00 mm, the length is 2950 ± 50 mm.

#### Fittings

Acc. to DIN 11865, DIN 32676, DIN 11864

#### Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat number / Standards and Hygiene Class

Tubes, pipes and fittings shall be permanently marked as per Dockweiler guideline AA 7.5.3–80. The marking must provide all necessary information to trace back the heat number and the material grade.

### 6. DOCUMENTATION, PACKAGING AND SHIPPING

#### Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204. Optional online documentation WebCert.

#### Packaging

Bright finished tubes and fittings are sealed with transparent PE caps and individually packaged in PE foil. The batch label on the foil packaging contains the information weldtron.

Electropolished tubes and fittings are sealed with PA/PE squares and yellow PE caps, sleeved and sealed in PE. The batch label on the foil packaging contains the information weldtron ep.

#### Shipping

Delivery in tubular container or wooden crate, fittings in strong cardboard box with shock absorbing filler.